Celanese
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CELANEX® 3200-2

CELANEX® PBT

Celanex 3200-2 is a general purpose, 15% glass reinforced polybutylene terephthalate with a good balance of mechanical properties and processability. Celanex 3200-2 contains an internal lubricant.

Product information

Resin Identification	PBT-GF15		ISO 1043
Part Marking Code	>PBT-GF15<		ISO 11469

Rheological properties

Melt volume-flow rate	26	cm^3/10min	ISO 1133
Temperature	250	°C	
Load	2.16	kg	
Moulding shrinkage range, parallel	0.5 - 0.7	%	ISO 294-4, 2577
Moulding shrinkage range, normal	0.9 - 1.1	%	ISO 294-4, 2577

Typical mechanical properties

Tensile modulus	5800	MPa	ISO 527-1/-2
Tensile stress at break, 5mm/min	100	MPa	ISO 527-1/-2
Tensile strain at break, 5mm/min	3.5	%	ISO 527-1/-2
Flexural modulus	5200	MPa	ISO 178
Flexural strength	150	MPa	ISO 178
Charpy impact strength, 23°C	20	kJ/m^2	ISO 179/1eU
Charpy impact strength, -30°C	20	kJ/m^2	ISO 179/1eU
Charpy notched impact strength, 23°C	5.5	kJ/m^2	ISO 179/1eA
Charpy notched impact strength, -30°C	5	kJ/m^2	ISO 179/1eA
Izod notched impact strength, 23°C	5	kJ/m^2	ISO 180/1A
Izod impact strength, 23°C	19.8	kJ/m^2	ISO 180/1U
Hardness, Rockwell, M-scale	90		ISO 2039-2
Poisson's ratio	0.35[C]		

[C]: Calculated

Thermal properties

Melting temperature, 10°C/min	225	°C	ISO 11357-1/-3
Glass transition temperature, 10°C/min	60	°C	ISO 11357-1/-3
Temperature of deflection under load, 1.8 MPa	195	°C	ISO 75-1/-2
Temperature of deflection under load, 0.45 MPa	215	°C	ISO 75-1/-2
Temperature of deflection under load, 8 MPa	90	°C	ISO 75-1/-2
Vicat softening temperature, 50°C/h 50N	215	°C	ISO 306
Coefficient of linear thermal expansion (CLTE), parallel	40	E-6/K	ISO 11359-1/-2
Coefficient of linear thermal expansion (CLTE), normal	110	E-6/K	ISO 11359-1/-2

Flammability

Burning Behav. at thickness h	HB	class	IEC 60695-11-10
Thickness tested	0.71	mm	IEC 60695-11-10
Oxygen index	20	%	ISO 4589-1/-2

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Electrical properties

Relative permittivity, 100Hz	4.2		IEC 62631-2-1
Relative permittivity, 1MHz	3.8		IEC 62631-2-1
Dissipation factor, 100Hz	16	E-4	IEC 62631-2-1
Dissipation factor, 1MHz	200	E-4	IEC 62631-2-1
Volume resistivity	>1E13	Ohm.m	IEC 62631-3-1
Surface resistivity	>1E15	Ohm	IEC 62631-3-2
Electric strength	29	kV/mm	IEC 60243-1
Comparative tracking index	350		IEC 60112

Physical/Other properties

Humidity absorption, 2mm	0.2	%	Sim. to ISO 62
Water absorption, 2mm	0.45	%	Sim. to ISO 62
Density	1410	kg/m³	ISO 1183

Injection

Drying Recommended	yes	
Drying Temperature	120	°C
Drying Time, Dehumidified Dryer	4	h
Processing Moisture Content	≤0.02	%
Melt Temperature Optimum	250	°C
Min. melt temperature	240	°C
Max. melt temperature	260	°C
Screw tangential speed	0.1 - 0.3	m/s
Mold Temperature Optimum	80	°C
Min. mould temperature	60	°C
Max. mould temperature	130	°C
Ejection temperature	186	°C

Characteristics

Processing	Injection Moulding
Delivery form	Pellets
Additives	Release agent

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)

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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)
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.

Processing Notes

Pre-Drying

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 <-40°F (-40°C) at 250°F (121°C) for 4 hours.

Storage

For subsequent storage of the material in the dryer until processed (<= 60 h) it is necessary to lower the temperature to 100° C.

Automotive

OEM	STANDARD	ADDITIONAL INFORMATION
Continental	SN 57908-6	
General Motors	GMW16733P-PBT-GF15	N/A
Li Auto	Q/LiA5310038	2021 (V2)
Stellantis - Chrysler	MS.50103 / CPN-2425	Black

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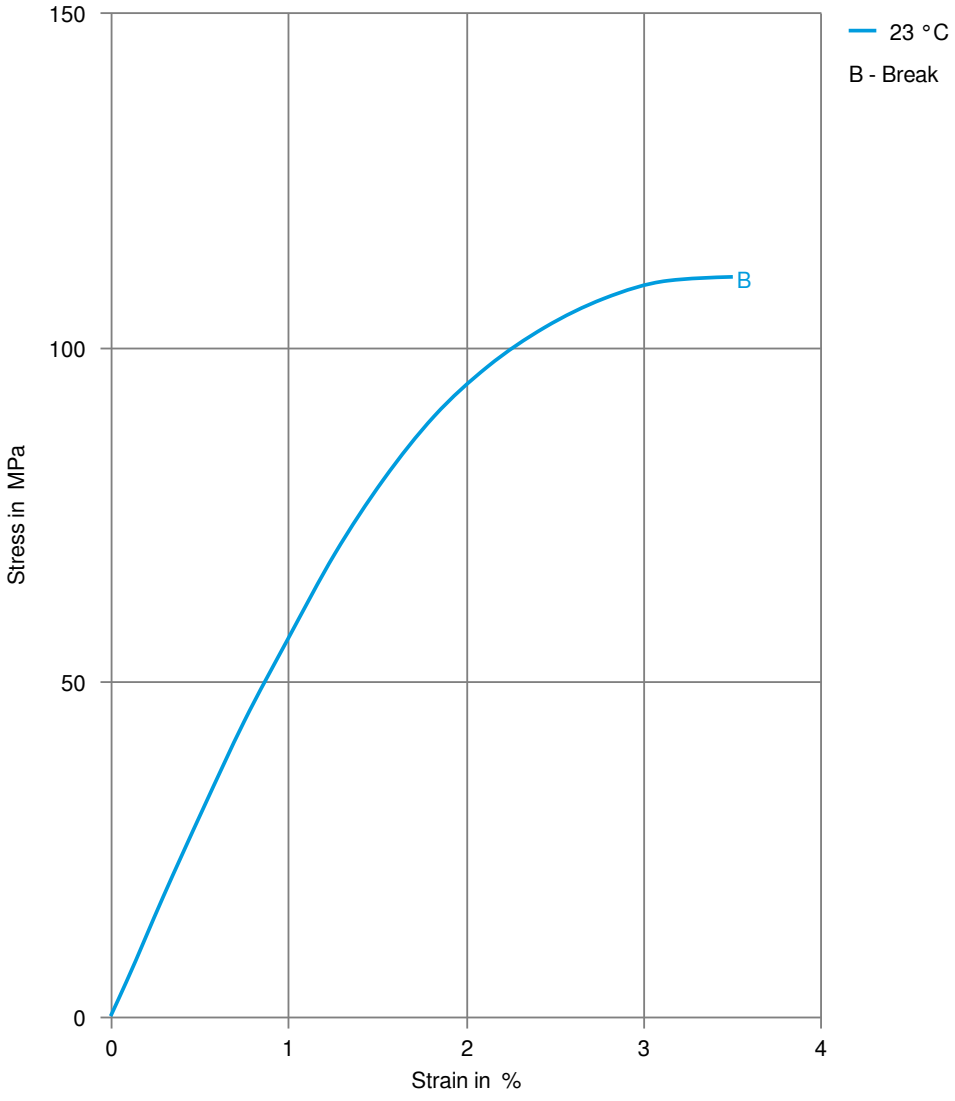
Stress-strain



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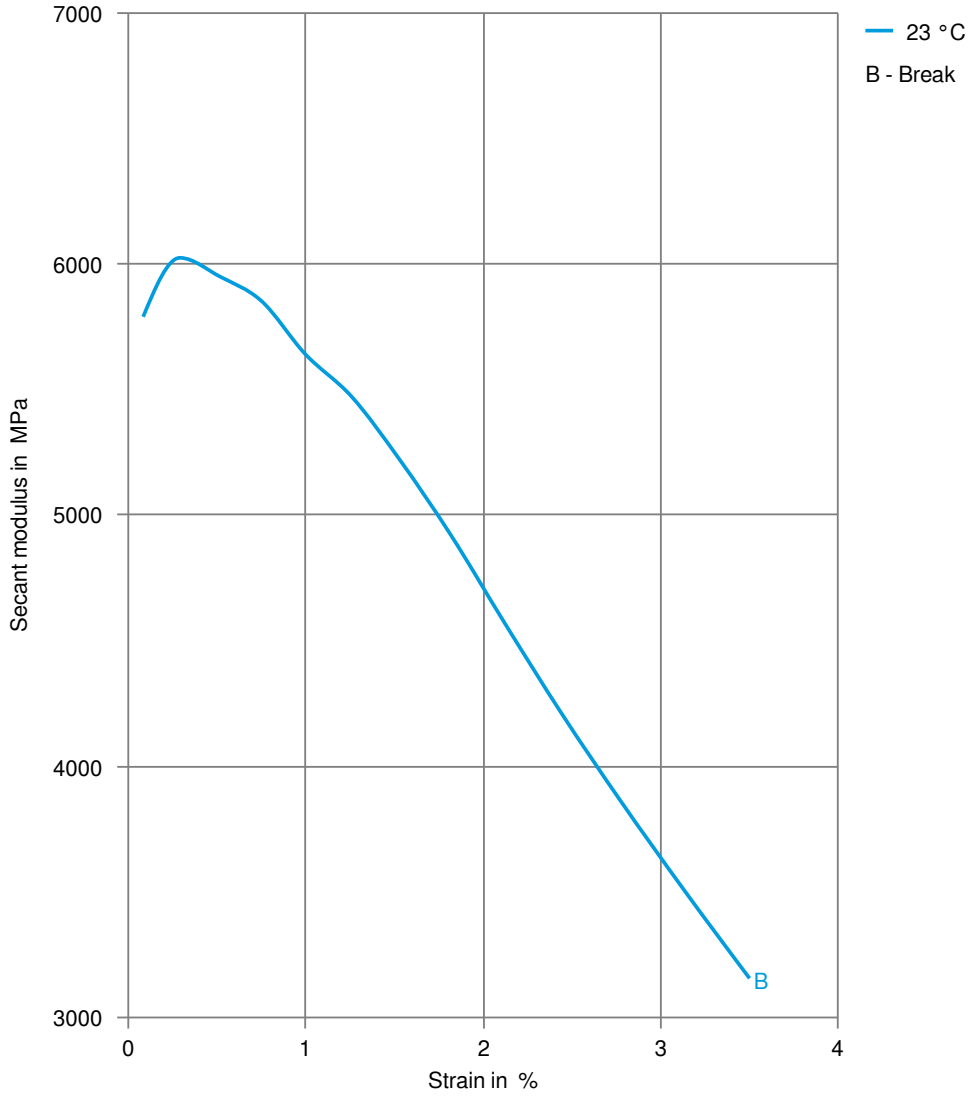
Secant modulus-strain



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