CELANEX® 3309HRHF

CELANEX® PBT

Celanex 3309HRHF is a 30% fiberglass reinforced Polybutylene Terephthalate which has excellent hydrolysis resistance, mechanical properties and improved flow.

Product information

Resin Identification	PBT-GF30	ISO 1043
Part Marking Code	>PBT-GF30<	ISO 11469

Rheological properties

Melt mass-flow rate	30	g/10min	ISO 1133
Melt mass-flow rate, Temperature	482	°F	
Melt mass-flow rate, Load	4.76	lb	
Molding shrinkage range, parallel	0.1 - 0.5	%	ISO 294-4, 2577
Molding shrinkage range, normal	0.7 - 1.2	%	ISO 294-4, 2577

Typical mechanical properties

Tensile modulus	1.51E6	psi	ISO 527-1/-2
Tensile stress at break, 5mm/min	21800	psi	ISO 527-1/-2
Tensile strain at break, 5mm/min	2.6	%	ISO 527-1/-2
Flexural modulus	1.41E6	psi	ISO 178
Flexural strength	31900	psi	ISO 178
Charpy impact strength, 23°C	20.9	ftlb/in²	ISO 179/1eU
Charpy impact strength, -30°C	18.6	ftlb/in²	ISO 179/1eU
Charpy notched impact strength, 23°C	3.81	ftlb/in²	ISO 179/1eA
Charpy notched impact strength, -30°C	4.33	ftlb/in²	ISO 179/1eA
Izod notched impact strength, 23°C	4.28	ftlb/in²	ISO 180/1A
Izod impact strength, 23°C	21.4	ftlb/in²	ISO 180/1U

Thermal properties

Melting temperature, 10°C/min	437	°F	ISO 11357-1/-3
Glass transition temperature, 10°C/min	140	°F	ISO 11357-1/-3
Temperature of deflection under load, 1.8 MPa	410	°F	ISO 75-1/-2
Temperature of deflection under load, 0.45 MPa	432	°F	ISO 75-1/-2
Coefficient of linear thermal expansion (CLTE), parallel	0.11	E-4/°F	ISO 11359-1/-2
Coefficient of linear thermal expansion (CLTE), normal	0.556	E-4/°F	ISO 11359-1/-2

Electrical properties

Relative permittivity, 100Hz	2.8		IEC 62631-2-1
Relative permittivity, 1MHz	3.2		IEC 62631-2-1
Dissipation factor, 1MHz	140	E-4	IEC 62631-2-1
Volume resistivity	2E15	Ohm.m	IEC 62631-3-1
Surface resistivity	2E15	Ohm	IEC 62631-3-2
Electric strength	559	kV/in	IEC 60243-1
Comparative tracking index	425		IEC 60112

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Physical/Other properties

Humidity absorption, 2mm	0.16	%	Sim. to ISO 62
Density	0.0552	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	482	°F
Min. melt temperature	464	°F
Max. melt temperature	500	°F
Max. screw tangential speed	0.1 - 0.3	m/s
Mold Temperature Optimum	176	°F
Min. mold temperature	140	°F
Max. mold temperature	266	°F
Ejection temperature	334	°F

Automotive

OEM	STANDARD	ADDITIONAL INFORMATION
Ford	WSS-M4D1017-A1	
General Motors	GMW16459P-PBT-GF30W	N/A
Li Auto	Q/LiA5310038	2021 (V2)

Characteristics

Processing	Injection Molding
Special characteristics	Hydrolysis resistant, High Flow

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 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 470-500(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)

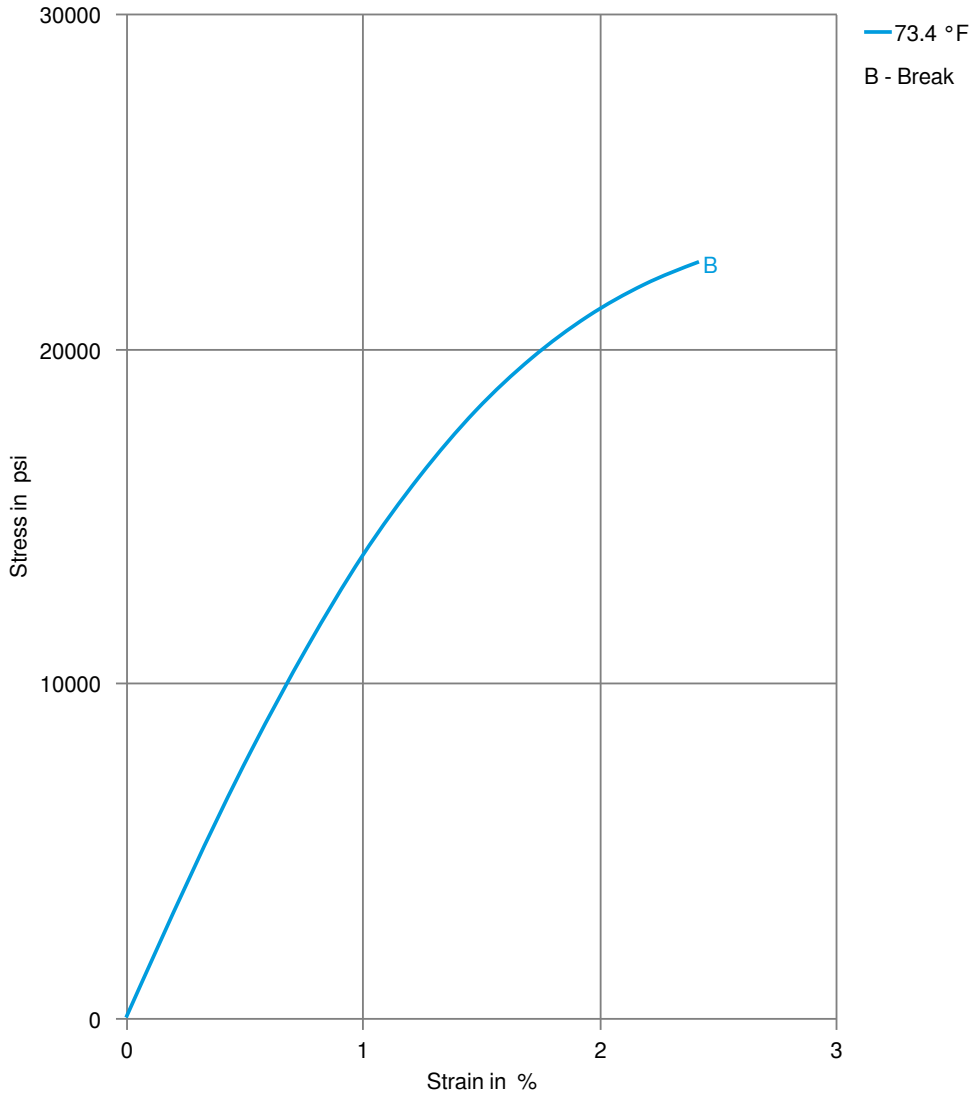
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Back Pressure 0-50 psi
Screw Speed Medium
Injection Speed Fast

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.

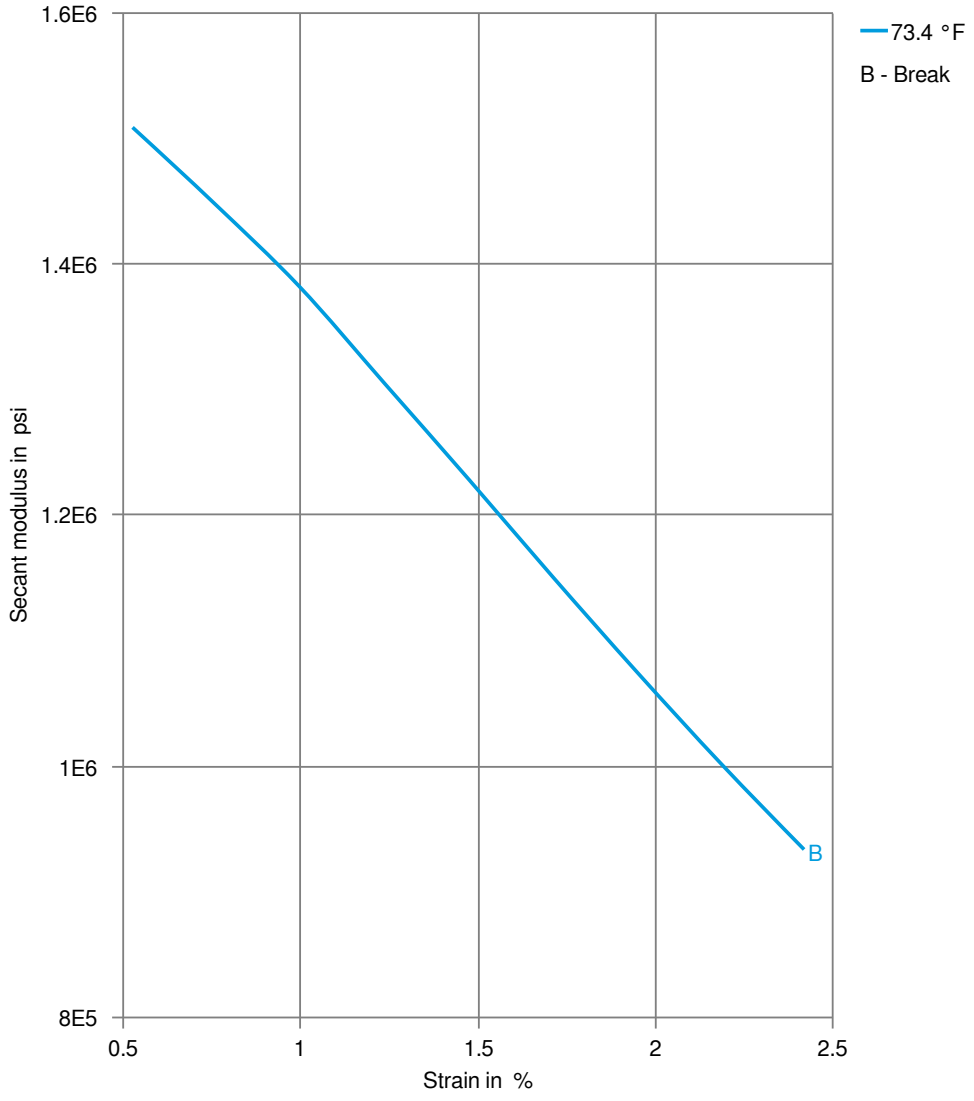
Stress-strain



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Secant modulus-strain



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