

CELANEX® 2004-2T

CELANEX® PBT

Celanex 2004-2T is an unfilled impact modified polyester that has an excellent combination of flowability and toughness. A typical application for Celanex 2004-2T is electrical connectors containing latches and / or film hinges. Celanex 2004-2T contains an internal lubricant.

Product information

Resin Identification	PBT-I	ISO 1043
Part Marking Code	>PBT-I<	ISO 11469

Rheological properties

Melt volume-flow rate	21 cm ³ /10min	ISO 1133
Temperature	250 °C	
Load	2.16 kg	
Viscosity number	142 cm ³ /g	ISO 307, 1628
Moulding shrinkage range, parallel	1.8 - 2 %	ISO 294-4, 2577

Typical mechanical properties

Tensile modulus	2100 MPa	ISO 527-1/-2
Tensile stress at yield, 50mm/min	53 MPa	ISO 527-1/-2
Tensile strain at yield, 50mm/min	10 %	ISO 527-1/-2
Tensile stress at break, 50mm/min	30 MPa	ISO 527-1/-2
Nominal strain at break	20 %	ISO 527-1/-2
Charpy notched impact strength, 23 °C	6 kJ/m ²	ISO 179/1eA
Poisson's ratio	0.4 ^[C]	

[C]: Calculated

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
Temperature of deflection under load, 1.8 MPa	55 °C	ISO 75-1/-2
Temperature of deflection under load, 0.45 MPa	165 °C	ISO 75-1/-2
Coefficient of linear thermal expansion (CLTE), parallel	110 E-6/K	ISO 11359-1/-2

Flammability

Burning Behav. at thickness h	HB class	IEC 60695-11-10
Thickness tested	1 mm	IEC 60695-11-10

Electrical properties

Relative permittivity, 100Hz	3.5	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
Arc Resistance	181 s	UL 746B

CELANEX® 2004-2T

CELANEX® PBT

Physical/Other properties

Water absorption, 2mm	0.45 %	Sim. to ISO 62
Density	1300 kg/m ³	ISO 1183

Injection

Drying Recommended	yes
Drying Temperature	120 °C
Drying Time, Dehumidified Dryer	4 h
Processing Moisture Content	≤0.02 %
Melt Temperature Optimum	250 °C
Min. melt temperature	240 °C
Max. melt temperature	260 °C
Screw tangential speed	0.1 - 0.3 m/s
Mold Temperature Optimum	80 °C
Min. mould temperature	60 °C
Max. mould temperature	130 °C

Characteristics

Processing	Injection Moulding
Delivery form	Pellets
Special characteristics	High impact or impact modified

Additional information

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.

Processing

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® 2004-2T

CELANEX® PBT

Processing Notes

CELANEX® 2004-2T

CELANEX® PBT

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.

Storage

For subsequent storage of the material in the dryer until processed (<= 60 h) it is necessary to lower the temperature to 100° C.

Automotive

OEM
VW Group

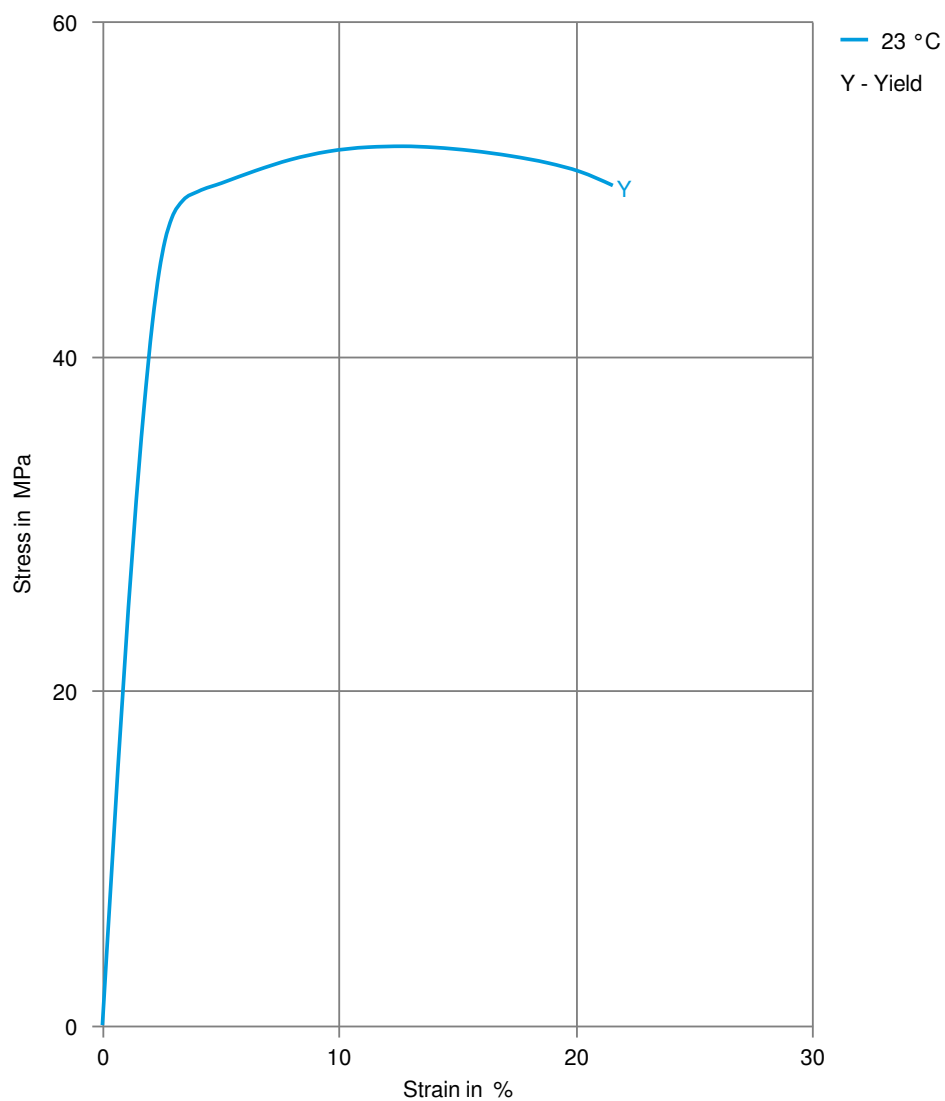
STANDARD
VW 50136

ADDITIONAL INFORMATION
PBT-1-A Black (With Deviations)

CELANEX® 2004-2T

CELANEX® PBT

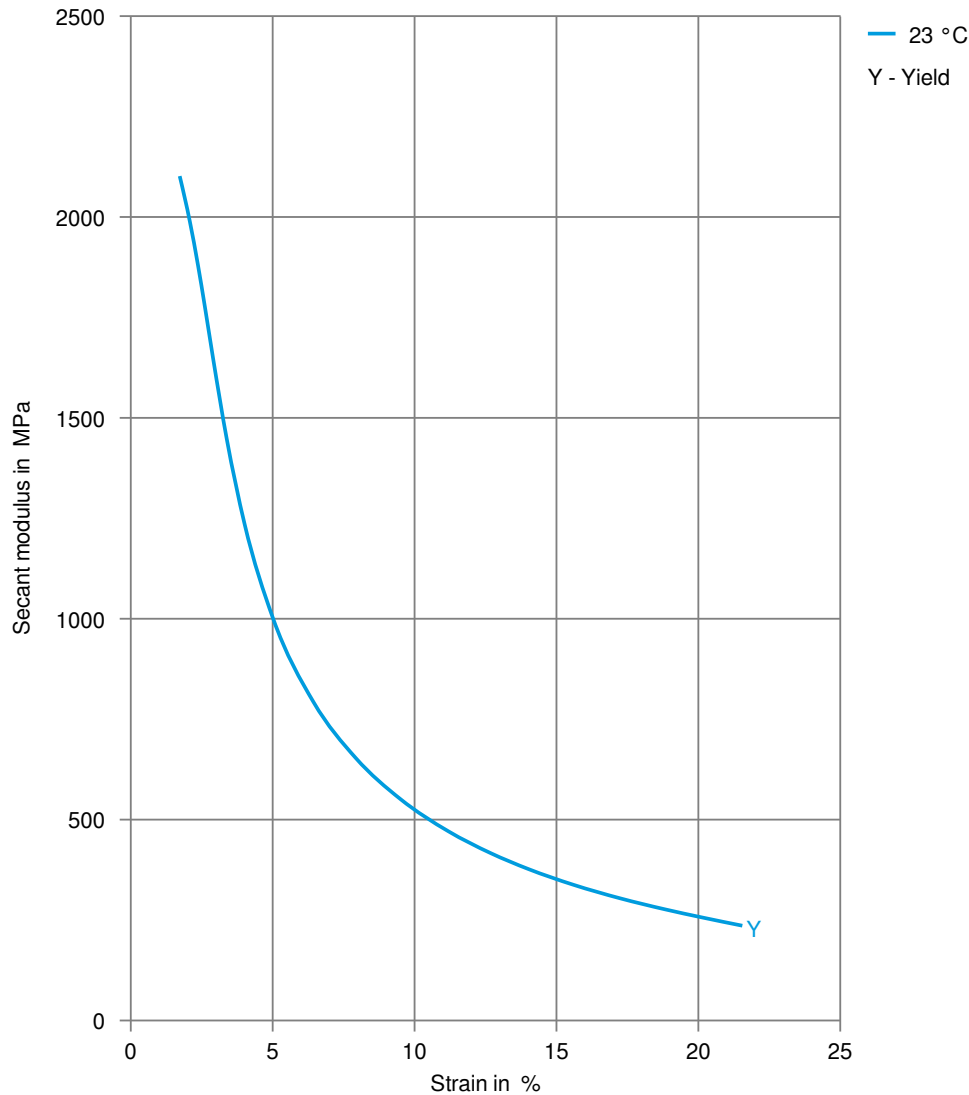
Stress-strain



CELANEX® 2004-2T

CELANEX® PBT

Secant modulus-strain



Printed: 2025-05-30

Page: 6 of 6

Revised: 2025-05-16 Source: Celanese Materials Database

NOTICE TO USERS: Values shown are based on testing of laboratory test specimens and represent data that fall within the standard range of properties for natural material. These values alone do not represent a sufficient basis for any part design and are not intended for use in establishing maximum, minimum, or ranges of values for specification purposes. Colourants or other additives may cause significant variations in data values. Properties of moulded parts can be influenced by a wide variety of factors including, but not limited to, material selection, additives, part design, processing conditions and environmental exposure. Other than those products expressly identified as medical grade (including by MT® product designation or otherwise), Celanese's products are not intended for use in medical or dental implants. Regardless of any such product designation, any determination of the suitability of a particular material and part design for any use contemplated by the users and the manner of such use is the sole responsibility of the users, who must assure themselves that the material as subsequently processed meets the needs of their particular product or use. To the best of our knowledge, the information contained in this publication is accurate; however, we do not assume any liability whatsoever for the accuracy and completeness of such information. The information contained in this publication should not be construed as a promise or guarantee of specific properties of our products. It is the sole responsibility of the users to investigate whether any existing patents are infringed by the use of the materials mentioned in this publication. Moreover, there is a need to reduce human exposure to many materials to the lowest practical limits in view of possible adverse effects. To the extent that any hazards may have been mentioned in this publication, we neither suggest nor guarantee that such hazards are the only ones that exist. We recommend that persons intending to rely on any recommendation or to use any equipment, processing technique or material mentioned in this publication should satisfy themselves that they can meet all applicable safety and health standards. We strongly recommend that users seek and adhere to the manufacturer's current instructions for handling each material they use, and entrust the handling of such material to adequately trained personnel only. Please call the telephone numbers listed for additional technical information. Call Customer Services for the appropriate Materials Safety Data Sheets (MSDS) before attempting to process our products.

© 2025 Celanese or its affiliates. All rights reserved. Celanese®, registered C-ball design and all other trademarks identified herein with ®, TM, SM, unless otherwise noted, are trademarks of Celanese or its affiliates. Fortron is a registered trademark of Fortron Industries LLC.