CELANEX® 2408MT GF20

CELANEX® PBT

Chemical abbreviation according to ISO 1043-1: PBT+PET GF20. Celanex® 2408MT® GF20 is a special grade developed for medical industry applications and is filled with 20% glass fiber for injection molded parts with superior adhesion to thermoplastic copolyesters in a two-component molding process.

Celanex 2408MT GF20 is a special grade developed for medical industry applications and complies with:

- CFR 21 (177.1660) of the Food and Drug Administration (FDA)
- the corresponding EU and national registry regulatory requirements
- biocompatibility in tests corresponding to USP 23 Class VI/ISO 10993
- low residual monomers
- no animal products

Product information

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

Rheological properties

Melt volume-flow rate	20	cm^3/10min	ISO 1133
Temperature	509	°F	
Load	4.76	lb	
Molding shrinkage, parallel	0.3	%	ISO 294-4, 2577
Molding shrinkage range, parallel	0.2 - 0.4	%	ISO 294-4, 2577
Molding shrinkage, normal	0.8	%	ISO 294-4, 2577
Molding shrinkage range, normal	0.7 - 0.9	%	ISO 294-4, 2577

Typical mechanical properties

Tensile modulus	1.07E6	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 modulus	1.07E6	psi	ISO 178
Flexural strength	29000	psi	ISO 178
Charpy impact strength, 23°C	21.4	$ftlb/in^2$	ISO 179/1eU
Charpy impact strength, -30°C	19	$ftlb/in^2$	ISO 179/1eU
Charpy notched impact strength, 23°C	3.81	$ftlb/in^2$	ISO 179/1eA
Charpy notched impact strength, -30°C	3.81	$ftlb/in^2$	ISO 179/1eA
Ball indentation hardness, H 961/30	29700	psi	ISO 2039-1

Thermal properties

Melting temperature, 10°C/min	491	°F	ISO 11357-1/-3
Temperature of deflection under load, 1.8 MPa	397	°F	ISO 75-1/-2
Temperature of deflection under load, 0.45 MPa	432	°F	ISO 75-1/-2
Temperature of deflection under load, 8 MPa	194	°F	ISO 75-1/-2
Vicat softening temperature, 50°C/h 50N	410	°F	ISO 306
Coefficient of linear thermal expansion (CLTE), parallel	0.22	E-4/°F	ISO 11359-1/-2
Coefficient of linear thermal expansion (CLTE), normal	0.417	E-4/°F	ISO 11359-1/-2

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Physical/Other properties

Humidity absorption, 2mm	0.15	%	Sim. to ISO 62
Water absorption, 2mm	0.4	%	Sim. to ISO 62
Density	0.0534	lb/in³	ISO 1183

Injection

Drying Recommended	yes	
Drying Temperature	266[1]	°F
Drying Time, Dehumidified Dryer	2 - 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	230	°F
Min. mold temperature	212	°F
Max. mold temperature	266	°F
Ejection temperature	374	°F

[1]: Limits: from 120°C to 140°C

Characteristics

Processing	Injection Molding, Multi Injection Molding
Additives	Release agent
Special characteristics	High Gloss

Additional information

Injection molding

To minimize the volatile content in the final product, dry the resin to <0.02%, preferably ≤0.01% water content. In injection molding, use the lowest possible melt temperature (recommended 265 °C) and shortest feasible residence time (recommended 2-3 minutes). Store the parts in a ventilated, clean area before use. If assistance is needed please contact your Celanese account representative.

These recommendations are based on internal Celanese testing. For drying and injection molding conditions outside the above parameters, customer must test for and verify suitably low volatiles emissions on molded articles to confirm the final product is suitably pure for its intended use.

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 4 to min. 2 hours. In case of longer residence times in the dry-air dryer, the temperature should be reduced to below 80°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 Notes

Pre-Drying

To avoid hydrolytic degradation during processing, CELANEX PBT resins have to be dried to a moisture level to less than 0.02%, preferably equal or less than 0.01%. Drying should be done in a dehumidifying hopper dryer capable of dewpoints <-40°C (-40°F) at 120°C - 140°C (284°F) for 4 +/- 2 hours.

Storage

For subsequent storage of the material in the dryer until processed (<= 60 h) it is necessary to lower the temperature below 80° C.

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NOTICE TO USERS: Values shown are based on testing of laboratory test specimens and represent data that fall within the standard range of properties for natural material. These values alone do not represent a sufficient basis for any part design and are not intended for use in establishing maximum, minimum, or ranges of values for specification purposes. Colorants or other additives may cause significant variations in data values. Properties of molded parts can be influenced by a wide variety of factors including, but not limited to, material selection, additives, part design, processing conditions and environmental exposure. Other than those products expressly identified as medical grade (including by MT® product designation or otherwise), Celanese's products are not intended for use in medical or dental implants. Regardless of any such product designation, any determination of the suitability of a particular material and part design for any use contemplated by the users and the manner of such use is the sole responsibility of the users, who must assure themselves that the material as subsequently processed meets the needs of their particular product or use. To the best of our knowledge, the information contained in this publication is accurate; however, we do not assume any liability whatsoever for the accuracy and completeness of such information. The information contained in this publication should not be construed as a promise or guarantee of specific properties of our products. It is the sole responsibility of the users to investigate whether any existing patents are infringed by the use of the materials mentioned in this publication. Moreover, there is a need to reduce human exposure to many materials to the lowest practical limits in view of possible adverse effects. To the extent that any hazards may have been mentioned in this publication, we neither suggest nor guarantee that such hazards are the only ones that exist. We recommend that persons intending to rely on any recommendation or to use any equipment, processing technique or material mentioned in this publication should satisfy themselves that they can meet all applicable safety and health standards. We strongly recommend that users seek and adhere to the manufacturer's current instructions for handling each material they use, and entrust the handling of such material to adequately trained personnel only. Please call the telephone numbers listed for additional technical information. Call Customer Services for the appropriate Materials Safety Data Sheets (MSDS) before attempting to process our products.
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