

## CELANEX® 3300-2LM | PBT | Glass Reinforced

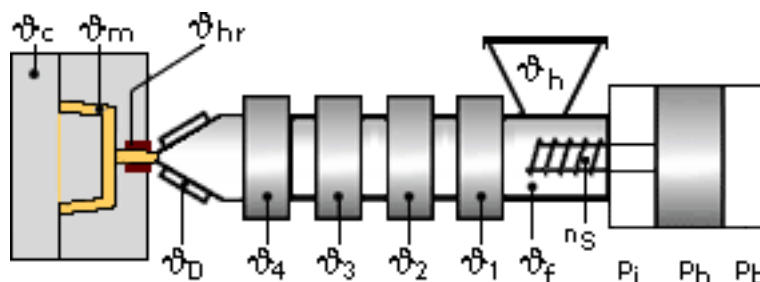
### Description

Celanex 3300-2LM is a 30% glass-filled PBT that is enhanced for improved laser marking graphics. It contains an internal lubricant for enhanced mold release.

Physical properties	Value	Unit	Test Standard
Density	<b>1530</b>	kg/m <sup>3</sup>	ISO 1183
Mold shrinkage - parallel	<b>.3-.5</b>	%	ISO 294-4

Mechanical properties	Value	Unit	Test Standard
Tensile stress at break (5mm/min)	<b>130</b>	MPa	ISO 527-2/1A
Flexural modulus (23°C)	<b>9700</b>	MPa	ISO 178
Flexural strength (23°C)	<b>210</b>	MPa	ISO 178
Notched impact strength (Izod) @ 23°C	<b>7.5</b>	kJ/m <sup>2</sup>	ISO 180/1A
Rockwell hardness	<b>90</b>	M-Scale	ISO 2039-2

### Typical injection moulding processing conditions



#### Temperature:

	ϕManifold	ϕMold	ϕMelt	ϕNozzle	ϕZone4	ϕZone3	ϕZone2	ϕZone1	ϕFeed	ϕHopper
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)
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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### Contact Information

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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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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 (+49 (0) 69 30516299 for Europe and +1 859-372-3244 for the Americas) for additional technical information. Call Customer Services for the appropriate Materials Safety Data Sheets (MSDS) before attempting to process our products.

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