Celanese
The chemistry inside innovation™

CELANEX® 2302SW1 GV1/30

CELANEX® PBT

Chemical abbreviation according to ISO 1043-1: PBT+PET GF30, PTFE-modified grade with 30% glass fiber for injection molded parts with superior gloss and improved slip and wear characteristics. Flammability UL 94 HB minimum thickness 0.8 mm.
Preliminary Data Sheet

Product information

Resin Identification	(PBT+PET+PTFE)-GF30	ISO 1043
Part Marking Code	>(PBT+PET+PTFE)-GF30<	ISO 11469

Rheological properties

Melt volume-flow rate	10	cm^3/10min	ISO 1133
Temperature	265	°C	
Load	2.16	kg	

Typical mechanical properties

Tensile modulus	10500	MPa	ISO 527-1/-2
Tensile stress at break, 5mm/min	145	MPa	ISO 527-1/-2
Tensile strain at break, 5mm/min	2.5	%	ISO 527-1/-2
Poisson's ratio	0.34[C]		

[C]: Calculated

Thermal properties

Melting temperature, 10°C/min	255	°C	ISO 11357-1/-3
Temperature of deflection under load, 1.8 MPa	200	°C	ISO 75-1/-2

Flammability

Burning Behav. at thickness h	HB	class	IEC 60695-11-10
Thickness tested	0.8	mm	IEC 60695-11-10

Physical/Other properties

Humidity absorption, 2mm	0.15	%	Sim. to ISO 62
Density	1500	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	265	°C
Min. melt temperature	255	°C
Max. melt temperature	275	°C
Screw tangential speed	0.1 - 0.3	m/s
Mold Temperature Optimum	100	°C
Min. mould temperature	90	°C
Max. mould temperature	130	°C

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Characteristics

Processing	Injection Moulding
Delivery form	Pellets
Additives	Release agent
Special characteristics	Heat stabilised or stable to heat, Low wear / Low friction

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 265-275 °C
Mold Temperature *) 90-100 °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 the material has to be avoided.

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.