



VYPET 2115

Polyester Alloy resin, 15% fiberglass Reinforced

Vypet 2115 is a 15% fiberglass reinforced, Modified 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	1.42
Izod, notched, 23°C, J/m	D256	58
Tensile Strength @Yield (5mm/min), MPa	D638	110
Elongation @ Break (5mm/min), %	D638	4
Flexural Strength (1.3mm/min), MPa	D790	170
Flexural Modulus (1.3mm/min), MPa	D790	5355
HDT, @ 1820 Kpa, °C	D648	198

(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 2115 grade 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 (-40°F) or lower. The material should be dried at 120°C (250°F) for 2-4 hours and the humidity content of the material should be maintained below 0.02% during molding.

Molding

Vypet 2115 resin has a relatively wide processing window with barrel temperature settings as following:

- Feed zone: 245-260°C (470-500°F)
- Middle zone: 250-265°C (480-510°F)
- Front zone: 255-270°C (490-520°F)
- Nozzle: 260-270°C (500-520°F)
- Melt temperature: 255-270°C (490-520°F)
- Mold temperature: 65-90°C (150-195°F)

Other Molding Parameters

- Injection Pressure: low
- Injection Speed: Medium - fast
- Back Pressure: Low
- Screw Speed: slow



ISO 17025



Conseil canadien des normes
Standards Council of Canada

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