Celanex® 3202-2

Celanese Corporation - Polybutylene Terephthalate

Monday, November 4, 2019

General Information

Product Description

Celanex 3202-2 is a 20% glass-filled Polybutylene Terephthalate that has an excellent balance of mechanical properties and processability. It contains an internal lubricant for mold release.

General			
Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Filler / Reinforcement	• Glass Fiber, 20% Filler by Weight		
Additive	• Lubricant		
Features	• Good Mold Release	• Good Processability	• Lubricated
RoHS Compliance	• Contact Manufacturer		

ASTM & ISO Properties [1]

Physical	Nominal Value	Unit	Test Method
Density	1.45	g/cm³	ISO 1183
Melt Mass-Flow Rate (MFR) (250°C/2.16 kg)	22	g/10 min	ISO 1133
Molding Shrinkage - Flow	0.40 to 0.80	%	ISO 294-4
Water Absorption (Equilibrium, 73°F, 50% RH)	0.10	%	ISO 62
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Stress (Break)	16700	psi	ISO 527-2/1A/5
Tensile Strain (Break)	3.2	%	ISO 527-2/1A/5
Flexural Modulus (73°F)	986000	psi	ISO 178
Flexural Stress (73°F)	26100	psi	ISO 178
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact Strength (73°F)	3.3	ft·lb/in²	ISO 180/1A
Thermal	**Nominal Value**	**Unit**	**Test Method**
Melting Temperature [2]	437	°F	ISO 11357-3

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	248 to 266	°F
Drying Time	4.0	hr
Suggested Max Moisture	0.020	%
Suggested Max Regrind	25	%
Hopper Temperature	68 to 122	°F
Rear Temperature	446 to 464	°F
Middle Temperature	455 to 482	°F
Front Temperature	455 to 482	°F
Nozzle Temperature	482 to 500	°F
Processing (Melt) Temp	455 to 500	°F
Mold Temperature	149 to 199	°F
Injection Rate	Moderate-Fast	
Back Pressure	0.00 to 50.0	psi

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Injection Notes
Die Temperature: 250 to 260°C
Feed Temperature: 230 to 240°C
Zone 4 Temperature: 240 to 260°C

Notes

[1] Typical properties: these are not to be construed as specifications.

[2] 10°C/min