

Celanex® 2402 MT

Polybutylene Terephthalate

Celanese Corporation

Message:

Celanex 2402 MT Natural is an unreinforced PBT with improved flow that complies with the requirements of CFR 21 177.1660 of the Food and Drug Administration (FDA) and is listed in the Drug Master File (DMF) 10047 (US) / 10033 (EU) and the Device Master File (MAF) 443 (US) / 1078 (EU).. 2402 MT also complies with the corresponding EU and national registry regulatory requirements. 2402 MT has displayed excellent biocompatibility in tests corresponding to USP 23 class VI. Celanex 2402 MT contains no animal derived materials.

General Information			
Features	Good liquidity		
	Biocompatibility		
	No kinetic components		
Agency Ratings	DMF 10033		
	DMF 10047		
	FDA 21 CFR 177.1660		
	MAF 1078		
	MAF 443		
	USP XXIII, Class VI		
RoHS Compliance	Contact manufacturer		
Physical	Nominal Value	Unit	Test Method
Density	1.31	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (250°C/2.16 kg)	40.0	cm ³ /10min	ISO 1133
Molding Shrinkage - Flow	1.8 - 2.0	%	ISO 294-4
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2700	MPa	ISO 527-2/1A/1
Tensile Stress (Yield)	60.0	MPa	ISO 527-2/1A/50
Tensile Strain (Yield)	4.0	%	ISO 527-2/1A/50
Nominal Tensile Strain at Break	15	%	ISO 527-2/1A/50
Flexural Modulus (23°C)	2550	MPa	ISO 178
Flexural Stress (23°C)	80.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-30°C	4.5	kJ/m ²	ISO 179/1eA
23°C	5.0	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength			ISO 179/1eU
-30°C	130	kJ/m ²	ISO 179/1eU
23°C	140	kJ/m ²	ISO 179/1eU

Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, not annealed	160	°C	ISO 75-2/B
1.8 MPa, not annealed	60.0	°C	ISO 75-2/A
Glass Transition Temperature ¹	60.0	°C	ISO 11357-2
Vicat Softening Temperature	190	°C	ISO 306/B50
Melting Temperature ²	225	°C	ISO 11357-3
CLTE - Flow	1.1E-4	cm/cm/°C	ISO 11359-2
Flammability	Nominal Value		Test Method
Flame Rating (0.800 mm)	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	120 - 130	°C	
Drying Time	4.0	hr	
Suggested Max Moisture	0.020	%	
Suggested Max Regrind	25	%	
Hopper Temperature	20.0 - 50.0	°C	
Rear Temperature	230 - 240	°C	
Middle Temperature	235 - 250	°C	
Front Temperature	235 - 250	°C	
Nozzle Temperature	250 - 260	°C	
Processing (Melt) Temp	235 - 260	°C	
Mold Temperature	65.0 - 93.0	°C	
Injection Rate	Moderate-Fast		
Back Pressure	0.00 - 0.345	MPa	
Injection instructions			
Manifold Temperature: 250 to 260°CZone 4 Temperature: 240 to 260°CFeed Temperature: 230 to 240°C			
NOTE			
1.	10°C/min		
2.	10°C/min		

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