

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
^[C] Melt volume-flow rate, MVR	22	cm ³ /10min	ISO 1133
Temperature	265	°C	-
Load	2.16	kg	-
^[C] Molding shrinkage, parallel	0.3	%	ISO 294-4, 2577
^[C] Molding shrinkage, normal	0.7	%	ISO 294-4, 2577

[C]: CAMPUS

Mechanical properties	Value	Unit	Test Standard
ISO Data			
^[C] Tensile Modulus	12500	MPa	ISO 527
^[C] Stress at break	135	MPa	ISO 527
^[C] Strain at break	3.4	%	ISO 527
^[C] Charpy impact strength, +23°C	50	kJ/m ²	ISO 179/1eU
^[C] Charpy notched impact strength, +23°C	5	kJ/m ²	ISO 179/1eA
^[C] Charpy notched impact strength, -30°C	3.7	kJ/m ²	ISO 179/1eA

[C]: CAMPUS

Thermal properties	Value	Unit	Test Standard
ISO Data			
^[C] Melting temperature, 10°C/min	255	°C	ISO 11357-1/-3
^[C] Temp. of deflection under load, 8.00 MPa	65	°C	ISO 75-1/-2
^[C] Coeff. of linear therm. expansion, parallel	14	E-6/K	ISO 11359-1/-2
^[C] Coeff. of linear therm. expansion, normal	11	E-6/K	ISO 11359-1/-2

[C]: CAMPUS

Electrical properties	Value	Unit	Test Standard
ISO Data			
^[C] Volume resistivity	200	Ohm*m	IEC 62631-3-1
^[C] Surface resistivity	70000	Ohm	IEC 62631-3-2

[C]: CAMPUS

Other properties	Value	Unit	Test Standard
^[C] Water absorption	0.45	%	Sim. to ISO 62
^[C] Humidity absorption	0.15	%	Sim. to ISO 62
^[C] Density	1380	kg/m ³	ISO 1183

[C]: CAMPUS

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	120 - 140	°C	-
Pre-drying - Time	2 - 4	h	-
Processing humidity	≤0.02	%	-
Melt temperature	265 - 275	°C	-
Mold temperature	90 - 100	°C	-

Characteristics

Processing

Injection Molding

Delivery form

Pellets

Special Characteristics

Increased electrical conductivity, Heat stabilized or stable to heat

Regional Availability

Europe

Additives

Release agent

Other text information**Injection molding**

To avoid hydrolytic degradation during processing, CELANEX resins have to be dried to a moisture level equal to or less than 0,02%. The drying should be done in a dry-air dryer (dew point < -30°C) with a temperature of 120 to 140 °C and a drying time of 2 to 4 hours. In case of longer residence times in the dry-air dryer, the temperature should be reduced to 100°C.

The time between drying and processing should be kept as short as possible. The processing machine feed hopper should be closed during the processing operation.

Melt Temperature 265-275 °C

Mold Temperature *) 90-100 °C

Maximum Barrel Residence Time **) 5-10 min

Injection Speed fast

Peripheral screw speed max.0,3 m/sec

Back Pressure 10-30 bar

Injection Pressure 600-1000 bar

Holding Pressure 400-800 bar

Nozzle Design open design preferred

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.

Celanese recommends only externally heated hot runner systems.

*) For moulded parts with especially high requirements to the surface quality or dimensional stability, a mold temperature of up to 110 °C can be advantageous.

**) If the cylinder temperatures are higher than the recommended maximum temperatures, the max. residence time in the barrel has to be reduced.