

Celanex® 3216HR

Polybutylene Terephthalate

Celanese Corporation

Message:

Celanex 3216HR is a flame retarded, hydrolysis resistant, 15% fiberglass reinforced polybutylene terephthalate which has an excellent balance of mechanical properties and processability.

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 15% filler by weight		
Additive	Flame retardancy		
Features	Workability, good		
	Hydrolysis resistance		
	Flame retardancy		
RoHS Compliance	Contact manufacturer		
Physical	Nominal Value	Unit	Test Method
Density	1.51	g/cm ³	ISO 1183
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	6000	MPa	ISO 527-2/1A/1
Tensile Stress (Break)	80.0	MPa	ISO 527-2/1A/5
Tensile Strain (Break)	4.2	%	ISO 527-2/1A/5
Flexural Modulus (23°C)	5300	MPa	ISO 178
Flexural Stress (23°C)	140	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Unnotched Impact Strength (23°C)	8.0	kJ/m ²	ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	152	°C	ISO 75-2/A
Melting Temperature ¹	225	°C	ISO 11357-3
Flammability	Nominal Value	Test Method	
Flame Rating (0.800 mm)	V-0	UL 94	
Injection	Nominal Value	Unit	
Drying Temperature	120 - 130	°C	
Drying Time	4.0	hr	
Suggested Max Moisture	0.020	%	
Hopper Temperature	20.0 - 50.0	°C	
Rear Temperature	230 - 240	°C	
Middle Temperature	235 - 250	°C	
Front Temperature	235 - 250	°C	
Nozzle Temperature	240 - 255	°C	
Processing (Melt) Temp	235 - 255	°C	

Mold Temperature	65.0 - 96.0	°C
Injection Rate	Moderate-Fast	
Injection instructions		
Manifold Temperature: 250 to 260°CZone 4 Temperature: 240 to 255°CFeed Temperature: 230 to 240°C		
NOTE		
1.	10°C/min	

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