



VYPET 6130

PBT 30% fiberglass Reinforced Resin

Vypet 6130 is a 30% fiberglass reinforced, toughened PBT injection molding compound designed for structural and electrical applications.

Features

- High temperature performances
- Excellent dimensional stability

Typical Applications

- Appliances handles
- Spotlight
- Electrical components

Typical Resin Properties ^(a)	ASTM Method	Typical values
Density at 23°C, g/cm ³	D792	1.53
Izod, notched, 23°C, J/m	D256	90
Tensile Strength @Yield (5mm/min), MPa	D638	148
Elongation @ Break (5mm/min), %	D638	4.4
Flexural Strength (1.3mm/min), MPa	D790	240
Flexural Modulus (1.3mm/min), MPa	D790	8 755
HDT, @ 1820 Kpa, °C	D648	217

(a) The property values are based on a limited number of tests and, therefore, should not be construed as product specifications.

Processing Guidelines

Drying

The Vypet 6130 grade process easily but must be thoroughly dried before molding, preferably in a dehumidifying desiccant hopper dryer, operating with an air flow rate of min1.0 CFM/lb, dew point of -18°C (-40°F) or lower. The material should be dried at 127°C (260.6° F) for 2-4 hours and the humidity content of the material should be maintained below 0.02% during molding.

Molding

Vypet products have a relatively wide processing window with barrel temperature settings as following:

- Feed zone: 227-243°C (440-470°F)
- Middle zone: 232-249°C (450-480°F)
- Front zone: 238-260°C (460-500°F)
- Nozzle: 238-254°C (460-490°F)
- Melt temperature: 243-260°C (470-500°F)
- Mold temperature: 71-88°C(160-190°F)

Other Molding Parameters

- Injection Pressure: 55-117MPa (8000-12000 psi)
- Injection Speed: Medium - fast
- Back Pressure: Low
- Screw Speed: 60-90 rpm



ISO 17025



Conseil canadien des normes
Standards Council of Canada

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8800, Crescent 1 Ville d'Anjou, (Québec) Canada H1J 1C8

Tel. : 514-354-5757 Fax. : 514-354- 3087 Email : lavergne@lavergne.ca

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