CELSTRAN® PBT-GF40-08

PBT-GLF40 Celanese

Mechanical properties	Value	Unit	Test Standard
ISO Data			
[C] Tensile Modulus	**13600**	MPa	ISO 527
[C] Stress at break	**180**	MPa	ISO 527
[C] Strain at break	**1.85**	%	ISO 527
[C] Charpy notched impact strength, +23°C	**32**	kJ/m²	ISO 179/1eA

[C]: CAMPUS

Thermal properties	Value	Unit	Test Standard
ISO Data			
[C] Temp. of deflection under load, 1.80 MPa	**225**	°C	ISO 75-1/-2
[C] Temp. of deflection under load, 0.45 MPa	**226**	°C	ISO 75-1/-2
[C] Coeff. of linear therm. expansion, parallel	**16**	E-6/K	ISO 11359-1/-2
[C] Coeff. of linear therm. expansion, normal	**87**	E-6/K	ISO 11359-1/-2

[C]: CAMPUS

Other properties	Value	Unit	Test Standard
[C] Density	**1610**	kg/m³	ISO 1183

[C]: CAMPUS

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	**120**	°C	-
Pre-drying - Time	**4**	h	-
Melt temperature	**280 - 300**	°C	-
Mold temperature	**80 - 90**	°C	-

Characteristics

Processing
Injection Molding

Features
Long fiber reinforced

Delivery form
Pellets

Regional Availability
North America, Europe, Asia Pacific

Other text information

Injection molding

PBT Drying Requirements: 4 hrs. @ 120° C.
A dehumidifier or desiccant dryer is recommended.
Celstran can be processed on a standard injection molding unit.
A general purpose metering screw is recommended with a zone distribution of 40% feed, 40% transition, and 20% metering.
A free flowing check ring assembly is recommended.

Melt Temp.: 280 - 300° C.
Mold Temp.: 80 - 90° C.