

# PBT | KEPEX 3300M | Unfilled grade

- KEPEX 3300M is a non-reinforced and mold-releasing PBT grade.
- It has easy mold-releasing characteristics and superior dimensional stability.
- It is suitable for precision injection molding parts.

Physical properties	<b>Test Standard</b>	Unit	Value	
Filler contents	ISO 1172	%	-	
Specific gravity	ISO 1183	-	1.32	
Mold shrinkage(Flow direction, $\Phi = 100 \text{ mm}$ , $t = 3 \text{ mm}$ )	KEP Method	%	2.1	

Thermal properties	Test Standard	Unit	Value
Melting point(10 °C/min)	ISO 11357	$^{\circ}$ C	220
Heat deflection temperature(0.45 MPa)	ISO 75	°C	170
Heat deflection temperature(1.8 MPa)	ISO 75	$^{\circ}$ C	80
Flammability(t = 0.8 mm)	UL 94	Class	НВ

Mechanical properties	Test Standard	Unit	Value
Tensile stress	ISO 527	MPa	65
Elongation at break	ISO 527	%	9.0
Tensile modulus	ISO 527	MPa	2700
Flexural strength	ISO 178	MPa	95
Flexural modulus	ISO 178	MPa	2750
Charpy impact strength(Notched) @ 23°C	ISO 179/1eA	kJ/m <sup>2</sup>	2.7
Charpy impact strength(Notched) @ -30°C	ISO 179/1eA	kJ/m <sup>2</sup>	2.0
Rockwell Hardness(R-Scale)	ISO 2039	-	118

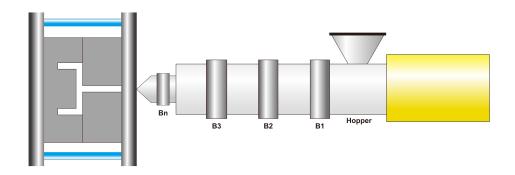
<b>Electrical properties</b>	Test Standard	Unit	Value
Permittivity(60 Hz)	ASTM D150	-	3.0
Dissipation factor(60 Hz)	ASTM D150	-	0.002
Volume resistivity	IEC 60093	Ω/ cm	10 <sup>16</sup>

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## Injection molding condition



## Pre-drying (Suggested max. moisture: 0.05%)

It is recommend to dry material at  $120^{\circ}\text{C} \sim 130^{\circ}\text{C}(248^{\circ}\text{F} \sim 266^{\circ}\text{F})$  for 3 h ~ 5 h at dryer.

## **Temperature**

Mold temperature :  $70 \,^{\circ}\text{C} \sim 90 \,^{\circ}\text{C} (158 \,^{\circ}\text{F} \sim 194 \,^{\circ}\text{F})$ Barrel temperature :  $230 \,^{\circ}\text{C} \sim 250 \,^{\circ}\text{C} (446 \,^{\circ}\text{F} \sim 482 \,^{\circ}\text{F})$ 

Mold	Bn(Nozzle)	B3(Metering)	B2(Compression)	B1(Feeding)	Hopper
70 ~ 90 °C	250 ℃	240 °C	240 °C	230 °C	60 ~ 80 °C
158 ~ 194 °F	482 °F	464 °F	464 °F	446 °F	140 ~ 176 °F

#### **Plastification**

Screw speed:  $80 \sim 120 \text{ rpm}$ Back pressure:  $5 \sim 10 \text{ kgf/cm}^2$ 

#### Disclaimer

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