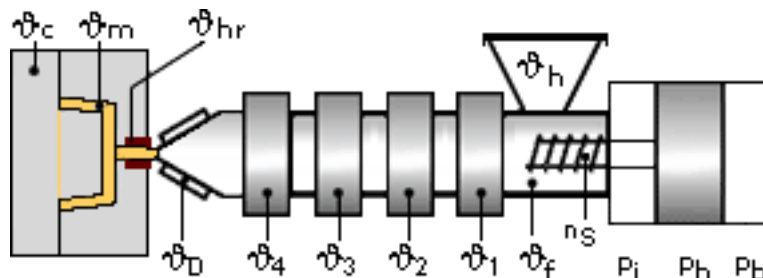


CELSTRAN® PBT-CF40-08 | PBT | Specialty

Description

40% long carbon fiber reinforced PBT

Typical injection moulding processing conditions



Pre Drying:

Necessary low maximum residual moisture content: 0.02%

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

Drying time: 2-4 h

Drying temperature: 248 - 284 °F

Temperature:

	T_{Mold}	T_{Melt}	T_{Nozzle}	T_{Feed}
min (°F)	194	509	509	68
max (°F)	212	545	545	122

Injection Molding

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.

Melt Temp.: 280 - 300° C.

Mold Temp.: 80 - 90° C.

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