Celanese
The chemistry inside innovation™

CELANEX® 2004-2

unreinforced grade with good balance of flowability & toughness
Celanex 2004-2 is an unfilled polyester that has an excellent combination of flowability and toughness. A typical application for Celanex 2004-2 is electrical connectors containing latches. Celanex 2004-2 contains an internal lubricant.

Product information

Part Marking Code	> PBT-I <	ISO 11469

Rheological properties

Melt volume-flow rate	33	cm^3/10min	ISO 1133
Temperature	250	°C	
Load	2.16	kg	
Moulding shrinkage range, parallel	1.7 - 2.1	%	ISO 294-4, 2577
Moulding shrinkage range, normal	1.6 - 1.9	%	ISO 294-4, 2577

Typical mechanical properties

Tensile Modulus	2400	MPa	ISO 527-1/-2
Yield stress, 50mm/min	54	MPa	ISO 527-1/-2
Yield strain, 50mm/min	8	%	ISO 527-1/-2
Nominal strain at break	37	%	ISO 527-1/-2
Flexural Modulus	2300	MPa	ISO 178
Flexural Strength	69	MPa	ISO 178
Charpy impact strength, 23°C	218[P]	kJ/m^2	ISO 179/1eU
Charpy impact strength, -30°C	45	kJ/m^2	ISO 179/1eU
Charpy notched impact strength, 23°C	4.5	kJ/m^2	ISO 179/1eA
Charpy notched impact strength, -30°C	4.5	kJ/m^2	ISO 179/1eA
Izod notched impact strength, 23°C	4.6	kJ/m^2	ISO 180/1A
Izod notched impact strength, -30°C	4.6	kJ/m^2	ISO 180/1A
Izod impact strength, 23°C	NB	kJ/m^2	ISO 180/1U
Shore D hardness, 15s	81		ISO 48-4 / ISO 868

[P]: Partial Break

Thermal properties

Melting temperature, 10°C/min	225	°C	ISO 11357-1/-3
Glass transition temperature, 10°C/min	60	°C	ISO 11357-1/-3
Temp. of deflection under load, 1.8 MPa	54	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	166	°C	ISO 75-1/-2
Vicat softening temperature, 50°C/h, 50N	175	°C	ISO 306
Coeff. of linear therm. expansion, parallel	110	E-6/K	ISO 11359-1/-2

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Flammability

Burning Behav. at thickness h	HB	class	UL 94
Thickness tested	1.00	mm	UL 94

Electrical properties

Relative permittivity, 100Hz	3.7		IEC 62631-2-1
Relative permittivity, 1MHz	3.5		IEC 62631-2-1
Dissipation factor, 100Hz	30	E-4	IEC 62631-2-1
Dissipation factor, 1MHz	210	E-4	IEC 62631-2-1
Volume resistivity	>1E13	Ohm.m	IEC 62631-3-1
Surface resistivity	>1E15	Ohm	IEC 62631-3-2

Other properties

Water absorption, 2mm	0.45	%	Sim. to ISO 62
Density	1300	kg/m³	ISO 1183

Injection

Drying Temperature	120 - 130	°C	
Drying Time, Dehumidified Dryer	4	h	
Processing Moisture Content	0.02	%	
Melt Temperature Optimum	250	°C	Internal
Max. mould temperature	65 - 93	°C	
Injection speed	medium-fast		

Additional information

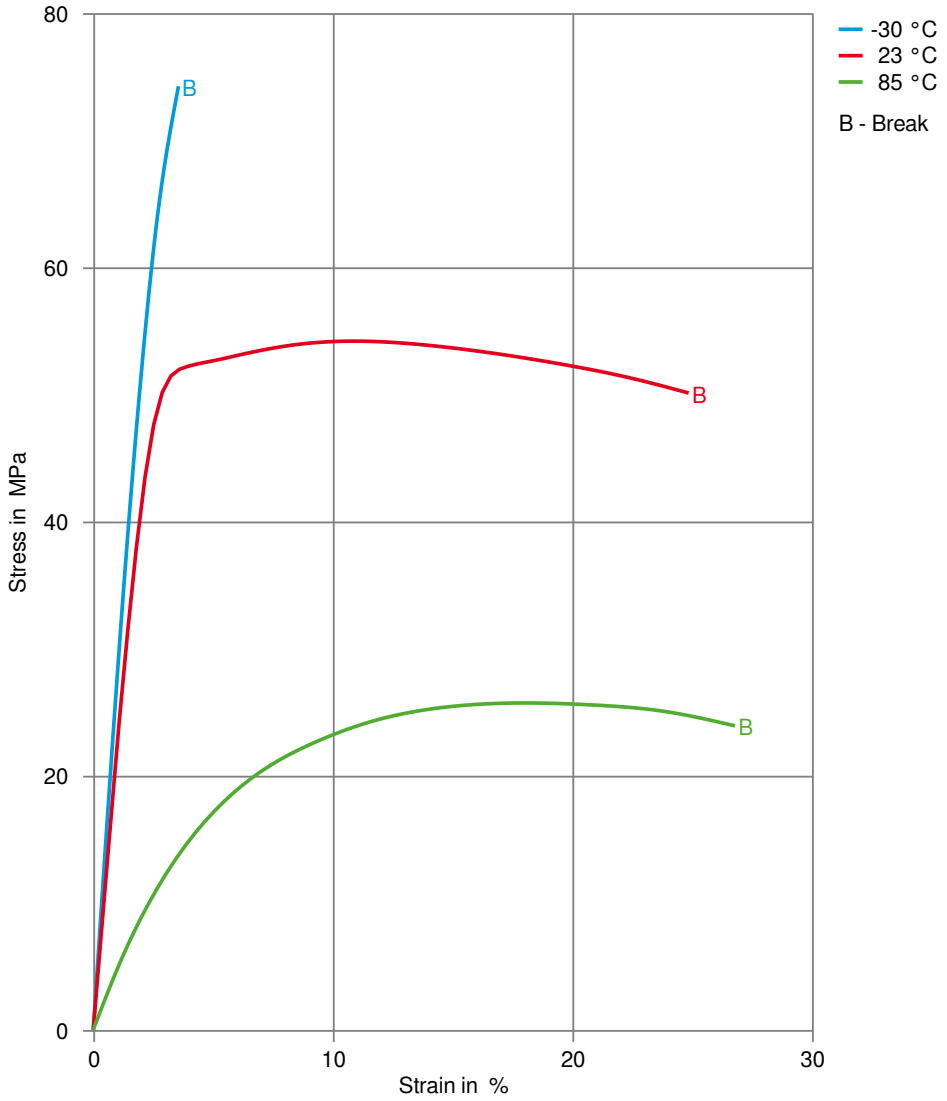
Injection molding

Rear Temperature 450-470(230-240) deg F (deg C)
Center Temperature 460-480(235-250) deg F (deg C)
Front Temperature 470-500(240-260) deg F (deg C)
Nozzle Temperature 480-500(250-260) deg F (deg C)
Melt Temperature 460-500(235-260) deg F (deg C)
Mold Temperature 150-200(65-93) deg F (deg C)
Back Pressure 0-50 psi
Screw Speed Medium
Injection Speed Fast

Injection speed, injection pressure and holding pressure have to be optimized to the individual article geometry. To avoid material degradation during processing low back pressure and minimum screw speed have to be used. Overheating of the material has to be avoided, in particular for flame retardant grades. Up to 25% clean and dry regrind may be used.

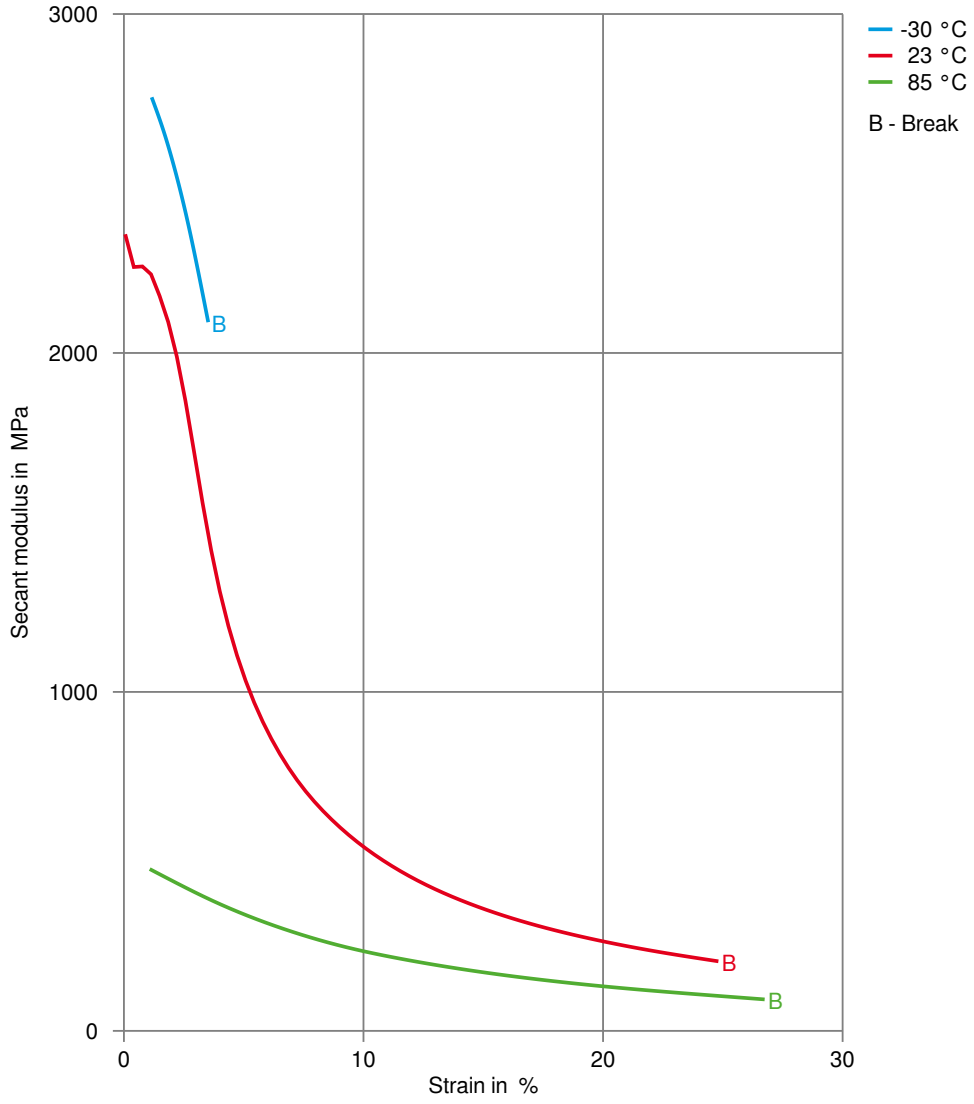
CELANEX® 2004-2

Stress-strain



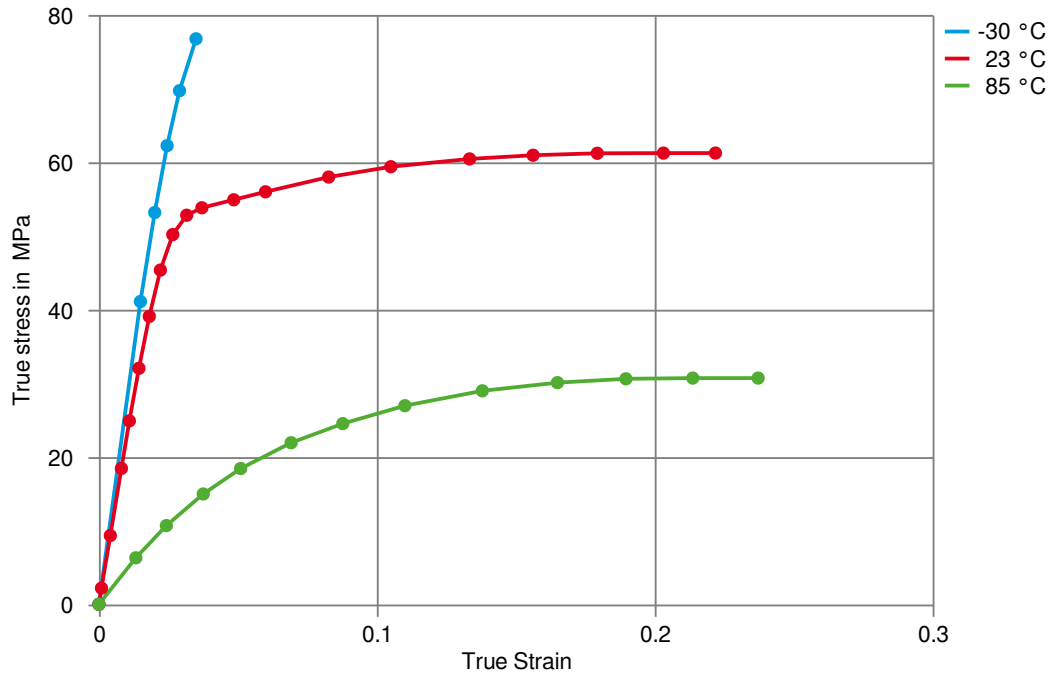
CELANEX® 2004-2

Secant modulus-strain



CELANEX® 2004-2

True stress-strain



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Processing Texts

Pre-drying	To avoid hydrolytic degradation during processing, CELANEX resins have to be dried to a moisture level equal to or less than 0.02%. Drying should be done in a dehumidifying hopper dryer capable of dewpoints <-40°F (-40°C) at 250°F (121°C) for 4 hours.
Longer pre-drying times/storage	For subsequent storage of the material in the dryer until processed (<= 60 h) it is necessary to lower the temperature to 100° C.
Injection molding	Rear Temperature 450-470(230-240) deg F (deg C) Center Temperature 460-480(235-250) deg F (deg C) Front Temperature 470-500(240-260) deg F (deg C) Nozzle Temperature 480-500(250-260) deg F (deg C) Melt Temperature 460-500(235-260) deg F (deg C) Mold Temperature 150-200(65-93) deg F (deg C) Back Pressure 0-50 psi Screw Speed Medium Injection Speed Fast Injection speed, injection pressure and holding pressure have to be optimized to the individual article geometry. To avoid material degradation during processing low back pressure and minimum screw speed have to be used. Overheating of the material has to be avoided, in particular for flame retardant grades. Up to 25% clean and dry regrind may be used.
Injection molding Preprocessing	To avoid hydrolytic degradation during processing, CELANEX resins have to be dried to a moisture level equal to or less than 0.02%. Drying should be done in a dehumidifying hopper dryer capable of dewpoints <-30°F (-34°C) at 250°F (121°C) for 4 hours.

Other Approvals

Other Approvals

OEM	Specification	Additional Information
Renault		No spec listed