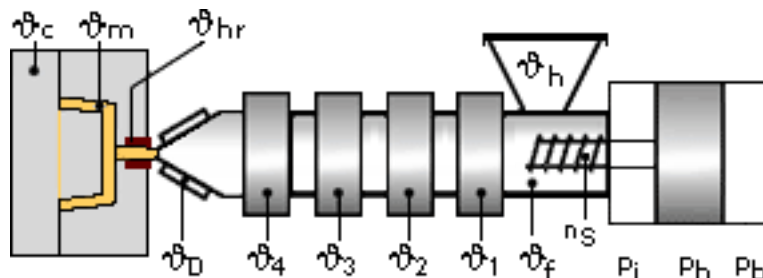


CELSTRAN® PBT-GF40-08 | PBT | Glass Reinforced

Description

40% Long Glass Fiber Reinforced PBT

Typical injection moulding processing conditions



Pre Drying:

CELSTRAN PBT 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

Drying time: 2 - 4 h

Drying temperature: 248 - 284 °F

Temperature:

	Feed	Hopper
min (°F)	68	68
max (°F)	122	122

Injection Molding

Celstran can be processed on a standard injection molding unit. A general purpose metering screw is recommended with a zone distribution of 40% feed, 40% transition, and 20% metering. A free flowing check ring assembly is recommended.

Melt Temp.: 280 - 300° C.

Mold Temp.: 80 - 90° C.

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

CELSTRAN® PBT-GF40-08 | PBT | Glass Reinforced

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

e: info-engineeredmaterials-eu@celanese.co

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