



Celanex® 4022

Celanese Corporation - Polybutylene Terephthalate

Monday, November 4, 2019

General Information

Product Description

Celanex 4022 is a white PBT resin typically used for applications requiring very opaque parts.

General

Material Status	• Commercial: Active
Availability	• Europe • North America
RoHS Compliance	• Contact Manufacturer
Appearance	• White

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.46	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (250°C/2.16 kg)	19	g/10 min	ISO 1133
Molding Shrinkage - Flow	1.8 to 2.0	%	ISO 294-4
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	464000	psi	ISO 527-2/1A
Tensile Stress (Break)	8410	psi	ISO 527-2/1A/5
Tensile Strain (Break)	8.0	%	ISO 527-2/1A/5
Flexural Stress (73°F)	12500	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (73°F)	1.7	ft-lb/in ²	ISO 179/1eA
Charpy Unnotched Impact Strength (73°F)	16	ft-lb/in ²	ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (264 psi, Unannealed)	145	°F	ISO 75-2/A
Electrical	Nominal Value	Unit	Test Method
Comparative Tracking Index	400	V	IEC 60112

Processing Information

Injection	Nominal Value	Unit
Suggested Max Regrind	25	%
Hopper Temperature	68 to 122	°F
Rear Temperature	446 to 464	°F
Middle Temperature	455 to 482	°F
Front Temperature	455 to 482	°F
Nozzle Temperature	482 to 500	°F
Processing (Melt) Temp	455 to 500	°F
Mold Temperature	149 to 199	°F
Injection Rate	Fast	
Back Pressure	0.00 to 50.0	psi

Injection Notes

Die Temperature: 250 to 260°C
Feed Temperature: 230 to 240°C
Zone 4 Temperature: 240 to 260°C

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Notes

¹ Typical properties: these are not to be construed as specifications.