

**Product Texts**

Celanex 5206HG is a 15% glass-filled polyester featuring super high surface gloss and high flow for long flow channels. A typical application is oven handles.

Flammability at thickness h (0.8 HB mm)

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Molding shrinkage, parallel	0.5	%	ISO 294-4, 2577

[C]: CAMPUS

Mechanical properties	Value	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Tensile Modulus	6400	MPa	ISO 527
<sup>[C]</sup> Stress at break	95	MPa	ISO 527
<sup>[C]</sup> Strain at break	1.8	%	ISO 527
<sup>[C]</sup> Charpy notched impact strength, +23°C	4.7	kJ/m <sup>2</sup>	ISO 179/1eA

[C]: CAMPUS

Thermal properties	Value	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Melting temperature, 10°C/min	250	°C	ISO 11357-1/-3
<sup>[C]</sup> Temp. of deflection under load, 1.80 MPa	180	°C	ISO 75-1/-2
<sup>[C]</sup> Temp. of deflection under load, 0.45 MPa	220	°C	ISO 75-1/-2
<sup>[C]</sup> Burning Behav. at thickness h	HB	class	IEC 60695-11-10
Thickness tested	0.8	mm	-

[C]: CAMPUS

Other properties	Value	Unit	Test Standard
<sup>[C]</sup> Density	1450	kg/m <sup>3</sup>	ISO 1183

[C]: CAMPUS

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Melt temperature	270 - 300	°C	-
Mold temperature	120 - 135	°C	-

**Characteristics**

**Processing**

Injection Molding

**Features**

High Gloss

**Delivery form**

Pellets

**Other text information**

**Injection molding**

Rear Temperature 480-500 (250-260) deg F (deg C)  
 Center Temperature 490-510 (255-265) deg F (deg C)  
 Front Temperature 500-540 (260-270) deg F (deg C)  
 Nozzle Temperature 510-520 (265-275) deg F (deg C)  
 Melt Temperature 520-570 (270-300) deg F (deg C)  
 Mold Temperature 250-275 (120-135) deg F (deg C)  
 Back Pressure 0-25 psi

Screw Speed 50-75 rpm  
Injection Speed Medium/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. Up to 25% clean and dry regrind may be used.