

Vandar® 2500

Polybutylene Terephthalate

Celanese Corporation

Message:

Vandar 2500 is an unfilled polyester alloy which exhibits excellent toughness and impact strength. It is specially designed to offer excellent chemical resistance, good colorability and dimensional stability.

General Information			
UL YellowCard	E45575-239370		
Features	Good dimensional stability		
	Impact resistance, high		
	Good coloring		
	Good chemical resistance		
	Good toughness		
RoHS Compliance		Contact manufacturer	
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.25	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR)	12	g/10 min	ASTM D1238
Molding Shrinkage			
Flow	1.7 - 2.2	%	ASTM D955
Vertical flow direction	1.7 - 2.2	%	ISO 294-4
Flow direction	1.7 - 2.2	%	ISO 294-4
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (M-Scale)	104		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	1450	MPa	ISO 527-2/1A/1
Tensile Strength			
Yield, 23°C	33.8	MPa	ASTM D638
Yield	35.0	MPa	ISO 527-2/1A/50
Tensile Strain			
Yield	5.0	%	ISO 527-2/1A/50
Fracture, 23°C	100	%	ASTM D638
Nominal Tensile Strain at Break	> 50	%	ISO 527-2/1A/50
Flexural Modulus (23°C)	1500	MPa	ISO 178
Flexural Stress (23°C)	50.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-30°C	9.0	kJ/m ²	ISO 179/1eA
23°C	88	kJ/m ²	ISO 179/1eA

Charpy Unnotched Impact Strength			ISO 179/1eU
-30°C	170	kJ/m ²	ISO 179/1eU
23°C	200	kJ/m ²	ISO 179/1eU
Notched Izod Impact (23°C)	No Break		ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, not annealed	125	°C	ISO 75-2/B
0.45 MPa, annealed	127	°C	ASTM D648
1.8 MPa, not annealed	51.7	°C	ASTM D648
1.8 MPa, not annealed	50.0	°C	ISO 75-2/A
Glass Transition Temperature ¹	70.0	°C	ISO 11357-2
Melting Temperature ²	225	°C	ISO 11357-3, ASTM D3418
Linear thermal expansion coefficient			ISO 11359-2
Flow	1.3E-4	cm/cm/°C	ISO 11359-2
Lateral	1.3E-4	cm/cm/°C	ISO 11359-2
Flammability	Nominal Value		Test Method
Flame Rating	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	240 - 260	°C	
Processing (Melt) Temp	235 - 260	°C	
Mold Temperature	65.0 - 96.0	°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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