Celanese
The chemistry inside innovation™

CELANEX® 2300 GV1/10

CELANEX® PBT

Product information

Resin Identification	PBT-GF10		ISO 1043
Part Marking Code	>PBT-GF10<		ISO 11469

Rheological properties

Melt volume-flow rate	21	cm^3/10min	ISO 1133
Temperature	250	°C	
Load	2.16	kg	
Viscosity number	115	cm^3/g	ISO 307, 1628
Moulding shrinkage range, parallel	0.8 - 1.1	%	ISO 294-4, 2577
Moulding shrinkage range, normal	1.1 - 1.3	%	ISO 294-4, 2577

Typical mechanical properties

Tensile modulus	4700	MPa	ISO 527-1/-2
Tensile stress at break, 5mm/min	90	MPa	ISO 527-1/-2
Tensile strain at break, 5mm/min	3.5	%	ISO 527-1/-2
Charpy impact strength, 23°C	26	kJ/m^2	ISO 179/1eU
Charpy impact strength, -30°C	26	kJ/m^2	ISO 179/1eU
Charpy notched impact strength, 23°C	5	kJ/m^2	ISO 179/1eA
Charpy notched impact strength, -30°C	5	kJ/m^2	ISO 179/1eA
Poisson's ratio	0.36[C]		

[C]: Calculated

Thermal properties

Melting temperature, 10°C/min	225	°C	ISO 11357-1/-3
Temperature of deflection under load, 1.8 MPa	190	°C	ISO 75-1/-2
Temperature of deflection under load, 0.45 MPa	200	°C	ISO 75-1/-2
Vicat softening temperature, 50°C/h 50N	205	°C	ISO 306
Coefficient of linear thermal expansion (CLTE), parallel	60	E-6/K	ISO 11359-1/-2
Thermal conductivity of melt	0.144	W/(m K)	ISO 22007-2
Specific heat capacity of melt	1870	J/(kg K)	ISO 22007-4

Flammability

Burning Behav. at thickness h	HB	class	IEC 60695-11-10
Thickness tested	1	mm	IEC 60695-11-10
UL recognition	yes		UL 94
FMVSS Class	B		ISO 3795 (FMVSS 302)
Burning rate, Thickness 1 mm	43.8	mm/min	ISO 3795 (FMVSS 302)

Physical/Other properties

Humidity absorption, 2mm	0.2	%	Sim. to ISO 62
Water absorption, 2mm	0.5	%	Sim. to ISO 62
Density	1380	kg/m^3	ISO 1183
Density of melt	1170	kg/m^3	

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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
Ejection temperature	219	°C

Characteristics

Processing	Injection Moulding
Delivery form	Pellets
Additives	Release agent
Special characteristics	Heat stabilised or stable to heat

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%. The drying should be done in a dry-air dryer (dew point < -30 °C) with a temperature of 120 to 140 °C and a drying time of 2 to 4 hours. In case of longer residence times in the dry-air dryer, the temperature should be reduced to 100 °C.
The time between drying and processing should be kept as short as possible. The processing machine feed hopper should be closed during the processing operation.

Processing

Melt Temperature 260-270 °C
Mold Temperature *) 75-85 °C
Maximum Barrel Residence Time **) 5-10 min
Injection Speed fast
Peripheral screw speed max.0,3 m/sec
Back Pressure 10-30 bar
Injection Pressure 600-1000 bar
Holding Pressure 400-800 bar
Nozzle Design open design preferred

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

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the material has to be avoided. For grades containing flame retardants, a maximum temperature of 265 °C should not be exceeded. Up to 25% clean and dry regrind may be used.

Celanese recommends only externally heated hot runner systems.

*) For moulded parts with especially high requirements to the surface quality or dimensional stability, a mold temperature of up to 110 °C can be advantageous.

**) If the cylinder temperatures are higher than the recommended maximum temperatures, the max. residence time in the barrel has to be reduced.

Processing Notes

Pre-Drying

CELANEX should in principle be predried. Because of the necessary low maximum residual moisture content the use of dry air dryers is recommended. The dew point should be =< - 30° C. The time between drying and processing should be as short as possible.

Storage

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

Automotive

OEM	STANDARD	ADDITIONAL INFORMATION
Bosch	N28 BN07-GF010	Nat Akro
Bosch	N28 BN07-GF010	Blk Akro
Bosch	N28 BN07-O001	Natural
Bosch	N28 BN07-O001	Black