



VYPET 2130-FR

Polyester Alloy 30% Glass Reinforced V-0 flame retardant grade

The Vypet 2130-FR is a Modified PBT 30% glass reinforced V-0 flame retardant injection molding compound designed for electrical applications

Features

- High temperature performance
- Excellent dimensional stability
- Excellent strength and stiffness

Typical Applications

- Electric motors
- Connectors

Typical Resin Properties ^(a)	Test Method	Typical values
Density @ 23°C (73°F), g/cm ³	ISO 1183	1.65
Tensile strength @ break (5mm/min), MPa	ISO 527-1,2	130
Elongation @ break (5mm/min), %	ISO 527-1,2	3
Flexural Strength (2 mm/min), MPa	ISO 178	200
Flexural Modulus (2 mm/min), MPa	ISO 178	10, 500
Izod notched, 23°C, kJ/m ²	ISO 179/1 A	7
HDT @ 18 MPa, °C	ISO 75	205
Flammability	UL94	V0

(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 2130FR 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 2130FR 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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