

Vandar® 6000

Polybutylene Terephthalate

Celanese Corporation

Message:

Vandar 6000 is a toughened polyester alloy with excellent cold temperature impact resistance.

General Information			
Features	Low temperature impact resistance		
RoHS Compliance	Contact manufacturer		
Multi-Point Data	Isothermal Stress vs. Strain (ISO 11403-1)		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.20	g/cm ³	ASTM D792, ISO 1183
Molding Shrinkage			
Flow	0.50 - 0.90	%	ASTM D955
Vertical flow direction	0.50 - 0.90	%	ISO 294-4
Flow direction	0.50 - 0.90	%	ISO 294-4
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	1750	MPa	ISO 527-2/1A/1
Tensile Strength			
Yield, 23°C	44.1	MPa	ASTM D638
Yield	45.0	MPa	ISO 527-2/1A/50
Fracture, 23°C	44.1	MPa	ASTM D638
50% strain	35.0	MPa	ISO 527-2/1A/50
Tensile Strain			
Yield	4.5	%	ISO 527-2/1A/50
Fracture, 23°C	190	%	ASTM D638
Nominal Tensile Strain at Break	> 50	%	ISO 527-2/1A/50
Flexural Modulus (23°C)	1600	MPa	ISO 178
Flexural Stress (23°C)	55.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, Partial Break)	56	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, not annealed	106	°C	ISO 75-2/B
0.45 MPa, annealed	110	°C	ASTM D648
1.8 MPa, not annealed	70.0	°C	ASTM D648
1.8 MPa, not annealed	74.0	°C	ISO 75-2/A
Glass Transition Temperature ¹	78.0	°C	ISO 11357-2
CLTE - Flow	9.0E-5	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	240 - 255	°C
Middle Temperature	250 - 260	°C
Front Temperature	250 - 260	°C
Nozzle Temperature	260 - 270	°C
Processing (Melt) Temp	260 - 280	°C
Mold Temperature	65.0 - 96.0	°C
Injection Rate	Moderate-Fast	
Back Pressure	0.00 - 0.689	MPa
Injection instructions		
Manifold Temperature: 260 to 280°CZone 4 Temperature: 255 to 265°CFeed Temperature: 240 to 255°C		
NOTE		
1.	10°C/min	

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