

CELANEX® 2300 GV1/10 | PBT | Glass Reinforced

Description

Chemical abbreviation according to ISO 1043-1: PBT
Moulding compound ISO 7792- PBT, MGHR, 08-050N, GF10

Polybutylene terephthalate , 10 % glass fibre reinforced.

Flammability UL 94 HB minimum thickness 1.2 mm.

Recognition by Underwriters Laboratories, USA (UL)

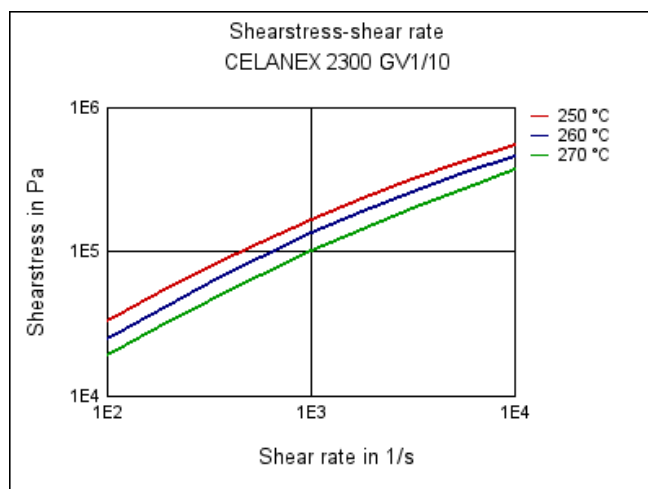
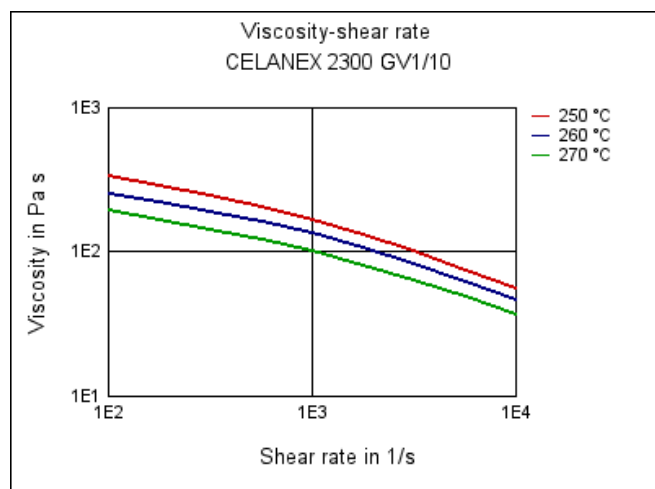
Physical properties	Value	Unit	Test Standard
Density	1380	kg/m ³	ISO 1183
Melt volume rate (MVR)	21	cm ³ /10min	ISO 1133
MVR test temperature	250	°C	ISO 1133
MVR test load	2.16	kg	ISO 1133
Humidity absorption (23°C/50%RH)	0.2	%	ISO 62
Mechanical properties	Value	Unit	Test Standard
Tensile modulus (1mm/min)	4700	MPa	ISO 527-2/1A
Tensile stress at break (5mm/min)	90	MPa	ISO 527-2/1A
Tensile strain at break (5mm/min)	3.5	%	ISO 527-2/1A
Tensile creep modulus (1h)	4600	MPa	ISO 899-1
Tensile creep modulus (1000h)	3500	MPa	ISO 899-1
Flexural strength (23°C)	130	MPa	ISO 178
Charpy impact strength @ 23°C	26	kJ/m ²	ISO 179/1eU
Charpy impact strength @ -30°C	26	kJ/m ²	ISO 179/1eU
Charpy notched impact strength @ 23°C	5	kJ/m ²	ISO 179/1eA
Charpy notched impact strength @ -30°C	5	kJ/m ²	ISO 179/1eA
Thermal properties	Value	Unit	Test Standard
Melting temperature (10°C/min)	225	°C	ISO 11357-1,-2,-3
DTUL @ 1.8 MPa	190	°C	ISO 75-1/-2
DTUL @ 0.45 MPa	210	°C	ISO 75-1/-2
DTUL @ 8.0 MPa	60	°C	ISO 75-1/-2
Vicat softening temperature B50 (50°C/h 50N)	205	°C	ISO 306
Coeff.of linear therm. expansion (parallel)	0.6	E-4/°C	ISO 11359-2
Limiting oxygen index (LOI)	19	%	ISO 4589
Flammability @1.6mm nom. thickn.	HB	class	UL94
thickness tested (1.6)	1.49	mm	UL94
UL recognition (1.6)	UL	-	UL94
Flammability at thickness h	HB	class	UL94
thickness tested (h)	1.22	mm	UL94
UL recognition (h)	UL	-	UL94
Electrical properties	Value	Unit	Test Standard
Relative permittivity - 100 Hz	4	-	IEC 60250
Relative permittivity - 1 MHz	3.9	-	IEC 60250
Dissipation factor - 100 Hz	13	E-4	IEC 60250
Dissipation factor - 1 MHz	190	E-4	IEC 60250

CELANEX® 2300 GV1/10 | PBT | Glass Reinforced

Electrical properties	Value	Unit	Test Standard
Volume resistivity	>1E13	Ohm*m	IEC 60093
Surface resistivity	>1E15	Ohm	IEC 60093
Electric strength	28	kV/mm	IEC 60243-1
Comparative tracking index CTI	325	-	IEC 60112

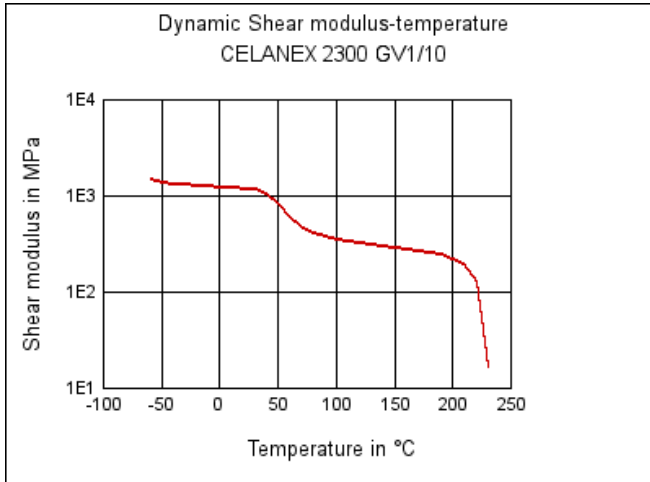
Test specimen production	Value	Unit	Test Standard
Processing conditions acc. ISO	7792	-	Internal
Injection molding melt temperature	265	°C	ISO 294
Injection molding mold temperature	80	°C	ISO 294
Injection molding flow front velocity	200	mm/s	ISO 294
Injection molding hold pressure	70	MPa	ISO 294

Rheological Calculation properties	Value	Unit	Test Standard
Density of melt	1170	kg/m³	Internal
Thermal conductivity of melt	0.144	W/(m K)	Internal
Specific heat capacity of melt	1870	J/(kg K)	Internal
Ejection temperature	219	°C	Internal

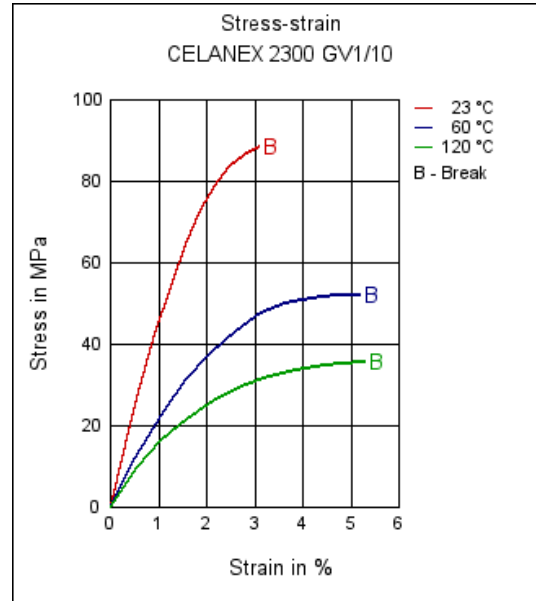
Viscosity-shear rate
Shearstress-shear rate


CELANEX® 2300 GV1/10 | PBT | Glass Reinforced

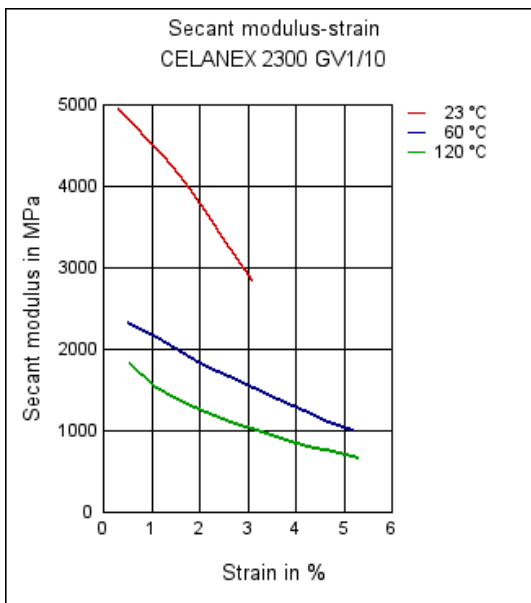
Dynamic Shear modulus-temperature



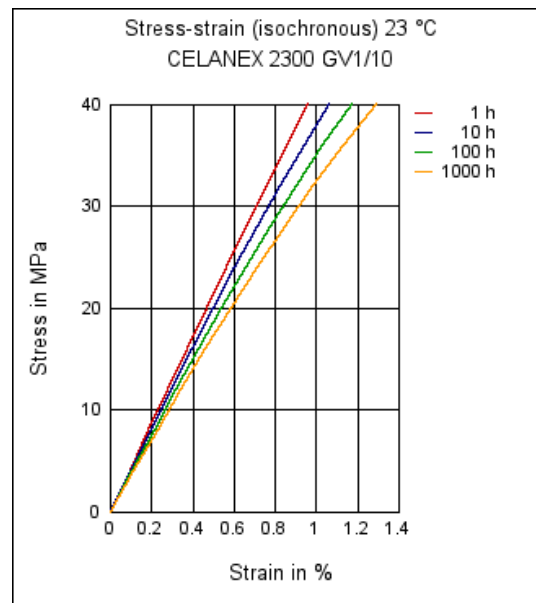
Stress-strain



Secant modulus-strain

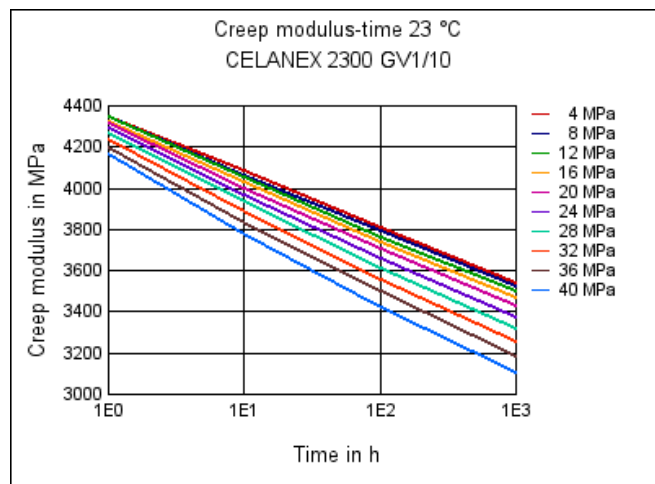


Stress-strain (isochronous)

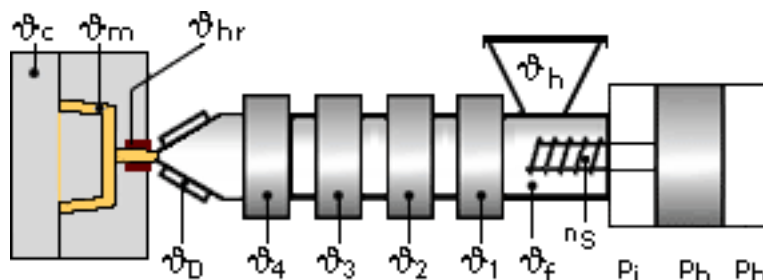


CELANEX® 2300 GV1/10 | PBT | Glass Reinforced

Creep modulus-time



Typical injection moulding processing conditions



Pre Drying:

Necessary low maximum residual moisture content: 0.02%

CELANEX should in principle be predried. Because of the necessary low maximum residual moisture content the use of dry air dryers is recommended. The dew point should be $\leq -30^{\circ}\text{C}$. The time between drying and processing should be as short as possible.

For subsequent storage of the material in the dryer until processed ($\leq 60\text{ h}$) it is necessary to lower the temperature to 100°C .

Drying time: 2 - 4 h

Drying temperature: 120 - 140 °C

Temperature:

	$\vartheta_{\text{Manifold}}$	ϑ_{Mold}	ϑ_{Melt}	$\vartheta_{\text{Nozzle}}$	ϑ_{Zone4}	ϑ_{Zone3}	ϑ_{Zone2}	ϑ_{Zone1}	ϑ_{Feed}	$\vartheta_{\text{Hopper}}$
min (°C)	260	75	260	260	255	255	250	250	190	20
max (°C)	270	100	270	270	265	265	260	260	200	50

CELANEX® 2300 GV1/10 | PBT | Glass Reinforced

Speed:**Injection speed: fast****Screw speed**

Screw diameter (mm)	16	25	40	55	75
Screw speed (RPM)	-	90	75	60	-

Injection Molding

Melt Temperature	260-270	°C
Mold Temperature *)	75-85	°C
Maximum Barrel Residence Time **)	5-10	min
Injection Speed	fast	
Peripheral screw speed	max. 0,3	m/sec
Back Pressure	10-30	bar
Injection Pressure	600-1000	bar
Holding Pressure	400-800	bar
Nozzle Design	open design preferred	

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. For grades containing flame retardants, a maximum temperature of 265 °C should not be exceeded.

Ticona recommends only externally heated hot runner systems.

*) For moulded parts with especially high requirements to the surface quality or dimensional stability, a mold temperature of up to 110 °C can be advantageous.

**) If the cylinder temperatures are higher than the recommended maximum temperatures, the max. residence time in the barrel has to be reduced.

Contact Information

Americas

8040 Dixie Highway, Florence, KY 41042 USA

Product Information Service

t: +1-800-833-4882 t: +1-859-372-3244

Customer Service

t: +1-800-526-4960 t: +1-859-372-3214

e: info-engineeredmaterials-am@celanese.com

Asia

4560 Jinke Road, Zhang Jiang Hi Tech Park

Shanghai 201203 PRC

Customer Service

t: +86 21 3861 9266 f: +86 21 3861 9599

e: info-engineeredmaterials-asia@celanese.com

Europa

Am Unisys-Park 1, 65843 Sulzbach, Germany

Product Information Service

t: +(00)-800-86427-531 t: +49-(0)-69-45009-1011

e: info-engineeredmaterials-eu@celanese.co

General Disclaimer

This publication was printed based on Celanese's present state of knowledge, and Celanese undertakes no obligation to update it. Because conditions of product use are outside Celanese's control, Celanese makes no warranties, express or implied, and assumes no liability in connection with any use of this information. Nothing herein is intended as a license to operate under or a recommendation to infringe any patents.

NOTICE TO USERS: Values shown are based on testing of laboratory test specimens and represent data that fall within the standard range of properties for natural material. These values alone do not represent a sufficient basis for any part design and are not intended for use in establishing maximum, minimum, or ranges of values for specification purposes. Colorants or other additives may cause significant variations in data values.

Properties of molded parts can be influenced by a wide variety of factors including, but not limited to, material selection, additives, part design, processing conditions and environmental exposure. Any determination of the suitability of a particular material and part design for any use contemplated by the users and the manner of such use is the sole responsibility of the users, who must assure themselves that the material as subsequently processed meets the needs of their particular product or use.

CELANEX® 2300 GV1/10 | PBT | Glass Reinforced

To the best of our knowledge, the information contained in this publication is accurate; however, we do not assume any liability whatsoever for the accuracy and completeness of such information. The information contained in this publication should not be construed as a promise or guarantee of specific properties of our products. It is the sole responsibility of the users to investigate whether any existing patents are infringed by the use of the materials mentioned in this publication.

Moreover, there is a need to reduce human exposure to many materials to the lowest practical limits in view of possible adverse effects. To the extent that any hazards may have been mentioned in this publication, we neither suggest nor guarantee that such hazards are the only ones that exist. We recommend that persons intending to rely on any recommendation or to use any equipment, processing technique or material mentioned in this publication should satisfy themselves that they can meet all applicable safety and health standards.

We strongly recommend that users seek and adhere to the manufacturer's current instructions for handling each material they use, and entrust the handling of such material to adequately trained personnel only. Please call the telephone numbers listed (+49 (0) 69 30516299 for Europe, +1 859-372-3244 for the Americas and +86 21 3861 9266 for Asia) for additional technical information. Visit our web site for the appropriate Safety Data Sheets (SDS) before attempting to process our products. Feel free to call Customer Services for additional assistance.

The products mentioned herein are not intended for use in medical or dental implants.

© 2014 Celanese or its affiliates. All rights reserved. (Published 25.November.2014)

Celanese®, registered C-ball design and all other trademarks identified herein with ®, TM, SM, unless otherwise noted, are trademarks of Celanese or its affiliates. Fortron is a registered trademark of Fortron Industries LLC.