

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
^[C] Molding shrinkage, parallel	0.6	%	ISO 294-4, 2577
^[C] : CAMPUS			

Mechanical properties	Value	Unit	Test Standard
ISO Data			
^[C] Stress at break	115	MPa	ISO 527
^[C] Strain at break	3.2	%	ISO 527
^[C] : CAMPUS			

Thermal properties	Value	Unit	Test Standard
ISO Data			
^[C] Melting temperature, 10°C/min	225	°C	ISO 11357-1/-3
^[C] : CAMPUS			

Other properties	Value	Unit	Test Standard
^[C] Humidity absorption	0.1	%	Sim. to ISO 62
^[C] Density	1450	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

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 470-500(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.