

Product Texts

Celanex 3314 is a non-exuding (UL approved V-0 at 1/64 inch), 30% fiberglass reinforced polybutylene terephthalate which has an excellent balance of mechanical properties and processability. It is well suited for electrical connector applications.

Flammability at thickness h (0.39 V-0 mm)

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
^[C] Melt volume-flow rate, MVR	13	cm ³ /10min	ISO 1133
Temperature	250	°C	-
Load	2.16	kg	-
^[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	10000	MPa	ISO 527
^[C] Stress at break	136	MPa	ISO 527
^[C] Strain at break	2.6	%	ISO 527
^[C] Charpy impact strength, +23°C	52	kJ/m ²	ISO 179/1eU
^[C] Charpy impact strength, -30°C	14	kJ/m ²	ISO 179/1eU
^[C] Charpy notched impact strength, +23°C	7.9	kJ/m ²	ISO 179/1eA
^[C] Charpy notched impact strength, -30°C	7.3	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] Temp. of deflection under load, 1.80 MPa	210	°C	ISO 75-1/-2
^[C] Temp. of deflection under load, 0.45 MPa	220	°C	ISO 75-1/-2
^[C] Vicat softening temperature, B	225	°C	ISO 306
^[C] Coeff. of linear therm. expansion, parallel	20	E-6/K	ISO 11359-1/-2
^[C] Coeff. of linear therm. expansion, normal	75	E-6/K	ISO 11359-1/-2
^[C] Burning Behav. at thickness h	V-0	class	IEC 60695-11-10
Thickness tested	0.4	mm	-

[C]: CAMPUS

Electrical properties	Value	Unit	Test Standard
ISO Data			
^[C] Relative permittivity, 100Hz	2.8	-	IEC 62631-2-1
^[C] Relative permittivity, 1MHz	3.4	-	IEC 62631-2-1
^[C] Dissipation factor, 1MHz	140	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	33	kV/mm	IEC 60243-1

[C]: CAMPUS

Other properties	Value	Unit	Test Standard
^[C] Water absorption	0.5	%	Sim. to ISO 62
^[C] Humidity absorption	0.16	%	Sim. to ISO 62
^[C] Density	1670	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 - 255	°C	-
Mold temperature	65 - 93	°C	-

Characteristics

Processing

Injection Molding

Special Characteristics

Heat stabilized or stable to heat

Delivery form

Pellets

Applications

Electrical and Electronical

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%. 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 470-490(240-255) deg F (deg C)
- Nozzle Temperature 480-490(250-255) deg F (deg C)
- Melt Temperature 460-490(235-255) 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.