

Keplex® 3300M

Polybutylene Terephthalate

Korea Engineering Plastics Co., Ltd

Message:

KEPEX 3300M is a non-reinforced and mold-releasing PBT grade.
It has easy mold-releasing characteristics and superior dimensional stability.
It is suitable for precision injection molding parts.

General Information			
Features	Good dimensional stability		
	Good demoulding performance		
RoHS Compliance	RoHS compliance		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.33	g/cm ³	ISO 1183
shrinkage-Flow (3.00 mm)	2.1	%	Internal method
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	118		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress	63.0	MPa	ISO 527-2
Tensile Strain (Break)	15	%	ISO 527-2
Flexural Modulus	2800	MPa	ISO 178
Flexural Stress	94.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	3.9	kJ/m ²	ISO 179/1eA
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	68.0	°C	ISO 75-2/A
Melting Temperature ¹	220	°C	ISO 11357-3
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+16	ohms · cm	IEC 60093
Dielectric Strength	18	kV/mm	IEC 60243-1
Dielectric Constant (60 Hz)	3.00		ASTM D150
Dissipation Factor (60 Hz)	2.0E-3		ASTM D150
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.8 mm)	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	120 - 130	°C	
Drying Time	3.0 - 5.0	hr	

Suggested Max Moisture	0.050	%
Hopper Temperature	60 - 80	°C
Rear Temperature	230	°C
Middle Temperature	240	°C
Front Temperature	240	°C
Nozzle Temperature	250	°C
Mold Temperature	70 - 90	°C
Back Pressure	0.490 - 0.981	MPa
Screw Speed	80 - 120	rpm

NOTE

1. 10°C/min

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