

CELANEX® DEV 3209HRHF (PRELIMINARY)

Rheological properties

Melt mass-flow rate	37 g/10min	ISO 1133
Melt mass-flow rate, Temperature	250 °C	
Melt mass-flow rate, Load	2.16 kg	
Moulding shrinkage range, parallel	0.5 %	ISO 294-4, 2577
Moulding shrinkage range, normal	1.3 %	ISO 294-4, 2577

Typical mechanical properties

Tensile Modulus	6406 MPa	ISO 527-1/-2
Stress at break, 5mm/min	116 MPa	ISO 527-1/-2
Strain at break, 5mm/min	3.1 %	ISO 527-1/-2
Flexural Modulus	5970 MPa	ISO 178
Flexural Strength	173 MPa	ISO 178
Charpy notched impact strength, 23°C	6.5 kJ/m ²	ISO 179/1eA
Charpy notched impact strength, -30 °C	6.5 kJ/m ²	ISO 179/1eA
Hardness, Rockwell, M-scale	88	ISO 2039-2

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	203 °C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	220 °C	ISO 75-1/-2
Coeff. of linear therm. expansion, parallel	40 E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal	120 E-6/K	ISO 11359-1/-2

Other properties

Humidity absorption, 2mm	<0.1 %	Sim. to ISO 62
Density	1410 kg/m ³	ISO 1183

Injection

Drying Temperature	120 °C
Drying Time, Dehumidified Dryer	4 - 8 h
Max. mould temperature	65 - 93 °C

