

Celanex® 2404 MT

Polybutylene Terephthalate

Celanese Corporation

Message:

Celanex 2404 MT Natural is an unreinforced PTFE filled PBT with improved friction, sliding, and wear properties 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).. 2404 MT also complies with the corresponding EU and national registry regulatory requirements. 2404 MT has displayed excellent biocompatibility in tests corresponding to USP 23 class VI. Celanex 2404 MT contains no animal derived materials.

General Information			
Additive	PTFE lubricant		
Features	Low friction coefficient		
	Good wear resistance		
	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		
Appearance	Natural color		
Physical	Nominal Value	Unit	Test Method
Density	1.34	g/cm³	ISO 1183
Melt Volume-Flow Rate (MVR) (250°C/2.16 kg)	21.0	cm³/10min	ISO 1133
Molding Shrinkage - Flow	1.8 - 2.0	%	ISO 294-4
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2600	MPa	ISO 527-2/1A/1
Tensile Stress (Yield)	56.0	MPa	ISO 527-2/1A/50
Tensile Strain (Yield)	7.0	%	ISO 527-2/1A/50
Nominal Tensile Strain at Break	19	%	ISO 527-2/1A/50
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	3.3	kJ/m²	ISO 179/1eA
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	55.0	°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
Electrical	Nominal Value	Unit	Test Method
Comparative Tracking Index	600	V	IEC 60112
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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