

Celanex® 4302LM

Polybutylene Terephthalate

Celanese Corporation

Message:

Celanex 4302 is a 30% glass reinforced PBT designed for improved mold flow, warp resistance and surface appearance, that is also enhanced for improved laser marking graphics.

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 30% filler by weight		
Additive	Impact modifier		
Features	Impact modification		
	Laser marking		
	Bending resistance		
	Excellent appearance		
RoHS Compliance	Contact manufacturer		
Physical	Nominal Value	Unit	Test Method
Density	1.49	g/cm ³	ISO 1183
Molding Shrinkage - Flow	0.30 - 0.50	%	ISO 294-4
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Break)	120	MPa	ISO 527-2/1A/5
Tensile Strain (Break)	2.8	%	ISO 527-2/1A/5
Flexural Modulus (23°C)	8700	MPa	ISO 178
Flexural Stress (23°C)	190	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	14	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	173	°C	ISO 75-2/A
Melting Temperature ¹	225	°C	ISO 11357-3
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	

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Recommended distributors for this material

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