CELANEX® 2302SW1 GV1/20

CELANEX® PBT

Chemical abbreviation according to ISO 1043-1: PBT+PET GF20, PTFE-modified grade with 20% glass fiber for injection molded parts with superior gloss and improved slip and wear characteristics. Flammability UL 94 HB minimum thickness 0.8 mm.

Product information

Resin Identification	(PBT+PET+PTFE)-GF20	ISO 1043
Part Marking Code	>(PBT+PET+PTFE)-GF20<	ISO 11469

Rheological properties

Melt volume-flow rate	16	cm^3/10min	ISO 1133
Temperature	509	°F	
Load	4.76	lb	
Viscosity number	2020	in^3/lb	ISO 307, 1628
Molding shrinkage range, parallel	0.4 - 0.5	%	ISO 294-4, 2577
Molding shrinkage range, normal	0.9 - 1.1	%	ISO 294-4, 2577

Typical mechanical properties

Tensile modulus	1.16E6	psi	ISO 527-1/-2
Tensile stress at break, 5mm/min	19600	psi	ISO 527-1/-2
Tensile strain at break, 5mm/min	3	%	ISO 527-1/-2
Flexural strain at failure	3	%	ISO 178
Charpy impact strength, 23°C	26.2	ftlb/in^2	ISO 179/1eU
Charpy notched impact strength, 23°C	4.28	ftlb/in^2	ISO 179/1eA

Thermal properties

Melting temperature, 10°C/min	491	°F	ISO 11357-1/-3
Coefficient of linear thermal expansion (CLTE), parallel	0.11	E-4/°F	ISO 11359-1/-2
Coefficient of linear thermal expansion (CLTE), Parallel, 23-55°C(73-130°F)	0.139	E-4/°F	ASTM E 831
Coefficient of linear thermal expansion (CLTE), parallel, -40-23°C	0.139	E-4/°F	ISO 11359-1/-2
Coefficient of linear thermal expansion (CLTE), parallel, 55-160°C	0.0889	E-4/°F	ISO 11359-1/-2
Coefficient of linear thermal expansion (CLTE), normal	0.667	E-4/°F	ISO 11359-1/-2
Coefficient of linear thermal expansion (CLTE), Normal,23-55°C (73-130°F)	0.528	E-4/°F	ASTM E 831
Coefficient of linear thermal expansion (CLTE), normal, -40-23°C	0.389	E-4/°F	ISO 11359-1/-2
Coefficient of linear thermal expansion (CLTE), normal, 55-160°C	0.889	E-4/°F	ISO 11359-1/-2

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Flammability

Burning Behav. at 1.5mm nom. thickn.	HB	class	IEC 60695-11-10
Thickness tested	0.0630	in	IEC 60695-11-10
Burning Behav. at thickness h	HB	class	IEC 60695-11-10
Thickness tested	0.0315	in	IEC 60695-11-10
FMVSS Class	B		ISO 3795 (FMVSS 302)
Burning rate, Thickness 1 mm	1.81	in/min	ISO 3795 (FMVSS 302)

Physical/Other properties

Humidity absorption, 2mm	0.15	%	Sim. to ISO 62
Water absorption, 2mm	0.4	%	Sim. to ISO 62
Density	0.0549	lb/in³	ISO 1183

Injection

Drying Recommended	yes	
Drying Temperature	248	°F
Drying Time, Dehumidified Dryer	4	h
Processing Moisture Content	≤0.02	%
Melt Temperature Optimum	509	°F
Min. melt temperature	491	°F
Max. melt temperature	527	°F
Max. screw tangential speed	0.1 - 0.3	m/s
Mold Temperature Optimum	212	°F
Min. mold temperature	194	°F
Max. mold temperature	266	°F

Automotive

OEM	STANDARD
Continental	SN 57908-11

Characteristics

Processing	Injection Molding
Additives	Release agent
Special characteristics	Heat stabilized 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

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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.

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