

Product Texts

Celanex 3400-2 is a general purpose, 40% glass reinforced polybutylene terephthalate that offers a good combination of mechanical, electrical, and thermal properties. This grade provides outstanding processability and good chemical resistance. Celanex 3400-2 is a high flow material.

Flammability at thickness h (0.71 HB mm)

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
^[C] Molding shrinkage, parallel	0.4	%	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	12100	MPa	ISO 527
^[C] Stress at break	140	MPa	ISO 527
^[C] Strain at break	2.4	%	ISO 527
^[C] Charpy impact strength, +23°C	47	kJ/m ²	ISO 179/1eU
^[C] Charpy impact strength, -30°C	45	kJ/m ²	ISO 179/1eU
^[C] Charpy notched impact strength, +23°C	11	kJ/m ²	ISO 179/1eA
^[C] Charpy notched impact strength, -30°C	9.5	kJ/m ²	ISO 179/1eA
^[C] Shore D hardness	85	-	ISO 7619-1

[C]: CAMPUS

Thermal properties	Value	Unit	Test Standard
ISO Data			
^[C] Melting temperature, 10°C/min	225	°C	ISO 11357-1/-3
^[C] Glass transition temperature, 10°C/min	45	°C	ISO 11357-1/-2
^[C] Temp. of deflection under load, 1.80 MPa	212	°C	ISO 75-1/-2
^[C] Temp. of deflection under load, 0.45 MPa	225	°C	ISO 75-1/-2
^[C] Coeff. of linear therm. expansion, parallel	15	E-6/K	ISO 11359-1/-2
^[C] Coeff. of linear therm. expansion, normal	101	E-6/K	ISO 11359-1/-2
^[C] Burning Behav. at thickness h	HB	class	IEC 60695-11-10
Thickness tested	0.7	mm	-

[C]: CAMPUS

Electrical properties	Value	Unit	Test Standard
ISO Data			
^[C] Relative permittivity, 100Hz	3.5	-	IEC 62631-2-1
^[C] Relative permittivity, 1MHz	3.4	-	IEC 62631-2-1
^[C] Dissipation factor, 1MHz	130	E-4	IEC 62631-2-1
^[C] Volume resistivity	1E13	Ohm*m	IEC 62631-3-1
^[C] Surface resistivity	1E15	Ohm	IEC 62631-3-2
^[C] Electric strength	19	kV/mm	IEC 60243-1

[C]: CAMPUS

Other properties	Value	Unit	Test Standard
^[C] Water absorption	0.05	%	Sim. to ISO 62
^[C] Humidity absorption	0.15	%	Sim. to ISO 62
^[C] Density	1610	kg/m ³	ISO 1183

[C]: CAMPUS

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	121	°C	-
Pre-drying - Time	4	h	-
Processing humidity	≤0.02	%	-
Melt temperature	235 - 260	°C	-
Mold temperature	65 - 93	°C	-

Characteristics

Processing

Injection Molding

Chemical Resistance

General Chemical Resistance

Delivery form

Pellets

Applications

General Purpose

Additives

Lubricants

Regional Availability

North America, Europe, Asia Pacific, South and Central America, Near East/Africa

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%. Drying should be done in a dehumidifying hopper dryer capable of dewpoints <-30°F (-34°C) at 250°F (121°C) for 4 hours.

- 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 the material has to be avoided, in particular for flame retardant grades. Up to 25% clean and dry regrind may be used.