



# VYPET 2430

**Polyester Alloy resin, 30% fiberglass Reinforced, Impact Modified**

The Vypet 2430 is a Modified PBT 30% fiberglass reinforced, impact modified 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 <sup>(a)</sup> | ASTM Method | Typical values |
|-----------------------------------------|-------------|----------------|
| Density at 23°C, g/cm <sup>3</sup>      | D792        | 1.47           |
| Izod, notched, 23°C, J/m                | D256        | 132            |
| Tensile Strength @Yield (5mm/min), MPa  | D638        | 120            |
| Elongation @ Break (5mm/min), %         | D638        | 4.5            |
| Flexural Strength (1.3mm/min), MPa      | D790        | 203            |
| Flexural Modulus (1.3mm/min), MPa       | D790        | 7360           |
| HDT, @ 1820 Kpa, °C                     | D648        | 205            |

(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 2430 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 2430 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  
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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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