

CELANEX® 3300D | PBT | Glass Reinforced

Description

Celanex 3300D is a general purpose, 30% glass reinforced, polybutylene terephthalate that offers a superior combination of mechanical, electrical, and thermal properties. This grade provides outstanding processability and good chemical resistance.

Physical properties	Value	Unit	Test Standard
Density	1530	kg/m ³	ISO 1183
Mold shrinkage - parallel	0.3-0.7	%	ISO 294-4
Mold shrinkage - normal	0.7-1.1	%	ISO 294-4
Humidity absorption (23°C/50%RH)	0.2	%	ISO 62

Mechanical properties	Value	Unit	Test Standard
Tensile modulus (1mm/min)	9200	MPa	ISO 527-2/1A
Tensile stress at break (5mm/min)	130	MPa	ISO 527-2/1A
Tensile strain at break (5mm/min)	2.5	%	ISO 527-2/1A
Flexural modulus (23°C)	9700	MPa	ISO 178
Flexural strength (23°C)	210	MPa	ISO 178
Charpy impact strength @ 23°C	46.0	kJ/m ²	ISO 179/1eU
Charpy impact strength @ -30°C	45.0	kJ/m ²	ISO 179/1eU
Charpy notched impact strength @ 23°C	8.5	kJ/m ²	ISO 179/1eA
Charpy notched impact strength @ -30°C	8.5	kJ/m ²	ISO 179/1eA
Notched impact strength (Izod) @ 23°C	7.5	kJ/m ²	ISO 180/1A
Rockwell hardness	90	M-Scale	ISO 2039-2

Thermal properties	Value	Unit	Test Standard
Melting temperature (10°C/min)	225	°C	ISO 11357-1,-2,-3
Glass transition temperature (10°C/min)	60	°C	ISO 11357-1,-2,-3
DTUL @ 1.8 MPa	205	°C	ISO 75-1/-2
DTUL @ 0.45 MPa	225	°C	ISO 75-1/-2
DTUL @ 8.0 MPa	150	°C	ISO 75-1/-2
Vicat softening temperature B50 (50°C/h 50N)	220	°C	ISO 306
Coeff.of linear therm. expansion (parallel)	0.25	E-4/°C	ISO 11359-2
Coeff.of linear therm. expansion (normal)	1	E-4/°C	ISO 11359-2
Limiting oxygen index (LOI)	20.0	%	ISO 4589
Flammability at thickness h	HB	class	UL94
thickness tested (h)	0.71	mm	UL94

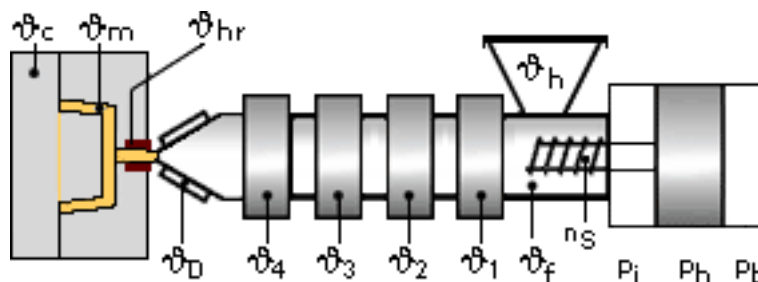
Electrical properties	Value	Unit	Test Standard
Relative permittivity - 100 Hz	4.5	-	IEC 60250
Relative permittivity - 1 MHz	4.1	-	IEC 60250
Dissipation factor - 100 Hz	22	E-4	IEC 60250
Dissipation factor - 1 MHz	160	E-4	IEC 60250
Volume resistivity	>1E13	Ohm*m	IEC 60093
Surface resistivity	>1E15	Ohm	IEC 60093
Electric strength	31	kV/mm	IEC 60243-1
Comparative tracking index CTI	425	-	IEC 60112

Test specimen production	Value	Unit	Test Standard
Processing conditions acc. ISO	7792-2	-	Internal

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Test specimen production	Value	Unit	Test Standard
Injection molding melt temperature	260	°C	ISO 294
Injection molding mold temperature	82	°C	ISO 294
Injection molding flow front velocity	300	mm/s	ISO 294
Injection molding hold pressure	48	MPa	ISO 294

Typical injection moulding processing conditions



Pre Drying:

Necessary low maximum residual moisture content: 0.02%

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.

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

Drying time: 4 h

Drying temperature: 120 - 130 °C

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

Speed:

Injection speed: medium-fast

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	

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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.

Contact Information

Americas

Ticona North American Headquarters
Product Information Service
8040 Dixie Highway
Florence, KY 41042
USA
Tel.: +1-800-833-4882
Tel.: +1-859-372-3244
email: prodinfo@ticona.com
Ticona on the web: www.ticona.com

Customer Service

Tel.: +1-800-526-4960
Tel.: +1-859-372-3214
Fax: +1-859-372-3125

Europe

Ticona GmbH
Information Service
Tel.: +49 (0) 180-5842662 (Germany)
+49 (0) 69-30516299 (Europe)
Fax: +49 (0) 180-2021202 (Germany & Europe)
email: infoservice@ticona.de
Internet: www.ticona.com

General Disclaimer

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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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