

Celanex® 3300-2LM

Polybutylene Terephthalate

Celanese Corporation

Message:

Celanex 3300-2LM is a 30% glass-filled PBT that is enhanced for improved laser marking graphics. It contains an internal lubricant for enhanced mold release. It is a lasermarkable grade available in black color to mark white. The grade is specially formulated to yield crisp marks when subjected to a Nd:YAG laser or equivalent operated at 1064nm or 532nm. Lasers operating in the UV region (355nm) may yield different results.

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 30% filler by weight		
Additive	Lubricant		
Features	Laser marking Lubrication		
RoHS Compliance	Contact manufacturer		
Appearance	Black		
Physical	Nominal Value	Unit	Test Method
Density	1.53	g/cm ³	ISO 1183
Molding Shrinkage - Flow	0.30 - 0.50	%	ISO 294-4
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (M-Scale)	90		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength			
Fracture, 23°C	134	MPa	ASTM D638
Fracture	130	MPa	ISO 527-2/1A/5
Tensile Elongation (Break, 23°C)	2.0	%	ASTM D638
Flexural Modulus (23°C)	9700	MPa	ISO 178
Flexural Stress (23°C)	210	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	7.5	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, annealed	228	°C	ASTM D648
1.8 MPa, not annealed	206	°C	ASTM D648
Flammability	Nominal Value	Unit	Test Method
Flame Rating	HB		UL 94
Injection	Nominal Value	Unit	Test Method
Suggested Max Regrind	25	%	
Hopper Temperature	20.0 - 50.0	°C	
Rear Temperature	230 - 240	°C	
Middle Temperature	235 - 250	°C	

Front Temperature	235 - 250	°C
Nozzle Temperature	250 - 260	°C
Processing (Melt) Temp	235 - 260	°C
Mold Temperature	65.0 - 93.0	°C
Injection Rate	Fast	
Back Pressure	0.00 - 0.345	MPa

Injection instructions

Manifold Temperature: 250 to 260°C Zone 4 Temperature: 240 to 260°C Feed Temperature: 230 to 240°C

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