

CELANEX® 2302 GV1/30 ECO-R - PBT
Description

Chemical abbreviation according ISO 1043-1: PBT+PET Moulding compound ISO 7792- PBT/PET, MGHR, 08-110N, GF30. Polybutylene terephthalate (PBT) / recycled Polyethylene terephthalate (r-PET) polymer blend, 30% glass fiber reinforced, for injection molded parts with superior gloss and with min. 25% recycled PET content.

Physical properties	Value	Unit	Test Standard
Density	96.8	lb/ft ³	ISO 1183
Melt volume rate, MVR	14	cm ³ /10min	ISO 1133
MVR temperature	509	°F	ISO 1133
MVR load	4.76	lb	ISO 1133
Mechanical properties	Value	Unit	Test Standard
Tensile modulus	1.45E6	psi	ISO 527-1, -2
Tensile stress at break, 5mm/min	21000	psi	ISO 527-1, -2
Tensile strain at break, 5mm/min	2.2	%	ISO 527-1, -2
Charpy notched impact strength, 23°C	4.04	ft-lb/in ²	ISO 179/1eA
Thermal properties	Value	Unit	Test Standard
Melting temperature, 10°C/min	491	°F	ISO 11357-1/-3
Electrical properties	Value	Unit	Test Standard
Comparative tracking index	PLC 2	-	UL 746
CTI 50 drops	250	V	IEC 60112

Typical injection moulding processing conditions

Pre Drying	Value	Unit
Necessary low maximum residual moisture content	0.02	%
Drying time	2 - 4	h
Drying temperature	248 - 284	°F
Temperature	Value	Unit
Hopper temperature	68 - 122	°F
Feeding zone temperature	446 - 464	°F
Zone1 temperature	482 - 500	°F
Zone2 temperature	482 - 500	°F
Zone3 temperature	500 - 518	°F
Zone4 temperature	500 - 518	°F
Nozzle temperature	509 - 527	°F
Melt temperature	509 - 527	°F
Mold temperature	194 - 248	°F
Hot runner temperature	509 - 527	°F
Speed	Value	
Injection speed	fast	
Screw Speed	Value	Unit
Screw speed diameter, 25mm	90	RPM
Screw speed diameter, 40mm	75	RPM
Screw speed diameter, 55mm	60	RPM

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Other text information

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 $\leq -30^{\circ}\text{C}$. The time between drying and processing should be as short as possible.

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

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.

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 $< -30^{\circ}\text{C}$) 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.

Characteristics

Special Characteristics	Heat resistant, High gloss, Recycled content
Product Categories	Glass reinforced, Polymer blend
Processing	Injection molding
Delivery Form	Pellets
Additives	Release agent, Antioxidant
