

CELANEX® 3209HR

CELANEX® PBT

Celanex 3209HR is a 15% glass filled PBT that has an excellent hydrolysis resistance, mechanical properties and processability. Celanex 3209HR is non-lubricated.

Product information

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

Rheological properties

Melt mass-flow rate	22 g/10min	ISO 1133
Melt mass-flow rate, Temperature	250 °C	
Melt mass-flow rate, Load	2.16 kg	
Moulding shrinkage, parallel	0.1 %	ISO 294-4, 2577
Moulding shrinkage, normal	0.9 %	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	5300 MPa	ISO 178
Flexural strength	150 MPa	ISO 178
Charpy impact strength, 23°C	22 kJ/m ²	ISO 179/1eU
Charpy impact strength, -30°C	22 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	4 kJ/m ²	ISO 179/1eA
Izod notched impact strength, 23°C	5.3 kJ/m ²	ISO 180/1A
Izod impact strength, 23°C	17 kJ/m ²	ISO 180/1U
Poisson's ratio	0.35 ^[C]	
Shore D hardness, 15s	82	ISO 48-4 / ISO 868

[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	180 °C	ISO 75-1/-2
Temperature of deflection under load, 0.45 MPa	220 °C	ISO 75-1/-2
Vicat softening temperature, 50°C/h 10N	220 °C	ISO 306
Coefficient of linear thermal expansion (CLTE), parallel	38 E-6/K	ISO 11359-1/-2
Coefficient of linear thermal expansion (CLTE), normal	100 E-6/K	ISO 11359-1/-2

Electrical properties

Relative permittivity, 100Hz	3.7	IEC 62631-2-1
Relative permittivity, 1MHz	2.9	IEC 62631-2-1
Dissipation factor, 1MHz	240 E-4	IEC 62631-2-1
Volume resistivity	4E14 Ohm.m	IEC 62631-3-1
Surface resistivity	2E16 Ohm	IEC 62631-3-2
Electric strength	17 kV/mm	IEC 60243-1

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Comparative tracking index	325	IEC 60112
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Physical/Other properties

Humidity absorption, 2mm	0.17 %	Sim. to ISO 62
Density	1410 kg/m ³	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

Characteristics

Processing	Injection Moulding
Delivery form	Pellets
Special characteristics	Hydrolysis resistant

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)
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

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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.

Automotive

OEM
Li Auto

STANDARD
Q/LiA5310038

ADDITIONAL INFORMATION
2021 (V2)