

Celanex® 2002-3

Polybutylene Terephthalate

Celanese Corporation

Message:

Celanex 2002-3 is a general purpose, unreinforced polybutylene terephthalate with a good balance of mechanical properties and processability. Celanex 2002-3 is a medium flow material that contains an internal lubricant.

General Information			
Additive	Lubricant		
Features	Workability, good		
	Medium liquidity		
	Lubrication		
	General		
Uses	General		
RoHS Compliance	Contact manufacturer		
Physical	Nominal Value	Unit	Test Method
Density	1.31	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (250°C/2.16 kg)	20.0	cm ³ /10min	ISO 1133
Water Absorption (Equilibrium, 23°C, 50% RH)	0.25	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2500	MPa	ISO 527-2/1A/1
Tensile Stress (Yield)	60.0	MPa	ISO 527-2/1A/50
Tensile Strain			ISO 527-2/1A/50
Yield	4.0	%	ISO 527-2/1A/50
Fracture	> 50	%	ISO 527-2/1A/50
Flexural Modulus (23°C)	2500	MPa	ISO 178
Flexural Stress (23°C)	80.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-30°C	6.0	kJ/m ²	ISO 179/1eA
23°C	6.0	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength			ISO 179/1eU
-30°C	190	kJ/m ²	ISO 179/1eU
23°C	No Break		ISO 179/1eU
Notched Izod Impact			ISO 180/1A
-30°C	5.5	kJ/m ²	ISO 180/1A
23°C	5.5	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method

Heat Deflection Temperature			
0.45 MPa, not annealed	150	°C	ISO 75-2/B
1.8 MPa, not annealed	55.0	°C	ISO 75-2/A
Vicat Softening Temperature	190	°C	ISO 306/B50
Linear thermal expansion coefficient			ISO 11359-2
Flow	1.3E-4	cm/cm/°C	ISO 11359-2
Lateral	1.2E-4	cm/cm/°C	ISO 11359-2
Injection	Nominal Value	Unit	
Drying Temperature	120 - 130	°C	
Drying Time	4.0	hr	
Suggested Max Moisture	0.020	%	
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	Moderate-Fast		
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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