



VYPET VNT 615

PET 15% Glass Reinforced

Vypet VNT 615 is a 15% fiberglass reinforced PET injection molding compound designed for structural applications.

Features

- Easy, fast processing
- Excellent strength and stiffness
- Excellent dimensional stability

Typical Applications

- Electrical components
- Motor encapsulation
- Appliances parts

Typical Resin Properties ^(a)	Method	Typical values
Density, 23°C, g/cm ³	ISO 1183	1.39
Ash content, %	ISO 3451 - 2	15
Izod notched, 23°C, kJ/m ²	ISO 180	10
Tensile Strength @ Break, (5mm/min), MPa	ISO 527	75
Elongation @ Break, (5mm/min), %	ISO 527	5
Flexural Modulus (2mm/min), MPa	ISO 178	4,000
HDT, @ 264PSI, °C	ISO 75	205
Linear Mold Shrinkage, Flow direction (76mmx60mmx3.2mm), %	ASTM D955	0.3 - 0.4
Linear Mold Shrinkage, Transverse direction (76mmx60mmx3.2mm), %	ASTM D955	1 - 1.1

(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 VNT 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 or lower. The material should be dried at 121°C (250° F) for 4 hours and the humidity content of the material should be maintained below 0.02% during molding.

Molding

Vypet VNT products have a relatively wide processing window with barrel temperature settings as following:

- Feed zone: 260-270°C (500-520°F)
- Middle zone: 265-275°C (510-530°F)
- Front zone: 270-290°C (520-560°F)
- Nozzle: 275-300°C (530-570°F)
- Melt temperature: 275-300°C (530-570°F)
- Mold temperature: 93-121°C (200-250°F)

Other Molding Parameters

- Injection Pressure: 8000-12000 psi
- Injection Speed: Fast to improve aesthetics and reduce stress
- Back Pressure: Low (25-50 psi)
- Screw Speed: 50-75 rpm



ISO 17025



Conseil canadien des normes
Standards Council of Canada

MN46 R1 DS VYPET VNT 615 - Rev 2
8800, Crescent 1 Ville d'Anjou, (Québec) Canada H1J 1C8
Tel. : 514-354-5757 Fax. : 514-354- 3087 Email : lavergne@lavergne.ca

The information in this technical datasheet is, to our knowledge, true and accurate. Inasmuch as we have no control over the many different conditions under which this information and our products may be used, we do not guarantee the applicability or accuracy of this information or the suitability of our products in any given situation. Users of our products should make their own tests to determine the suitability of each product to their particular application. The products are sold without warranty and the buyer assumes all responsibility for loss or damage arising from the handling and use of our products, whether done in accordance with directions or not. Statements concerning the possible use of our products are not intended as recommendations to use our products in conflict with any existing patents covering any materials or its use