

CELANEX® 3300SW1

PBT-GF30

Celanese

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
^[C] Molding shrinkage, parallel	0.4	%	ISO 294-4, 2577
^[C] Molding shrinkage, normal	0.8	%	ISO 294-4, 2577

[C]: CAMPUS

Mechanical properties	Value	Unit	Test Standard
ISO Data			
^[C] Tensile Modulus	9600	MPa	ISO 527
^[C] Stress at break	125	MPa	ISO 527
^[C] Strain at break	2.8	%	ISO 527
^[C] Charpy impact strength, +23°C	50	kJ/m ²	ISO 179/1eU
^[C] Charpy notched impact strength, +23°C	8	kJ/m ²	ISO 179/1eA

[C]: CAMPUS

Thermal properties	Value	Unit	Test Standard
ISO Data			
^[C] Melting temperature, 10°C/min	224	°C	ISO 11357-1/-3
^[C] Temp. of deflection under load, 1.80 MPa	212	°C	ISO 75-1/-2

[C]: CAMPUS

Other properties	Value	Unit	Test Standard
^[C] Density	1610	kg/m ³	ISO 1183

[C]: CAMPUS

Characteristics**Processing**

Injection Molding

Regional Availability

North America

Delivery form

Pellets

Other text information**Injection molding**

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.