

Celanex® 4022

Polybutylene Terephthalate

Celanese Corporation

Message:

A white PBT resin typically used for applications requiring very opaque parts.

General Information			
RoHS Compliance	Contact manufacturer		
Appearance	White		
Physical	Nominal Value	Unit	Test Method
Density	1.46	g/cm ³	ISO 1183
Molding Shrinkage - Flow	1.8 - 2.0	%	ISO 294-4
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (M-Scale)	155		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	3200	MPa	ISO 527-2/1A/1
Tensile Stress (Break)	58.0	MPa	ISO 527-2/1A/5
Tensile Strain (Break)	8.0	%	ISO 527-2/1A/5
Flexural Stress (23°C)	86.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	3.5	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	33	kJ/m ²	ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	63.0	°C	ISO 75-2/A
Electrical	Nominal Value	Unit	Test Method
Comparative Tracking Index	400	V	IEC 60112
Flammability	Nominal Value	Unit	Test Method
Flame Rating	HB		UL 94
Injection	Nominal Value	Unit	
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	Fast		
Back Pressure	0.00 - 0.345	MPa	

Injection instructions

Manifold Temperature: 250 to 260°C Zone 4 Temperature: 240 to 260°C Feed Temperature: 230 to 240°C

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