CELANEX® 1642Z

PBT — Celanese

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
[C] Molding shrinkage, parallel	**0.6**	%	ISO 294-4, 2577
[C] Molding shrinkage, normal	**1.1**	%	ISO 294-4, 2577

[C]: CAMPUS

Mechanical properties	Value	Unit	Test Standard
ISO Data			
[C] Tensile Modulus	**6250**	MPa	ISO 527
[C] Stress at break	**105**	MPa	ISO 527
[C] Strain at break	**4**	%	ISO 527
[C] Charpy notched impact strength, +23°C	**6.3**	kJ/m²	ISO 179/1eA

[C]: CAMPUS

Thermal properties	Value	Unit	Test Standard
ISO Data			
[C] Coeff. of linear therm. expansion, parallel	**31**	E-6/K	ISO 11359-1/-2
[C] Coeff. of linear therm. expansion, normal	**120**	E-6/K	ISO 11359-1/-2

[C]: CAMPUS

Other properties	Value	Unit	Test Standard
[C] Water absorption	**0.1**	%	Sim. to ISO 62
[C] Density	**1450**	kg/m³	ISO 1183

[C]: CAMPUS

Characteristics

Processing
Injection Molding

Regional Availability
North America

Delivery form
Pellets

Other text information

Injection molding
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. Up to 25% clean and dry regrind may be used.