Celanese
The chemistry inside innovation™

CELANEX® 3300

30% glass-fiber reinforced, general purpose, high flow grade
Celanex 3300 is a general purpose, 30% glass reinforced, polybutylene terephthalate that offers a superior combination of mechanical, electrical, and thermal properties. This grade provides outstanding processability and good chemical resistance. Celanex 3300 is a high flow material.

Product information

Part Marking Code	> PBT-GF30 <	ISO 11469

Rheological properties

Melt volume-flow rate	13	cm^3/10min	ISO 1133
Melt mass-flow rate	17	g/10min	ISO 1133
Temperature	250	°C	
Load	2.16	kg	
Melt mass-flow rate, Temperature	250	°C	
Melt mass-flow rate, Load	2.16	kg	
Viscosity number	74	cm^3/g	ISO 307, 1157, 1628
Moulding shrinkage range, parallel	0.3 - 0.7	%	ISO 294-4, 2577
Moulding shrinkage range, normal	0.7 - 1.1	%	ISO 294-4, 2577

Typical mechanical properties

Tensile Modulus	10000	MPa	ISO 527-1/-2
Stress at break, 5mm/min	135	MPa	ISO 527-1/-2
Strain at break, 5mm/min	2.5	%	ISO 527-1/-2
Flexural Modulus	9700	MPa	ISO 178
Flexural Strength	210	MPa	ISO 178
Charpy impact strength, 23°C	46	kJ/m^2	ISO 179/1eU
Charpy impact strength, -30°C	45	kJ/m^2	ISO 179/1eU
Charpy notched impact strength, 23°C	8.5	kJ/m^2	ISO 179/1eA
Charpy notched impact strength, -30°C	8.5	kJ/m^2	ISO 179/1eA
Izod notched impact strength, 23°C	7.5	kJ/m^2	ISO 180/1A
Hardness, Rockwell, M-scale	90		ISO 2039-2
Poisson's ratio	0.43		
Shore D hardness, 15s	84		ISO 48-4 / ISO 868

Thermal properties

Melting temperature, 10°C/min	225	°C	ISO 11357-1/-3
Glass transition temperature, 10°C/min	60	°C	ISO 11357-1/-3
Temp. of deflection under load, 1.8 MPa	205	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	225	°C	ISO 75-1/-2
Temp. of deflection under load, 8 MPa	150	°C	ISO 75-1/-2
Vicat softening temperature, 50°C/h, 50N	220	°C	ISO 306
Coeff. of linear therm. expansion, parallel	25	E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal	100	E-6/K	ISO 11359-1/-2

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Flammability

Burning Behav. at thickness h	HB	class	UL 94
Thickness tested	0.71	mm	UL 94
Oxygen index	20	%	ISO 4589-1/-2

Electrical properties

Relative permittivity, 100Hz	4.5		IEC 62631-2-1
Relative permittivity, 1MHz	4.1		IEC 62631-2-1
Dissipation factor, 100Hz	22	E-4	IEC 62631-2-1
Dissipation factor, 1MHz	160	E-4	IEC 62631-2-1
Volume resistivity	>1E13	Ohm.m	IEC 62631-3-1
Surface resistivity	>1E15	Ohm	IEC 62631-3-2
Electric strength	31	kV/mm	IEC 60243-1
Comparative tracking index	PLC 1	PLC	UL 746A

Other properties

Humidity absorption, 2mm	0.16	%	Sim. to ISO 62
Water absorption, 2mm	0.4	%	Sim. to ISO 62
Density	1530	kg/m³	ISO 1183

VDA Properties

Emission of organic compounds	20	µgC/g	VDA 277

Injection

Drying Temperature	120 - 130	°C
Drying Time, Dehumidified Dryer	4	h
Processing Moisture Content	0.02	%
Max. mould temperature	65 - 93	°C
Injection speed	medium-fast	

Additional information

Injection molding

Rear Temperature 450-470(230-240) deg F (deg C)
Center Temperature 460-480(235-250) deg F (deg C)
Front Temperature 470-500(240-260) deg F (deg C)
Nozzle Temperature 480-500(250-260) deg F (deg C)
Melt Temperature 460-500(235-260) deg F (deg C)
Mold Temperature 150-200(65-93) deg F (deg C)
Back Pressure 0-50 psi
Screw Speed Medium
Injection Speed Fast

Injection speed, injection pressure and holding pressure have to be optimized to the individual article geometry. To avoid material degradation during processing low back pressure and minimum screw speed have to be used. Overheating of

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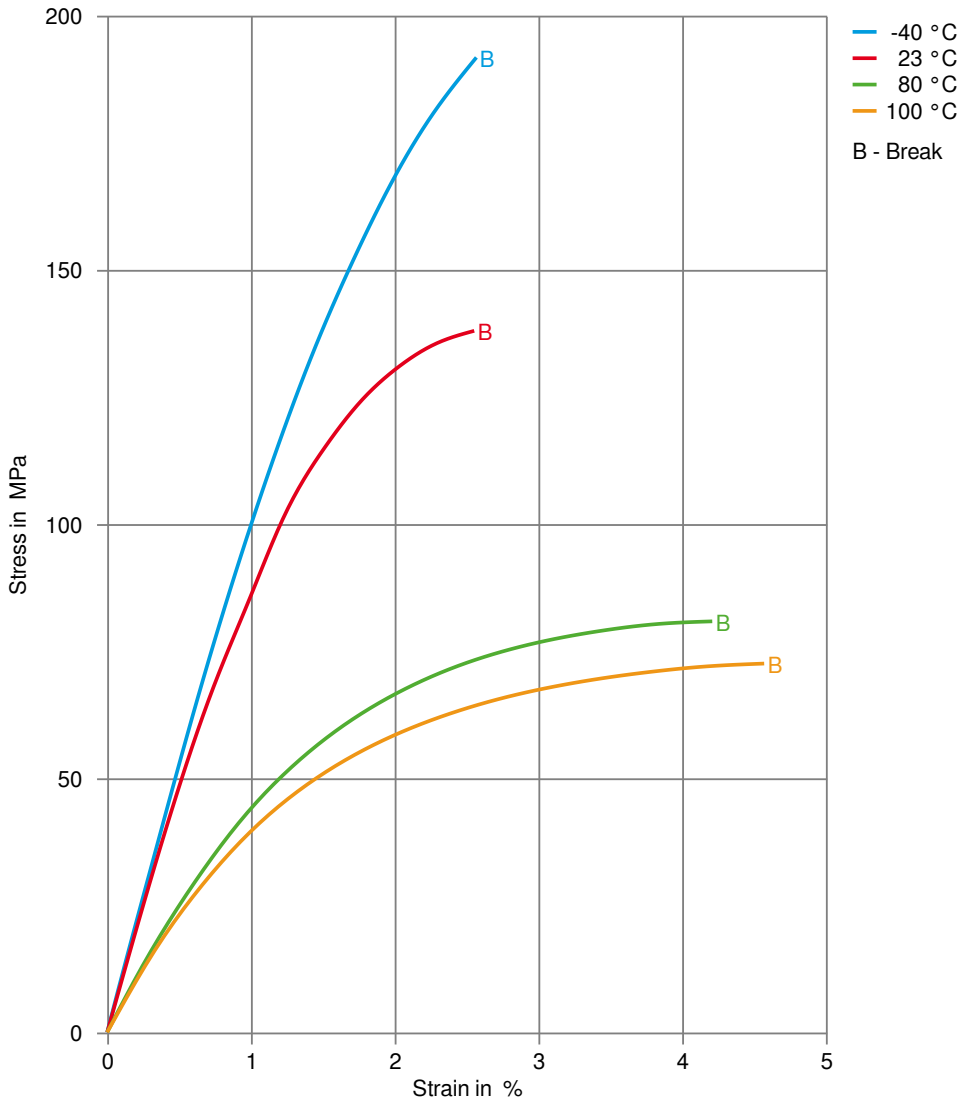
the material has to be avoided, in particular for flame retardant grades. Up to 25% clean and dry regrind may be used.

Stress-strain



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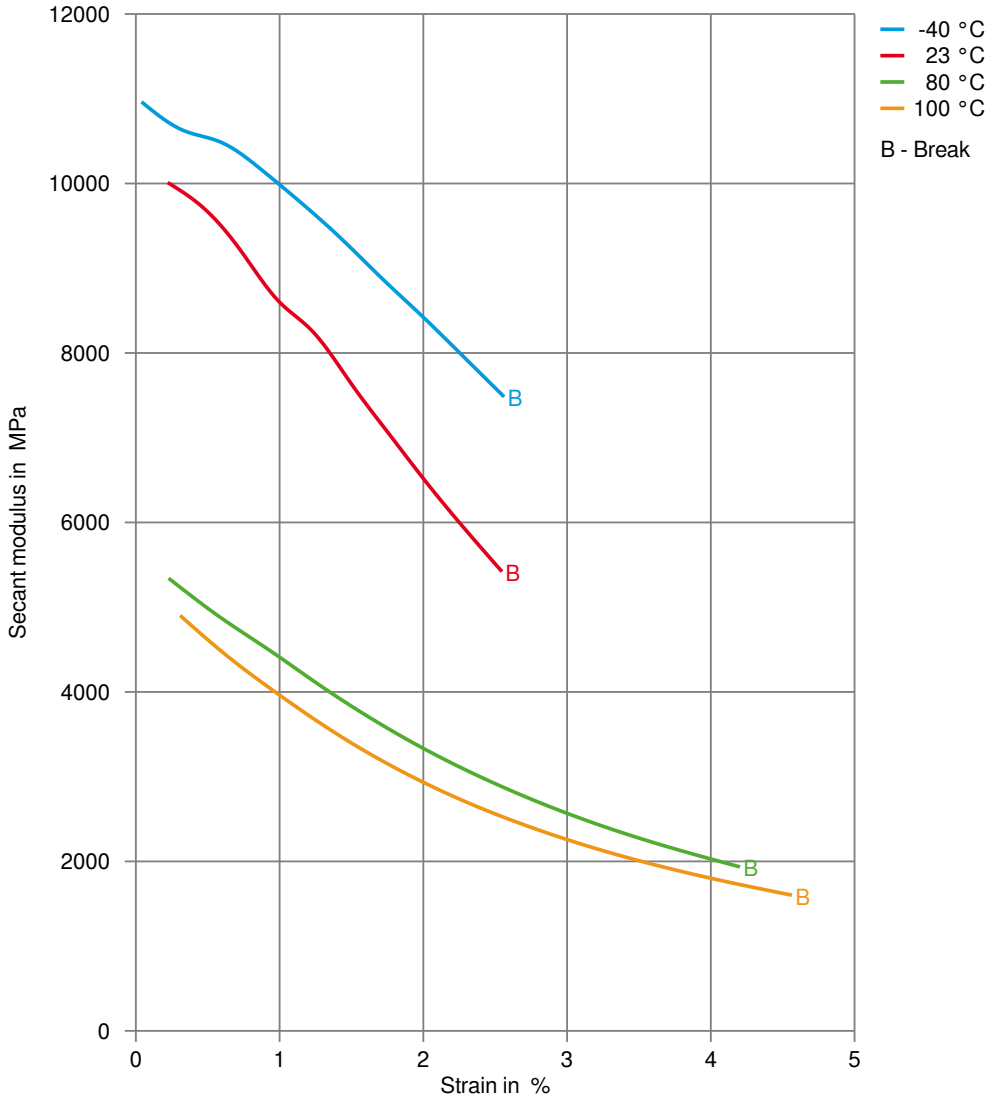
Secant modulus-strain



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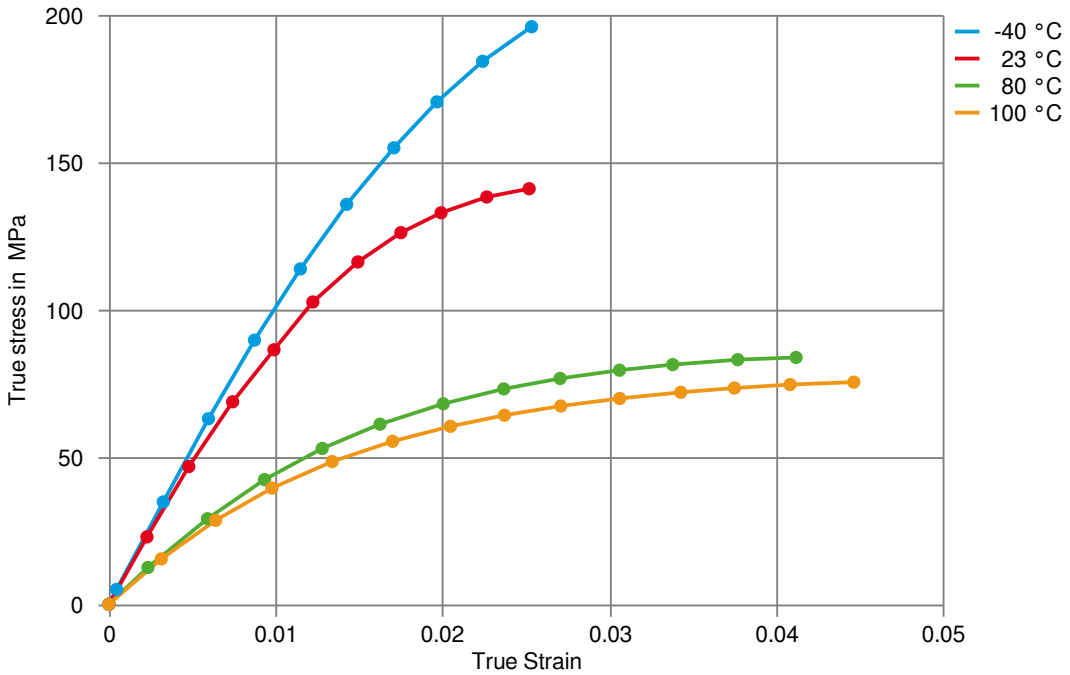
True stress-strain



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Processing Texts

Pre-drying	To avoid hydrolytic degradation during processing, CELANEX resins have to be dried to a moisture level equal to or less than 0.02%. Drying should be done in a dehumidifying hopper dryer capable of dewpoints <-40°F (-40°C) at 250°F (121°C) for 4 hours.
Longer pre-drying times/storage	For subsequent storage of the material in the dryer until processed (<= 60 h) it is necessary to lower the temperature to 100° C.
Injection molding	Rear Temperature 450-470(230-240) deg F (deg C) Center Temperature 460-480(235-250) deg F (deg C) Front Temperature 470-500(240-260) deg F (deg C) Nozzle Temperature 480-500(250-260) deg F (deg C) Melt Temperature 460-500(235-260) deg F (deg C) Mold Temperature 150-200(65-93) deg F (deg C) Back Pressure 0-50 psi Screw Speed Medium Injection Speed Fast Injection speed, injection pressure and holding pressure have to be optimized to the individual article geometry. To avoid material degradation during processing low back pressure and minimum screw speed have to be used. Overheating of the material has to be avoided, in particular for flame retardant grades. Up to 25% clean and dry regrind may be used.
Injection molding Preprocessing	To avoid hydrolytic degradation during processing, CELANEX resins have to be dried to a moisture level equal to or less than 0.02%. Drying should be done in a dehumidifying hopper dryer capable of dewpoints <-30°F (-34°C) at 250°F (121°C) for 4 hours.

Other Approvals

Other Approvals

OEM	Specification	Additional Information
Bosch	N28 BN07-GF028	Natural & Black
Stellantis - Chrysler	CPN 2252	Natural
Stellantis - Chrysler	CPN 3199	CANOD
Stellantis - Chrysler	CPN 4675	100% Color Match
Ford	WSS-M4D725-B1	
Ford	WSS-M4D929-A3	Natural
GM	GMW16733P-PBT-	Natural & Black

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