

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
^[C] Melt volume-flow rate, MVR	0.8	cm ³ /10min	ISO 1133
Temperature	250	°C	-
Load	2.16	kg	-
^[C] Molding shrinkage, parallel	0.7	%	ISO 294-4, 2577
^[C] Molding shrinkage, normal	0.6	%	ISO 294-4, 2577

[C]: CAMPUS

Mechanical properties	Value	Unit	Test Standard
ISO Data			
^[C] Tensile Modulus	1981	MPa	ISO 527
^[C] Yield stress	47	MPa	ISO 527
^[C] Yield strain	4.9	%	ISO 527
^[C] Charpy impact strength, +23°C	N	kJ/m ²	ISO 179/1eU
^[C] Charpy notched impact strength, +23°C	17	kJ/m ²	ISO 179/1eA
^[C] Charpy notched impact strength, -30°C	9	kJ/m ²	ISO 179/1eA

[C]: CAMPUS

Thermal properties	Value	Unit	Test Standard
ISO Data			
^[C] Temp. of deflection under load, 1.80 MPa	94	°C	ISO 75-1/-2
^[C] Temp. of deflection under load, 0.45 MPa	105	°C	ISO 75-1/-2
^[C] Vicat softening temperature, B	113	°C	ISO 306

[C]: CAMPUS

Other properties	Value	Unit	Test Standard
^[C] Density	1280	kg/m ³	ISO 1183

[C]: CAMPUS

Characteristics

Processing

Injection Molding

Delivery form

Pellets

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 480-520(249-271) deg F (deg C)

Center Temperature 480-530(249-276) deg F (deg C)

Front Temperature 480-530(249-276) deg F (deg C)

Nozzle Temperature 480-530(249-276) deg F (deg C)

Melt Temperature 480-520(249-271) deg F (deg C)

Mold Temperature 80-180(27-82) deg F (deg C)

Back Pressure 50-100 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.