

CELANEX® DS30HRLM

Celanex DS30HRLM is a non-lubricated, lasermarkable, 30% fiberglass reinforced Polybutylene Terephthalate which has excellent hydrolysis resistance, mechanical properties and processability.

Rheological properties

Melt mass-flow rate	14 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 - 0.5 %	ISO 294-4, 2577
Moulding shrinkage range, normal	0.7 - 0.9 %	ISO 294-4, 2577

Typical mechanical properties

Tensile Modulus	10000 MPa	ISO 527-1/-2
Stress at break, 5mm/min	140 MPa	ISO 527-1/-2
Strain at break, 5mm/min	2.8 %	ISO 527-1/-2
Flexural Modulus	9400 MPa	ISO 178
Flexural Strength	215 MPa	ISO 178
Charpy notched impact strength, 23°C	8 kJ/m ²	ISO 179/1eA
Izod notched impact strength, 23°C	9 kJ/m ²	ISO 180/1A
Izod impact strength, 23°C	35 kJ/m ²	ISO 180/1U

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
Temp. of deflection under load, 1.8 MPa	208 °C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	225 °C	ISO 75-1/-2
Vicat softening temperature, 50°C/h, 50N	220 °C	ISO 306
Coeff. of linear therm. expansion, parallel	25 E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal	100 E-6/K	ISO 11359-1/-2

Electrical properties

Relative permittivity, 100Hz	4.5	IEC 62631-2-1
Relative permittivity, 1MHz	4.1	IEC 62631-2-1
Dissipation factor, 100Hz	22 E-4	IEC 62631-2-1
Dissipation factor, 1MHz	160 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	31 kV/mm	IEC 60243-1
Comparative tracking index	PLC 1 PLC	UL 746A

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Other properties

Humidity absorption, 2mm	0.15 %	Sim. to ISO 62
Density	1550 kg/m ³	ISO 1183

Injection

Drying Temperature	120 - 130 °C
Drying Time, Dehumidified Dryer	4 h
Processing Moisture Content	0.02 %
Max. mould temperature	65 - 93 °C
Injection speed	medium-fast

Additional information

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
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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 Texts

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

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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.

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 $< -30^{\circ}\text{F}$ (-34°C) at 250°F (121°C) for 4 hours.
