



Celanex® 733LD

Celanese Corporation - Polybutylene Terephthalate Alloy

Monday, October 21, 2019

General Information

Product Description

Celanex 733LD is a 30% glass-filled PBT alloy that exhibits low warp characteristics. Celanex 733LD is well suited for electrical connectors.

General

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Fiber, 30% Filler by Weight
Features	• Low Warpage
Uses	• Connectors
RoHS Compliance	• Contact Manufacturer

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.43	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (250°C/2.16 kg)	7.9	g/10 min	ISO 1133
Molding Shrinkage			ISO 294-4
Across Flow	0.50 to 0.70	%	
Flow	0.10 to 0.30	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	10700	MPa	ISO 527-2/1A
Tensile Stress (Break)	140	MPa	ISO 527-2/1A/5
Tensile Strain (Break)	2.0	%	ISO 527-2/1A/5
Flexural Modulus (23°C)	10400	MPa	ISO 178
Flexural Stress (23°C)	200	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	7.2	kJ/m ²	ISO 179/1eA
Notched Izod Impact Strength (23°C)	7.0	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (0.45 MPa, Unannealed)	217	°C	ISO 75-2/B
Heat Deflection Temperature (1.8 MPa, Unannealed)	184	°C	ISO 75-2/A
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+16	ohms-cm	IEC 60093
Electric Strength	18	kV/mm	IEC 60243-1
Arc Resistance	93.0	sec	Internal Method
Comparative Tracking Index	200	V	IEC 60112

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	121	°C
Drying Time	4.0	hr
Suggested Max Moisture	0.020	%
Rear Temperature	230 to 250	°C
Middle Temperature	235 to 255	°C
Front Temperature	240 to 260	°C

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Injection	Nominal Value	Unit
Nozzle Temperature	250 to 265	°C
Processing (Melt) Temp	235 to 265	°C
Mold Temperature	65 to 93	°C
Injection Rate	Fast	
Back Pressure	0.00 to 0.345	MPa

Notes

¹ Typical properties: these are not to be construed as specifications.