

Celanex® 4300LM

Polybutylene Terephthalate

Celanese Corporation

Message:

Celanex 4300LM is a toughened 30% glass reinforced PBT that is enhanced for improved laser marking graphics. It is a lasermarkable grade available in a black color to mark white. The grade is specially formulated to yield crisp marks when subjected to a Nd:YAG laser or equivalent operated at 1064nm or 532nm. Lasers operating in the UV region (355nm) may yield different results.

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 30% filler by weight		
Features	Laser marking		
	Impact resistance, good		
RoHS Compliance	Contact manufacturer		
Appearance	Black		
Physical	Nominal Value	Unit	Test Method
Density	1.53	g/cm ³	ISO 1183
Molding Shrinkage - Flow	0.30 - 0.50	%	ISO 294-4
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	9300	MPa	ISO 527-2/1A/1
Tensile Stress (Break)	130	MPa	ISO 527-2/1A/5
Tensile Strain (Break)	3.1	%	ISO 527-2/1A/5
Flexural Modulus (23°C)	9000	MPa	ISO 178
Flexural Stress (23°C)	205	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-30°C	8.5	kJ/m ²	ISO 179/1eA
23°C	11	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	40	kJ/m ²	ISO 179/1eU
Notched Izod Impact (23°C)	12	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	200	°C	ISO 75-2/A
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

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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

