

## CELANEX® 3309HRT | PBT | Glass Reinforced

### Description

Celanex 3309HRT is a non-lubricated, 30% fiberglass reinforced Polybutylene Terephthalate that has excellent hydrolysis resistance, toughness and improved flow.

Physical properties	Value	Unit	Test Standard
Density	<b>1500</b>	kg/m <sup>3</sup>	ISO 1183
Mold shrinkage - parallel	<b>0-0.5</b>	%	ISO 294-4
Mold shrinkage - normal	<b>0.7</b>	%	ISO 294-4
Humidity absorption (23°C/50%RH)	<b>0.16</b>	%	ISO 62

Mechanical properties	Value	Unit	Test Standard
Tensile modulus (1mm/min)	<b>8700</b>	MPa	ISO 527-2/1A
Tensile stress at break (5mm/min)	<b>115</b>	MPa	ISO 527-2/1A
Tensile strain at break (5mm/min)	<b>2.8</b>	%	ISO 527-2/1A
Flexural modulus (23°C)	<b>9000</b>	MPa	ISO 178
Flexural strength (23°C)	<b>190</b>	MPa	ISO 178
Charpy impact strength @ 23°C	<b>53.0</b>	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy impact strength @ -30°C	<b>38.0</b>	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy notched impact strength @ 23°C	<b>10</b>	kJ/m <sup>2</sup>	ISO 179/1eA
Charpy notched impact strength @ -30°C	<b>10.0</b>	kJ/m <sup>2</sup>	ISO 179/1eA
Unnotched impact str (Izod) @ 23°C	<b>49</b>	kJ/m <sup>2</sup>	ISO 180/1U
Unnotched impact str (Izod) @ -30°C	<b>32</b>	kJ/m <sup>2</sup>	ISO 180/1U
Notched impact strength (Izod) @ 23°C	<b>10.0</b>	kJ/m <sup>2</sup>	ISO 180/1A

Thermal properties	Value	Unit	Test Standard
Melting temperature (10°C/min)	<b>225</b>	°C	ISO 11357-1,-2,-3
DTUL @ 1.8 MPa	<b>208</b>	°C	ISO 75-1/-2
DTUL @ 0.45 MPa	<b>222</b>	°C	ISO 75-1/-2
Coeff.of linear therm. expansion (parallel)	<b>0.24</b>	E-4/°C	ISO 11359-2
Coeff.of linear therm. expansion (normal)	<b>0.86</b>	E-4/°C	ISO 11359-2

Electrical properties	Value	Unit	Test Standard
Relative permittivity - 100 Hz	<b>2.8</b>	-	IEC 60250
Relative permittivity - 1 MHz	<b>2.8</b>	-	IEC 60250
Dissipation factor - 1 MHz	<b>110</b>	E-4	IEC 60250
Volume resistivity	<b>1E15</b>	Ohm*m	IEC 60093
Surface resistivity	<b>2E17</b>	Ohm	IEC 60093
Electric strength	<b>38</b>	kV/mm	IEC 60243-1
Comparative tracking index CTI	<b>450</b>	-	IEC 60112

## CELANEX® 3309HRT | PBT | Glass Reinforced

### 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	240	250	245	240	240	230	230	20
max (°C)	260	93	260	260	260	250	250	245	245	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	

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

Europe

## CELANEX® 3309HRT | PBT | Glass Reinforced

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](mailto:prodinfo@ticona.com)  
Ticona on the web: [www.ticona.com](http://www.ticona.com)

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](mailto:infoservice@ticona.de)  
Internet: [www.ticona.com](http://www.ticona.com)

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

### 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.

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 (+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.

The products mentioned herein are not intended for use in medical or dental implants.

© Copyright 2007, Ticona, all rights reserved. (Pub. 26-September-2013)