

CELANEX® 1700A

CELANEX® PBT

Celanex 1700A is a very high molecular weight grade of unreinforced polybutylene terephthalate for injection molding and extrusion applications.

Product information

Resin Identification	PBT	ISO 1043
Part Marking Code	>PBT<	ISO 11469

Rheological properties

Melt volume-flow rate	4.5 cm ³ /10min	ISO 1133
Temperature	250 °C	
Load	2.16 kg	
Melt mass-flow rate	5 g/10min	ISO 1133
Melt mass-flow rate, Temperature	250 °C	
Melt mass-flow rate, Load	2.16 kg	
Viscosity number	130 cm ³ /g	ISO 307, 1628
Moulding shrinkage range, parallel	1.8 - 2 %	ISO 294-4, 2577
Moulding shrinkage range, normal	1.8 - 2 %	ISO 294-4, 2577

Typical mechanical properties

Tensile modulus	2500 MPa	ISO 527-1/-2
Tensile stress at yield, 50mm/min	60 MPa	ISO 527-1/-2
Tensile strain at yield, 50mm/min	5 %	ISO 527-1/-2
Tensile stress at 50% strain	28 MPa	ISO 527-1/-2
Tensile stress at break, 50mm/min	35 MPa	ISO 527-1/-2
Nominal strain at break	>50 %	ISO 527-1/-2
Tensile strain at break, 50mm/min	120 %	ISO 527-1/-2
Flexural modulus	2200 MPa	ISO 178
Flexural strength	80 MPa	ISO 178
Flexural strain at failure	5 %	ISO 178
Charpy impact strength, 23°C	N kJ/m ²	ISO 179/1eU
Charpy impact strength, -30°C	220 kJ/m ²	ISO 179/1eU
Charpy notched impact strength, 23°C	7.5 kJ/m ²	ISO 179/1eA
Charpy notched impact strength, -30°C	7 kJ/m ²	ISO 179/1eA
Izod notched impact strength, 23°C	5.5 kJ/m ²	ISO 180/1A
Hardness, Rockwell, M-scale	72	ISO 2039-2
Poisson's ratio	0.38 ^[C]	
Shore D hardness, 15s	80	ISO 48-4 / ISO 868

[C]: Calculated

Thermal properties

Melting temperature, 10°C/min	225 °C	ISO 11357-1/-3
Glass transition temperature, 10°C/min	60 °C	ISO 11357-1/-3
Temperature of deflection under load, 1.8 MPa	50 °C	ISO 75-1/-2
Temperature of deflection under load, 0.45 MPa	150 °C	ISO 75-1/-2
Vicat softening temperature, 50°C/h 50N	182 °C	ISO 306
Coefficient of linear thermal expansion (CLTE), parallel	110 E-6/K	ISO 11359-1/-2
Coefficient of linear thermal expansion (CLTE), normal	100 E-6/K	ISO 11359-1/-2

CELANEX® 1700A

CELANEX® PBT

Flammability

Burning Behav. at thickness h	HB class	IEC 60695-11-10
Thickness tested	0.75 mm	IEC 60695-11-10
Oxygen index	22 %	ISO 4589-1/-2

Electrical properties

Relative permittivity, 100Hz	4	IEC 62631-2-1
Relative permittivity, 1MHz	3.6	IEC 62631-2-1
Dissipation factor, 100Hz	14 E-4	IEC 62631-2-1
Dissipation factor, 1MHz	210 E-4	IEC 62631-2-1
Volume resistivity	>1E13 Ohm.m	IEC 62631-3-1
Surface resistivity	>1E15 Ohm	IEC 62631-3-2
Electric strength	23 kV/mm	IEC 60243-1

Physical/Other properties

Humidity absorption, 2mm	0.2 %	Sim. to ISO 62
Water absorption, 2mm	0.45 %	Sim. to ISO 62
Water absorption, Immersion 24h	0.08 %	Sim. to ISO 62
Density	1310 kg/m ³	ISO 1183

Injection

Drying Recommended	yes
Drying Temperature	120 °C
Drying Time, Dehumidified Dryer	4 h
Processing Moisture Content	≤0.02 %
Melt Temperature Optimum	250 °C
Min. melt temperature	240 °C
Max. melt temperature	260 °C
Screw tangential speed	0.1 - 0.3 m/s
Mold Temperature Optimum	80 °C
Min. mould temperature	60 °C
Max. mould temperature	130 °C

Characteristics

Processing	Injection Moulding, Film Extrusion, Extrusion, Sheet Extrusion, Other Extrusion
Delivery form	Pellets

Additional information

Injection molding

Preprocessing

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 <-30 °F (-34 °C) at 250 °F (121 °C) for 4 hours.

Processing

CELANEX® 1700A

CELANEX® PBT

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.

Processing Notes

Pre-Drying

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.

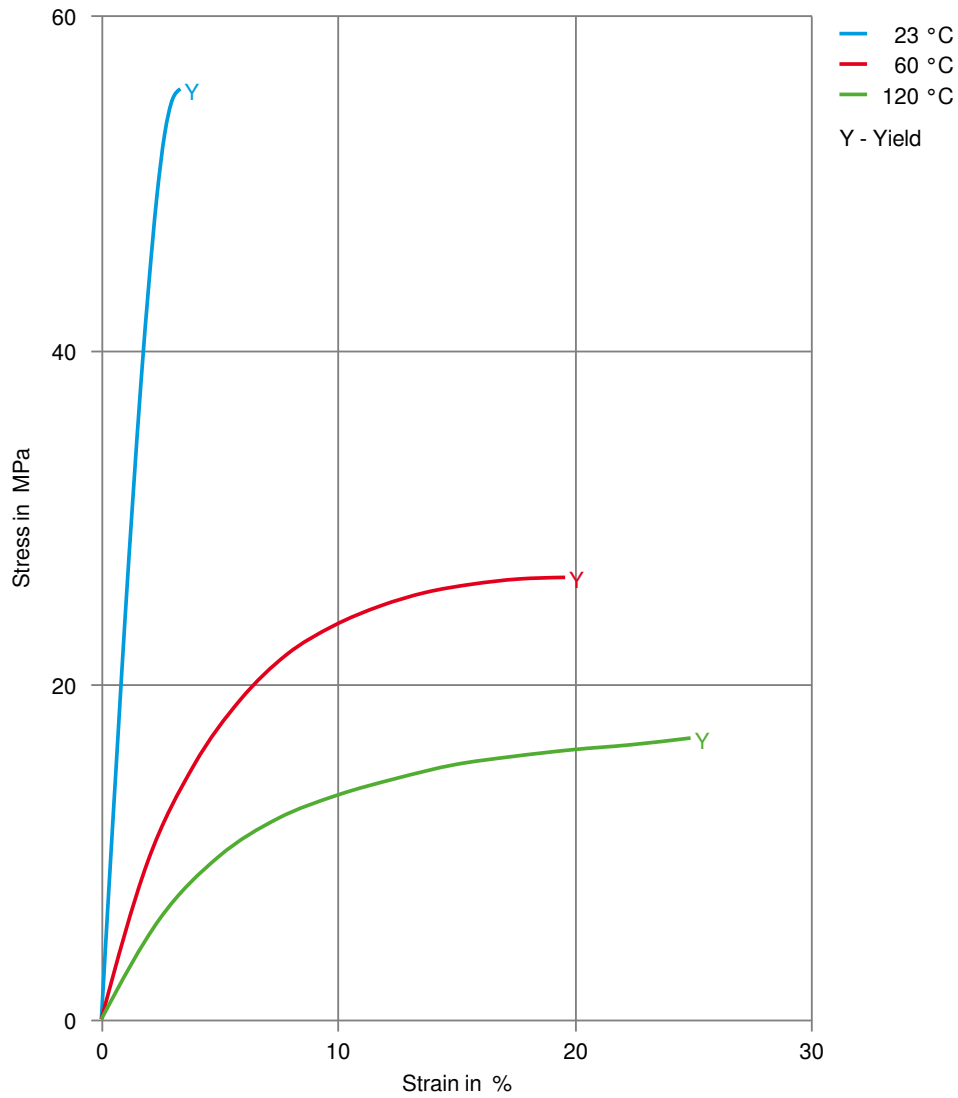
Storage

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

CELANEX® 1700A

CELANEX® PBT

Stress-strain



CELANEX® 1700A

CELANEX® PBT

Secant modulus-strain

