

Celanex® 4306UV

Polybutylene Terephthalate

Celanese Corporation

Message:

Celanex 4306UV is a 30% glass reinforced, toughened, low warpage, UV stable thermoplastic polyester.

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 30% filler by weight		
Features	Low warpage		
	Good UV resistance		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.50	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR)	10	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.40 - 0.60	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	9200	MPa	ISO 527-2/1A/1
Tensile Strength			
Fracture, 23°C	121	MPa	ASTM D638
Fracture	100	MPa	ISO 527-2/1A/5
Tensile Elongation			
Fracture, 23°C	3.0	%	ASTM D638
Fracture	1.9	%	ISO 527-2/1A/5
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	7.0	kJ/m ²	ISO 179/1eA
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, not annealed	223	°C	ASTM D648
1.8 MPa, not annealed	209	°C	ASTM D648
1.8 MPa, not annealed	121	°C	ISO 75-2/A
Melting Temperature ¹	225	°C	ISO 11357-3, ASTM D3418
Electrical	Nominal Value	Unit	Test Method
Dielectric Strength ²	19	kV/mm	ASTM D149
Injection	Nominal Value	Unit	
Drying Temperature	120 - 130	°C	
Drying Time	4.0	hr	
Suggested Max Moisture	0.020	%	
Hopper Temperature	20 - 50	°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 - 96	°C
Injection Rate	Moderate-Fast	

Injection instructions

Manifold Temperature: 250 to 260°CZone 4 Temperature: 240 to 260°CFeed Temperature: 230 to 240°C

NOTE

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| 1. | 10°C/min |
| 2. | Method A (short time) |

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