



# VYPET VNT 1020

## *Polyester/PC alloy*

Vypet 1020 Black, medium viscosity Polyester and PC alloy, has an excellent balance of stiffness and impact resistance.

### Features

- Excellent Processability
- Good Impact Resistance
- Good Chemical Resistance

### Typical Applications

- Automotive
- Industrial

Typical Resin Properties <sup>(a)</sup>	ASTM Method	Typical values
Specific gravity, 23°C, g/cm <sup>3</sup>	D792	1.19
Melt flow Rate (265°C/5kg), g/10min	D1238	25
Izod, notched, 23°C, J/m	D256	520
Tensile Strength @ break, (50mm/min), MPa	D638	45
Flexural Modulus (1.3mm/min), MPa	D790	2100
HDT, @ 1820 Kpa, °C	D648	95

(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 1020 grades process easily but must be thoroughly dried before molding, preferably in a dehumidifying desiccant hopper dryer, operating with an air flow rate of min 1.0 CFM/lb, dew point of -18°C or lower. The material should be dried at 99°C (210°F) for 4 hours and the humidity content of the material should be maintained below 0.02% during molding.

### Molding

Vypet 1020 products have a relatively wide processing window with barrel temperature settings as following:

- Feed zone: 243-254°C (470-490°F)
- Middle zone: 249-260°C (480-500°F)
- Front zone: 254-266°C (490-510°F)
- Nozzle: 257-268°C (495-515°F)
- Melt temperature: 260-277°C (500-530°F)
- Mold temperature: 18-74°C (65-165°F)

### Other Molding Parameters

- Injection Pressure: 10 000 - 20 000 psi
- Injection Speed: Slow to moderate
- Screw Speed: 50-75 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](mailto:lavergne@lavergne.ca)

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