

CELANEX® 2302UV GV1/30 - PBT

Description

30% glass filled PBT blend with good surface appearance and UV resistance

Physical properties	Value	Unit	Test Standard
Melt flow rate, MFR	25	g/10min	ISO 1133
MFR temperature	265	°C	ISO 1133
MFR load	2160	kg	ISO 1133

Mechanical properties	Value	Unit	Test Standard
Tensile modulus	11300	MPa	ISO 527-2/1A
Tensile stress at break, 5mm/min	140	MPa	ISO 527-2/1A
Tensile strain at break, 5mm/min	2.3	%	ISO 527-2/1A
Charpy notched impact strength, 23°C	8	kJ/m ²	ISO 179/1eA

Typical injection moulding processing conditions

Pre Drying	Value	Unit	Test Standard
Necessary low maximum residual moisture content	0.02	%	-
Drying time	2 - 4	h	-
Drying temperature	120 - 140	°C	-
Temperature	Value	Unit	Test Standard
Hopper temperature	20 - 50	°C	-
Feeding zone temperature	230 - 240	°C	-
Zone1 temperature	250 - 260	°C	-
Zone2 temperature	250 - 260	°C	-
Zone3 temperature	260 - 270	°C	-
Zone4 temperature	260 - 270	°C	-
Nozzle temperature	265 - 275	°C	-
Melt temperature	265 - 275	°C	-
Mold temperature	90 - 120	°C	-
Hot runner temperature	265 - 275	°C	-
Speed	Value	Unit	Test Standard
Injection speed	fast	-	-

