Celanese
The chemistry inside innovation™

CELANEX® 3216HR

CELANEX® PBT

Celanex 3216HR is a flame retarded, hydrolysis resistant, 15% fiberglass reinforced polybutylene terephthalate which has an excellent balance of mechanical properties and processability.

Product information

Resin Identification	PBT-I-GF15 FR(17)	ISO 1043
Part Marking Code	>PBT-I-GF15 FR(17)<	ISO 11469

Rheological properties

Melt mass-flow rate	9	g/10min	ISO 1133
Melt mass-flow rate, Temperature	250	°C	
Melt mass-flow rate, Load	2.16	kg	
Moulding shrinkage range, parallel	0.3 - 0.7	%	ISO 294-4, 2577
Moulding shrinkage range, normal	1 - 1.3	%	ISO 294-4, 2577

Typical mechanical properties

Tensile modulus	6000	MPa	ISO 527-1/-2
Tensile stress at break, 5mm/min	80	MPa	ISO 527-1/-2
Tensile strain at break, 5mm/min	3.1	%	ISO 527-1/-2
Flexural modulus	5300	MPa	ISO 178
Flexural strength	140	MPa	ISO 178
Charpy notched impact strength, 23°C	8	kJ/m²	ISO 179/1eA
Poisson's ratio	0.35[C]		

[C]: Calculated

Thermal properties

Melting temperature, 10°C/min	225	°C	ISO 11357-1/-3
Temperature of deflection under load, 1.8 MPa	180	°C	ISO 75-1/-2

Flammability

Burning Behav. at thickness h	V-0	class	IEC 60695-11-10
Thickness tested	0.8	mm	IEC 60695-11-10

Electrical properties

Comparative tracking index	250	IEC 60112

Physical/Other properties

Humidity absorption, 2mm	0.2	%	Sim. to ISO 62
Water absorption, 2mm	0.4	%	Sim. to ISO 62
Density	1510	kg/m³	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

Celanese
The chemistry inside innovation™

CELANEX® 3216HR

CELANEX® PBT

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	185 °C

Characteristics

Processing	Injection Moulding
Delivery form	Pellets
Additives	Flame retardant
Special characteristics	Flame retardant, Hydrolysis resistant

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 min. 4 hours.

Processing

Rear Temperature 450-470 (230-240) deg F (deg C)
Center Temperature 460-480 (235-250) deg F (deg C)
Front Temperature 470-490 (240-255) deg F (deg C)
Nozzle Temperature 480-490 (250-255) deg F (deg C)
Melt Temperature 460-490 (235-255) 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 PBT 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 min. 4 hours.

Celanese
The chemistry inside innovation™

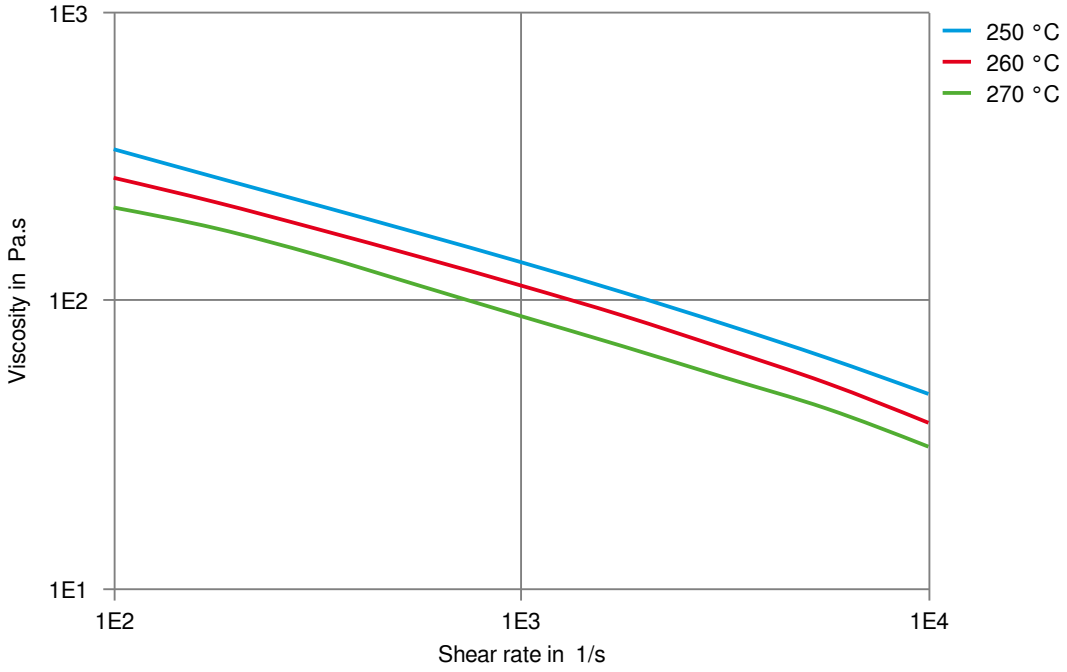
CELANEX® 3216HR

CELANEX® PBT

Storage

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

Viscosity-shear rate

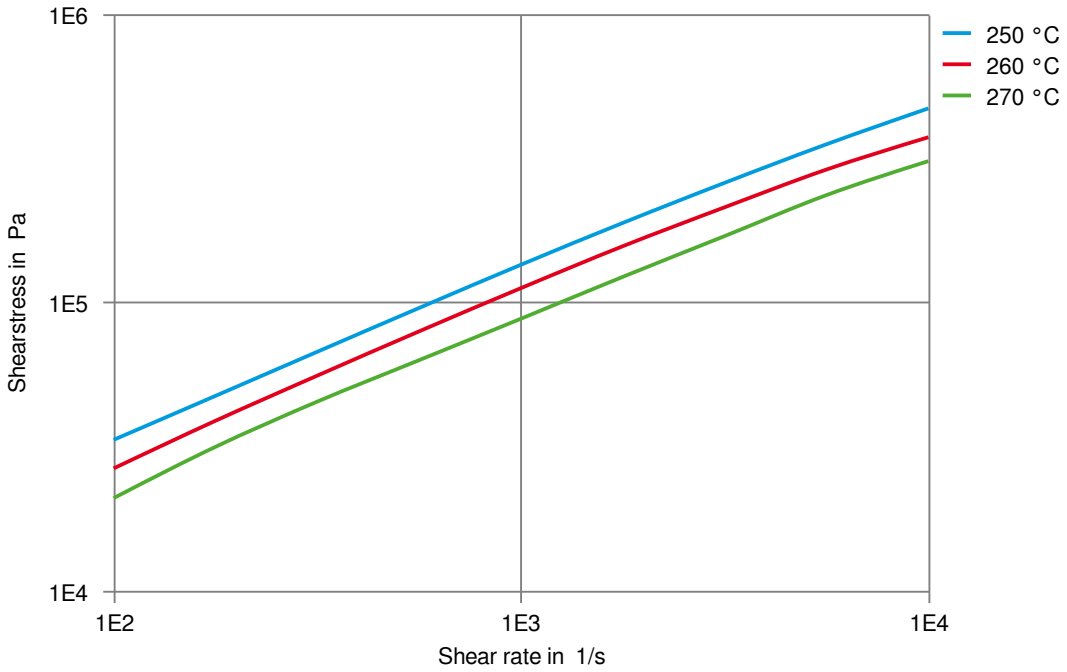


Celanese
The chemistry inside innovation™

CELANEX® 3216HR

CELANEX® PBT

Shearstress-shear rate

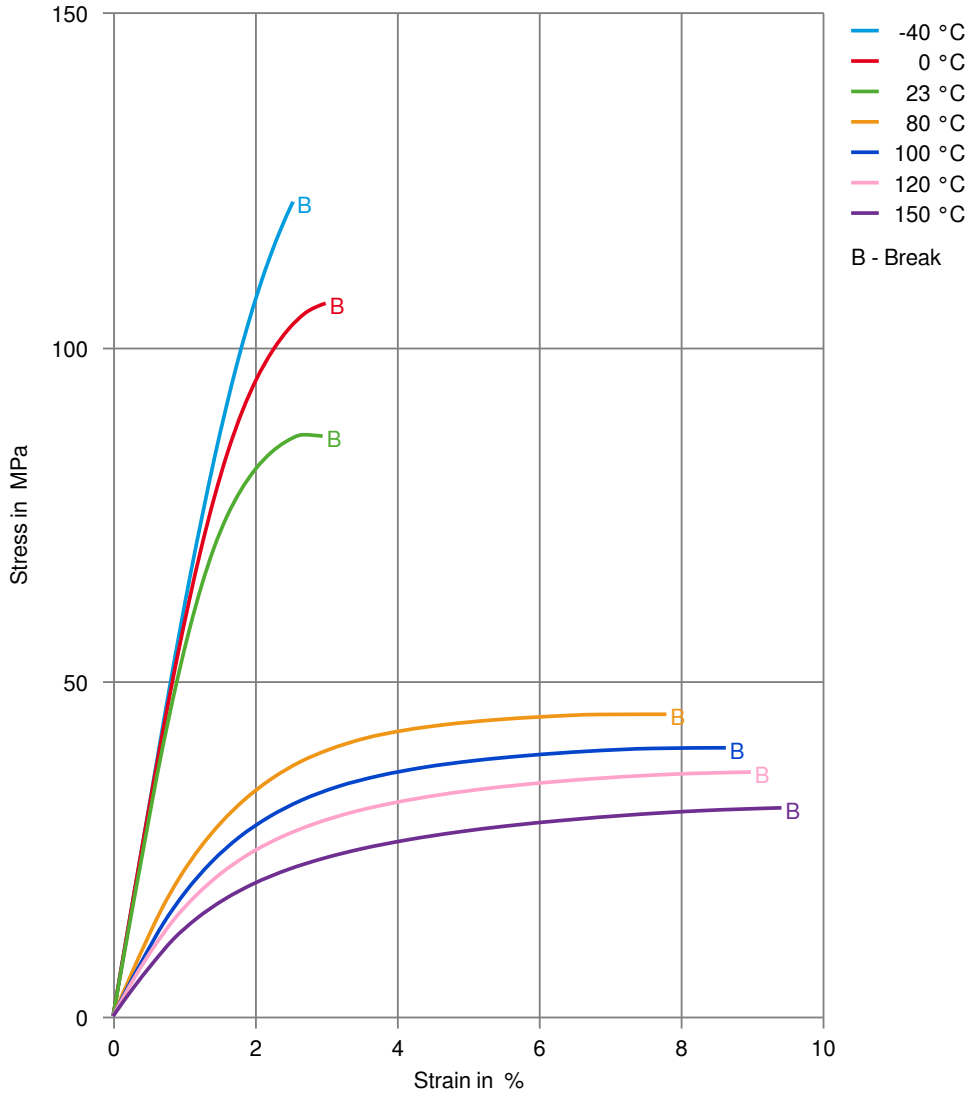


Celanese
The chemistry inside innovation™

CELANEX® 3216HR

CELANEX® PBT

Stress-strain



Celanese
The chemistry inside innovation™

CELANEX® 3216HR

CELANEX® PBT

Secant modulus-strain