

Celanex® 3316HR

Polybutylene Terephthalate

Celanese Corporation

Message:

Celanex 3316HR is a flame retarded, hydrolysis resistant, 30% fiberglass reinforced polybutylene terephthalate which has an excellent balance of mechanical properties and processability.

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 30% filler by weight		
Additive	Flame retardancy		
Features	Workability, good		
	Hydrolysis resistance		
	Flame retardancy		
RoHS Compliance	Contact manufacturer		
Physical	Nominal Value	Unit	Test Method
Density	1.61	g/cm ³	ISO 1183
Molding Shrinkage			ISO 294-4
Vertical flow direction	0.80 - 1.3	%	ISO 294-4
Flow direction	0.10 - 0.80	%	ISO 294-4
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	9850	MPa	ISO 527-2/1A/1
Tensile Stress (Break)	115	MPa	ISO 527-2/1A/5
Tensile Strain (Break)	2.5	%	ISO 527-2/1A/5
Flexural Modulus (23°C)	8950	MPa	ISO 178
Flexural Stress (23°C)	175	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	8.5	kJ/m ²	ISO 179/1eA
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	202	°C	ISO 75-2/A
Melting Temperature ¹	225	°C	ISO 11357-3
Linear thermal expansion coefficient			ISO 11359-2
Flow	2.5E-5	cm/cm/°C	ISO 11359-2
Lateral	9.0E-5	cm/cm/°C	ISO 11359-2
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+15	ohms	IEC 60093
Volume Resistivity			
--	4.4E+16	ohms · cm	ASTM D257
--	1.0E+15	ohms · cm	IEC 60093
Relative Permittivity (1 MHz)	2.90		IEC 60250

Dissipation Factor (1 MHz)	0.015		IEC 60250
Comparative Tracking Index	250	V	IEC 60112, ASTM D3638
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.750 mm)	V-0		UL 94
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	240 - 255	°C	
Processing (Melt) Temp	235 - 255	°C	
Mold Temperature	65.0 - 96.0	°C	
Injection Rate	Moderate-Fast		
Injection instructions			
Manifold Temperature: 250 to 260°CZone 4 Temperature: 240 to 255°CFeed Temperature: 230 to 240°C			
NOTE			
1.	10°C/min		

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