

Vandar® 6000

Celanese Corporation - Polybutylene Terephthalate

Tuesday, January 21, 2020

General Information

Product Description

Vandar 6000 is a toughened polyester alloy with excellent cold temperature impact resistance.

General

Material Status	• Commercial: Active
Availability	• Asia Pacific • Europe • Latin America • North America
Features	• Low Temperature Impact Resistance
RoHS Compliance	• Contact Manufacturer

ASTM & ISO Properties¹

Physical	Nominal Value	Unit	Test Method
Density	1.20	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (265°C/5.0 kg)	9.0	g/10 min	ISO 1133
Molding Shrinkage			ISO 294-4
Across Flow	0.50 to 0.90	%	
Flow	0.50 to 0.90	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	1750	MPa	ISO 527-2/1A
Tensile Stress (Yield)	45.0	MPa	ISO 527-2/1A/50
Tensile Stress (50% Strain)	35.0	MPa	ISO 527-2/1A/50
Tensile Strain (Yield)	4.5	%	ISO 527-2/1A/50
Nominal Tensile Strain at Break	> 50	%	ISO 527-2/1A/50
Flexural Modulus (23°C)	1600	MPa	ISO 178
Flexural Stress (23°C)	55.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength (23°C, Partial Break)	56	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (0.45 MPa, Unannealed)	106	°C	ISO 75-2/B
Heat Deflection Temperature (1.8 MPa, Unannealed)	74.0	°C	ISO 75-2/A
Glass Transition Temperature ²	78.0	°C	ISO 11357-2
CLTE - Flow	9.0E-5	cm/cm/°C	ISO 11359-2

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	120 to 130	°C
Drying Time	4.0	hr
Suggested Max Moisture	0.020	%
Hopper Temperature	20 to 50	°C
Rear Temperature	240 to 255	°C
Middle Temperature	250 to 260	°C
Front Temperature	250 to 260	°C
Nozzle Temperature	260 to 270	°C
Processing (Melt) Temp	260 to 280	°C

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Injection	Nominal Value	Unit
Mold Temperature	65 to 96	°C
Injection Rate	Moderate-Fast	

Injection Notes

Feeding zone temperature: 240 to 255°C

Zone4 temperature: 255 to 265°C

Hot runner temperature: 260 to 280°C

Notes

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

² 10°C/min