



VYPET 6115

PBT 15% fiberglass Reinforced Resin

The Vypet 6115 is a 15% fiberglass reinforced 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	1.4
Izod, notched, 23°C, J/m	D256	54
Tensile Strength @Yield (5mm/min), Mpa	D638	103
Elongation @ Break (5mm/min), %	D638	4.4
Flexural Strength, (1.3mm/min), MPa	D790	174
Flexural Modulus, (1.3mm/min), MPa	D790	5409
HDT, @ 1820 KPa, °C	D648	208

(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 6115 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 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: 245-260°C (473-500°F)
- Front zone: 250-265°C (482-509°F)
- Nozzle: 238-260°C (473-500°F)
- Melt temperature: 250-265°C (482-509°F)
- Mold temperature: 65-95°C(149-194°F)

Other Molding Parameters

- Injection Pressure: 55-117MPa (8000-17000 PSI)
- Injection Speed: Medium - fast
- Back Pressure: Low
- Screw Speed: 50-80 rpm



ISO 17025



Conseil canadien des normes
Standards Council of Canada

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