Celanex® 3314

Celanese Corporation - Polybutylene Terephthalate

Monday, November 4, 2019

General Information

Product Description

Celanex 3314 is a non-exuding (UL approved V-0 at 1/64 inch), 30% fiberglass reinforced polybutylene terephthalate which has an excellent balance of mechanical properties and processability. It is well suited for electrical connector applications.

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Filler / Reinforcement	• Glass Fiber, 30% Filler by Weight		
Features	• Good Processability	• Non-Exuding	
Uses	• Connectors		
RoHS Compliance	• Contact Manufacturer		

ASTM & ISO Properties [1]

Physical	Nominal Value	Unit	Test Method
Density	1.67	g/cm³	ISO 1183
Melt Mass-Flow Rate (MFR) (250°C/2.16 kg)	17	g/10 min	ISO 1133
Melt Volume-Flow Rate (MVR) (250°C/2.16 kg)	13	cm³/10min	ISO 1133
Molding Shrinkage			ISO 294-4
Across Flow	0.80	%	
Flow	0.30 to 0.50	%	
Water Absorption (Saturation, 73°F)	0.50	%	ISO 62
Water Absorption (Equilibrium, 73°F, 50% RH)	0.16	%	ISO 62
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	1.45E+6	psi	ISO 527-2/1A
Tensile Stress (Break)	19700	psi	ISO 527-2/1A/5
Tensile Strain (Break)	2.6	%	ISO 527-2/1A/5
Flexural Modulus (73°F)	1.45E+6	psi	ISO 178
Flexural Stress (73°F)	30500	psi	ISO 178
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Notched Impact Strength			ISO 179/1eA
-22°F	3.5	ft·lb/in²	
73°F	3.8	ft·lb/in²	
Charpy Unnotched Impact Strength			ISO 179/1eU
-22°F	6.7	ft·lb/in²	
73°F	25	ft·lb/in²	
Notched Izod Impact Strength			ISO 180/1A
-22°F	3.8	ft·lb/in²	
73°F	3.8	ft·lb/in²	
Hardness	**Nominal Value**	**Unit**	**Test Method**
Shore Hardness (Shore D, 15 sec)	85		ISO 868
Thermal	**Nominal Value**	**Unit**	**Test Method**
Heat Deflection Temperature (66 psi, Unannealed)	428	°F	ISO 75-2/B
Heat Deflection Temperature (264 psi, Unannealed)	410	°F	ISO 75-2/A

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Thermal	Nominal Value	Unit	Test Method
Vicat Softening Temperature	437	°F	ISO 306/B50
Melting Temperature [2]	437	°F	ISO 11357-3
CLTE - Flow	1.1E-5	in/in/°F	ISO 11359-2
CLTE - Transverse	4.2E-5	in/in/°F	ISO 11359-2
Electrical	**Nominal Value**	**Unit**	**Test Method**
Surface Resistivity	> 1.0E+17	ohms	IEC 60093
Volume Resistivity	> 1.0E+16	ohms·cm	IEC 60093
Electric Strength	840	V/mil	IEC 60243-1
Relative Permittivity			IEC 60250
100 Hz	2.80		
1 MHz	3.40		
Dissipation Factor (1 MHz)	0.014		IEC 60250
Comparative Tracking Index	200	V	IEC 60112
Flammability	**Nominal Value**	**Unit**	**Test Method**
Flame Rating (0.015 in)	V-0		UL 94

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	50	%
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 491	°F
Mold Temperature	149 to 199	°F
Injection Rate	Moderate-Fast	
Back Pressure	0.00 to 50.0	psi

Injection Notes

Die Temperature: 250 to 255°C
Feed Temperature: 230 to 240°C
Zone 4 Temperature: 240 to 255°C

Notes

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

[2] 10°C/min