



# VYPET 6433

## PBT 33% fiberglass Reinforced, Toughened Resin

The Vypet 6433 is a 33% fiberglass reinforced, toughened 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 <sup>(a)</sup>	ASTM Method	Typical values
Density at 23°C, g/cm <sup>3</sup>	D792	1.52
Izod, notched, 23°C, J/m	D256	130
Tensile Strength @Yield (5mm/min), Mpa	D638	130
Elongation @ Break (5mm/min), %	D638	4.4
Flexural Strength (1.3mm/min), MPa	D790	180
Flexural Modulus (1.3mm/min), MPa	D790	7000
HDT, @ 1820 Kpa, °C	D648	210

(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 6433 grades process easily but must be thoroughly dried before molding, preferably in a dehumidifying desiccant hopper dryer, operating with an air flow rate of min1.0 CFM/lb, dew point of -18°C (-40°F) or lower. The material should be dried at 127°C (260°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: 232-249°C (450-480°F)
- Front zone: 238-260°C (460-500°F)
- Nozzle: 238-254°C (460-490°F)
- Melt temperature: 243-260°C (470-500°F)
- Mold temperature: 70-95°C(158-203°F)

### Other Molding Parameters

- Injection Pressure: 55-117MPa (8000-12000 PSI)
- Injection Speed: Medium-fast
- Back Pressure: Low
- Screw Speed: 60-90 rpm



ISO 17025



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