CELSTRAN® PBT-GF50-08

CELSTRAN® Long Fibre

50% Long Glass Fiber Reinforced PBT

Product information

Resin Identification	PBT-LGF50	ISO 1043
Part Marking Code	>PBT-LGF50<	ISO 11469

Typical mechanical properties

Tensile modulus	2.41E6	psi	ISO 527-1/-2
Tensile stress at break, 5mm/min	25800	psi	ISO 527-1/-2
Tensile strain at break, 5mm/min	1.4	%	ISO 527-1/-2
Flexural modulus	2.31E6	psi	ISO 178
Flexural strength	41300	psi	ISO 178
Charpy notched impact strength, 23 °C	15.2	ftlb/in²	ISO 179/1eA

Physical/Other properties

Density	0.0625	lb/in³	ISO 1183

Injection

Drying Recommended	yes	
Drying Temperature	248	°F
Drying Time, Dehumidified Dryer	4	h
Processing Moisture Content	≤0.04	%
Melt Temperature Optimum	482	°F
Min. melt temperature	464	°F
Max. melt temperature	500	°F
Max. screw tangential speed	0.1 - 0.2	m/s
Mold Temperature Optimum	176	°F
Min. mold temperature	140	°F
Max. mold temperature	266	°F
Ejection temperature	352	°F

Characteristics

Processing	Injection Molding

Additional information

Injection molding

Preprocessing

PBT Drying Requirements: 4 hrs. @ 120° C.
A dehumidifier or desiccant dryer is recommended.

Processing

Celstran can be processed on a standard injection molding unit.
A general purpose metering screw is recommended with a zone distribution of 40% feed, 40% transition, and 20% metering.
A free flowing check ring assembly is recommended.

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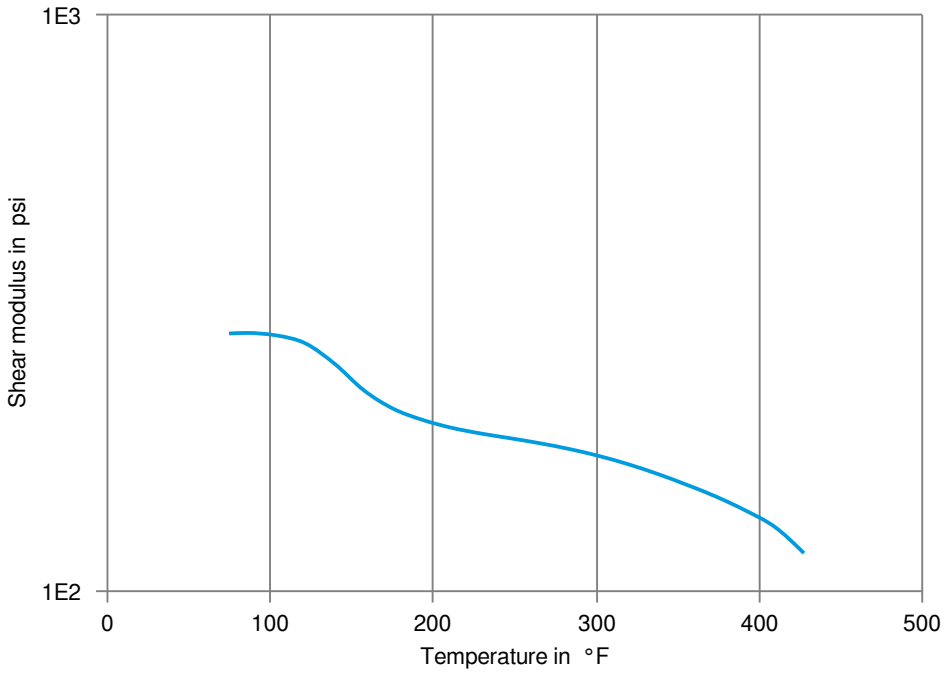
Melt Temp.: 280 - 300° C.
Mold Temp.: 80 - 90° C.

Processing Notes

Pre-Drying

CELSTRAN PBT 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

Dynamic Shear modulus-temperature



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