



VYPET VNT 630

PET 30% Glass fibers Reinforced

Vypet 630 is a 30 % glass reinforced PET injection molding compound designed for electrical and structural applications.

Features

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

Typical Applications

- Electric motors
- Brackets/Connectors
- Grills

Typical Resin Properties (a)

Typical Resin Properties (a)	ISO Method	Typical values
Density at 23°C, g/cm ³	1183	1.55
Ash Content	3451-1	30
Izod, notched, 73°F, KJ/m ²	180/A	8
Tensile Strength @Yield, MPa	527-1	140
Flexural Strength (2 mm/min), MPa	178	200
Flexural Modulus (2 mm/min), MPa	178	9200
HDT, @ 264psi, °C Edgewise	75	222
Mold shrink (2.0mm) Flow	294-4	0.3
Mold shrink (2.0mm) Cross	294-4	0.9

(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

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