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	Test Standard	Unit	Value
Filler contents	ISO 1172	%	-
Specific gravity	ISO 1183	-	1.32
Mold shrinkage(Flow direction, Φ = 100 mm, t = 3 mm)	KEP Method	%	2.1

Thermal properties	Test Standard	Unit	Value
Melting point(10 ℃/min)	ISO 11357	℃	220
Heat deflection temperature(0.45 MPa)	ISO 75	℃	170
Heat deflection temperature(1.8 MPa)	ISO 75	℃	80
Flammability(t = 0.8 mm)	UL 94	Class	HB

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℃	ISO 179/1eA	kJ/m^2	2.7
Charpy impact strength(Notched) @ -30℃	ISO 179/1eA	kJ/m^2	2.0
Rockwell Hardness(R-Scale)	ISO 2039	-	118

Electrical properties	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^{16}

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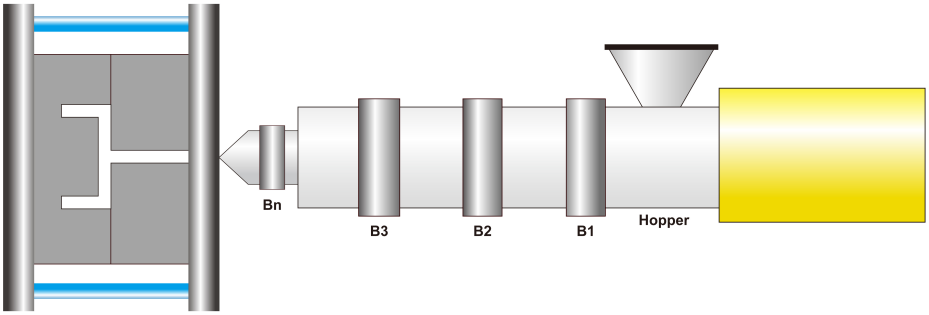
Injection molding condition



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

It is recommend to dry material at 120℃ ~ 130℃(248℉ ~ 266℉) for 3 h ~ 5 h at dryer.

Temperature

Mold temperature : 70 ℃ ~ 90 ℃(158 ℉ ~ 194 ℉)
Barrel temperature : 230 ℃ ~ 250 ℃(446 ℉ ~ 482 ℉)

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

Plastification

Screw speed : 80 ~ 120 rpm
Back pressure : 5 ~ 10 kgf/cm^2

Disclaimer