

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
^[C] Melt volume-flow rate, MVR	21	cm ³ /10min	ISO 1133
Temperature	250	°C	-
Load	2.16	kg	-
^[C] Molding shrinkage, parallel	1.9	%	ISO 294-4, 2577
^[C] Molding shrinkage, normal	1.8	%	ISO 294-4, 2577

[C]: CAMPUS

Mechanical properties	Value	Unit	Test Standard
ISO Data			
^[C] Tensile Modulus	2600	MPa	ISO 527
^[C] Yield stress	56	MPa	ISO 527
^[C] Yield strain	7	%	ISO 527
^[C] Nominal strain at break	19	%	ISO 527
^[C] Charpy notched impact strength, +23°C	3.3	kJ/m ²	ISO 179/1eA

[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	60	°C	ISO 11357-1/-2

[C]: CAMPUS

Other properties	Value	Unit	Test Standard
^[C] Humidity absorption	0.2	%	Sim. to ISO 62

[C]: CAMPUS

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	120	°C	-
Pre-drying - Time	4	h	-
Processing humidity	≤0.02	%	-
Melt temperature	235 - 260	°C	-
Mold temperature	65 - 93	°C	-

Characteristics

Processing

Injection Molding

Regional Availability

North America, Europe, Asia Pacific

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 <-40°F (-40°C) at 250°F (120°C) for minimum 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.