

CELANEX® 2000-3 | PBT | Unfilled

Description

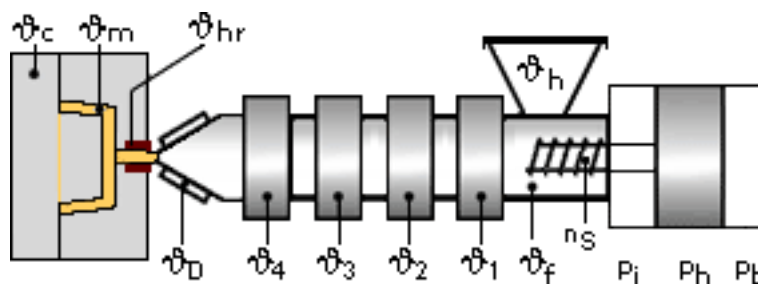
Celanex 2000-3 is a general purpose, unreinforced PBT with a good balance of mechanical properties and processability.. Celanex 2000-3 is a high flow material. Celanex 2000-3 contains an internal lubricant for improved mold release.

Mechanical properties	Value	Unit	Test Standard
Tensile modulus (1mm/min)	2700	MPa	ISO 527-2/1A
Tensile stress at yield (50mm/min)	60	MPa	ISO 527-2/1A
Tensile strain at yield (50mm/min)	4	%	ISO 527-2/1A
Tensile strain at break (50mm/min)	30	%	ISO 527-2/1A
Flexural modulus (23°C)	2600	MPa	ISO 178
Flexural strength (23°C)	85	MPa	ISO 178
Charpy impact strength @ 23°C	100.0	kJ/m ²	ISO 179/1eU
Charpy notched impact strength @ 23°C	4.0	kJ/m ²	ISO 179/1eA
Notched impact strength (Izod) @ 23°C	3.2	kJ/m ²	ISO 180/1A
Rockwell hardness	78	M-Scale	ISO 2039-2

Thermal properties	Value	Unit	Test Standard
DTUL @ 1.8 MPa	55	°C	ISO 75-1/-2
DTUL @ 0.45 MPa	155	°C	ISO 75-1/-2

Electrical properties	Value	Unit	Test Standard
Relative permittivity - 1 MHz	3.2	-	IEC 60250
Volume resistivity	1E15	Ohm*m	IEC 60093
Electric strength	15	kV/mm	IEC 60243-1

Typical injection moulding processing conditions



Temperature:

	$\vartheta_{\text{Manifold}}$	ϑ_{Mold}	ϑ_{Melt}	$\vartheta_{\text{Nozzle}}$	ϑ_{Zone4}	ϑ_{Zone3}	ϑ_{Zone2}	ϑ_{Zone1}	ϑ_{Feed}	$\vartheta_{\text{Hopper}}$
min (°C)	250	65	235	250	240	235	235	230	230	20
max (°C)	260	93	260	260	260	250	250	240	240	50

Injection Molding

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)

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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.

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General Disclaimer

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. Colorants or other additives may cause significant variations in data values.

Properties of molded 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. 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.

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