Celanese
The chemistry inside innovation™

CELANEX® 4307

30% glass-fiber reinforced; hydrolysis resistant; impact modified PBT grade; for use in nano molding technology (NMT)
Celanex® 4307 is a 30% glass fiber reinforced PBT resin. It offers excellent physical properties and good adhesion to metal with surface treatment.

Product information

Part Marking Code	PBT-I-GF30		ISO 11469

Rheological properties

Melt mass-flow rate	10	g/10min	ISO 1133
Melt mass-flow rate, Temperature	250	°C	
Melt mass-flow rate, Load	5	kg	
Moulding shrinkage range, parallel	0.2 - 0.4	%	ISO 294-4, 2577
Moulding shrinkage range, normal	0.9 - 1.2	%	ISO 294-4, 2577

Typical mechanical properties

Tensile Modulus	8800	MPa	ISO 527-1/-2
Stress at break, 5mm/min	120	MPa	ISO 527-1/-2
Strain at break, 5mm/min	3.5	%	ISO 527-1/-2
Flexural Modulus	8200	MPa	ISO 178
Flexural Strength	188	MPa	ISO 178
Charpy impact strength, 23°C	70	kJ/m²	ISO 179/1eU
Charpy notched impact strength, 23°C	17	kJ/m²	ISO 179/1eA

Thermal properties

Temp. of deflection under load, 1.8 MPa	190	°C	ISO 75-1/-2
Coeff. of linear therm. expansion, parallel	20	E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal	180	E-6/K	ISO 11359-1/-2

Other properties

Density	1470	kg/m³	ISO 1183

Injection

Drying Temperature	120	°C
Drying Time, Dehumidified Dryer	4 - 6	h
Max. mould temperature	120 - 150	°C
Hold pressure range	50 - 100	MPa
Injection speed	medium	

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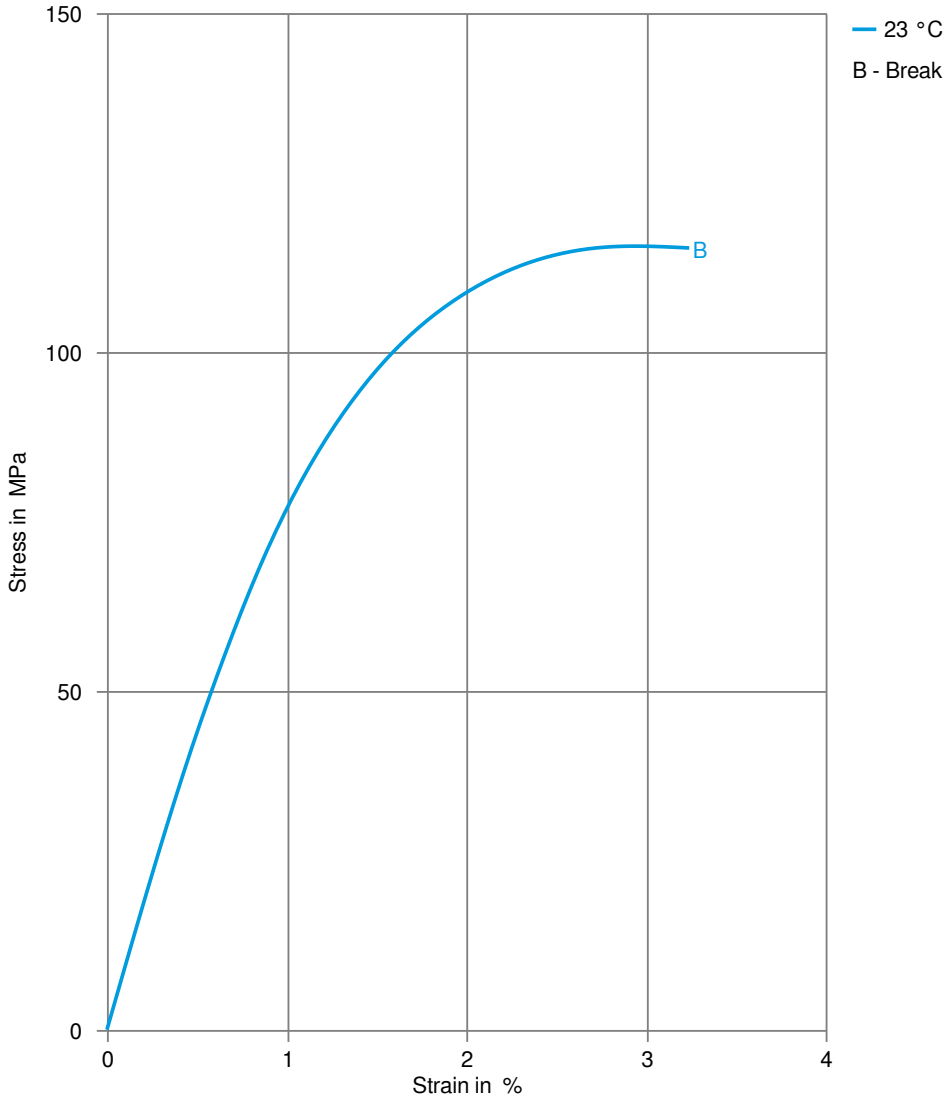
Stress-strain



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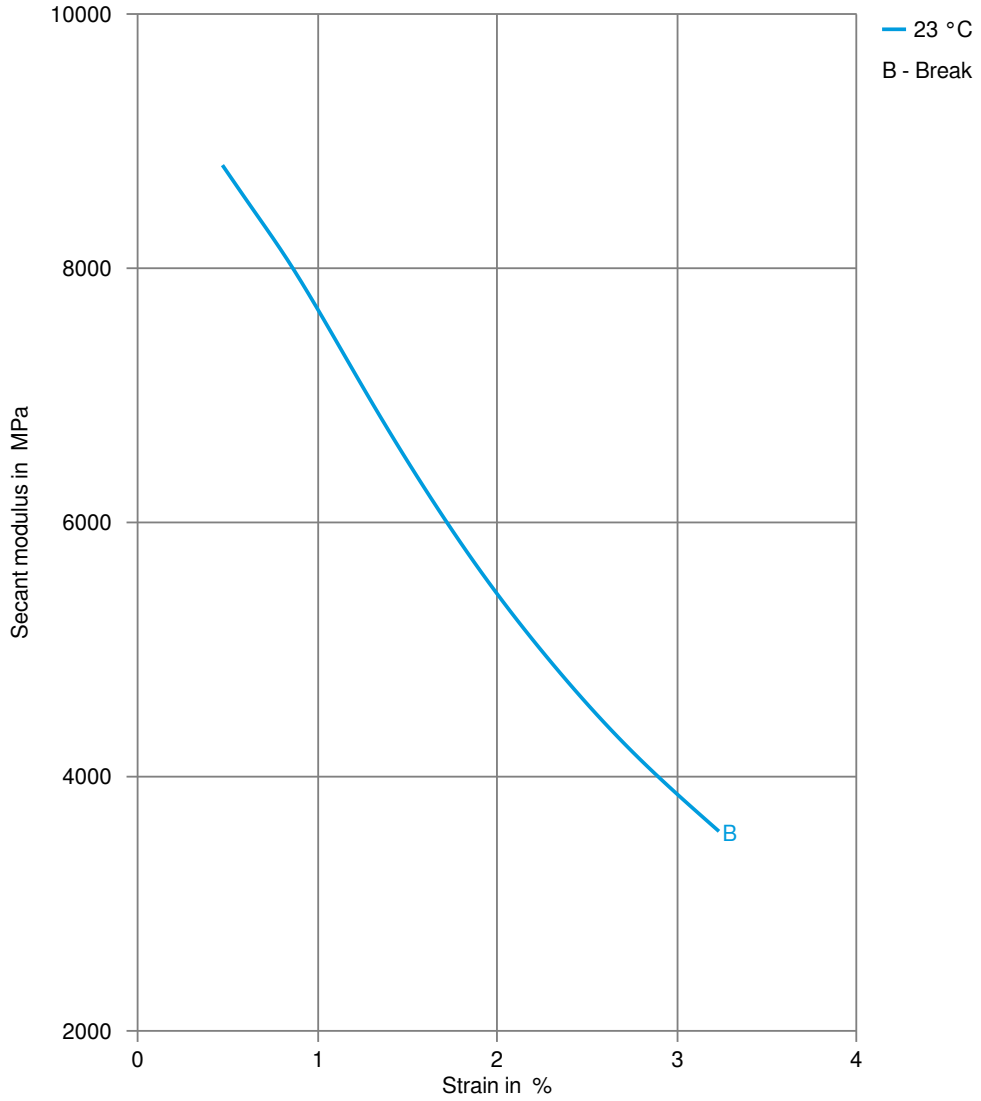
Secant modulus-strain



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Other Approvals

Other Approvals

OEM	Specification	Additional Information
Li Auto	Q/LiA5310038	2021 (V2)

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