

CELEX™ 330AD Polycarbonate Resin

Overview

CELEX 330AD is a 30% glass fiber reinforced high flow polycarbonate resin. It is formulated with proprietary additive to improve the surface aesthetics. CELEX 330AD is designed with high flexural modulus, excellent toughness and superior processability for use in structural parts of printers, scanners, copiers as well as other business machines.

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density	1.43 g/cm ³	1.43 g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (256°C/3.8 kg)	12 g/10 min	12 g/10 min	ASTM D1238
Molding Shrinkage - Flow	2.0E-3 to 3.0E-3 in/in	0.20 to 0.30 %	ASTM D955
Mechanical	Nominal Value (English)	Nominal Value (SI)	Test Method
Tensile Strength			ASTM D638
Yield, 0.126 in (3.20 mm), Injection Molded	16400 psi	113 MPa	
Tensile Elongation			ASTM D638
Break, 0.126 in (3.20 mm), Injection Molded	3.5 %	3.5 %	
Flexural Modulus			ASTM D790
0.126 in (3.20 mm), Injection Molded	1.10E+6 psi	7580 MPa	
Flexural Strength			ASTM D790
0.126 in (3.20 mm), Injection Molded	24900 psi	172 MPa	
Impact	Nominal Value (English)	Nominal Value (SI)	Test Method
Notched Izod Impact			ASTM D256
73°F (23°C), 0.126 in (3.20 mm), Injection Molded	3.0 ft-lb/in	160 J/m	
Thermal	Nominal Value (English)	Nominal Value (SI)	Test Method
Deflection Temperature Under Load			ASTM D648
264 psi (1.8 MPa), Unannealed, 0.126 in (3.20 mm), Injection Molded	266 °F	130 °C	
Injection	Nominal Value (English)	Nominal Value (SI)	
Drying Temperature	248 °F	120 °C	
Drying Time	3.0 to 4.0 hr	3.0 to 4.0 hr	
Rear Temperature	482 to 491 °F	250 to 255 °C	
Middle Temperature	491 to 500 °F	255 to 260 °C	
Front Temperature	500 to 509 °F	260 to 265 °C	
Nozzle Temperature	509 to 518 °F	265 to 270 °C	
Mold Temperature	140 to 212 °F	60 to 100 °C	