



# VYPET VNT 630 FR

## PET 30% Glassfiber Reinforced, Flame Retardant

Vypet VNT 630 FR is a 30% fiberglass reinforced flame retardant PET injection molding compound designed for electrical and structural applications.

### Features

- Flame retardant
- Excellent strength and stiffness
- Excellent dimensional stability

### Typical Applications

- Electrical parts
- Appliances
- Electronic applications

### Typical Resin Properties<sup>(a)</sup>

| ASTM Method | Typical values   |
|-------------|------------------|
| D792        | 1.65             |
| D256        | 90               |
| D256        | 85               |
| D638        | 145              |
| D790        | 215              |
| D790        | 10 200           |
| D648        | 228              |
| D3418       | 255              |
| D3835       | Min 180          |
| D257        | 10 <sup>15</sup> |
| D149        | 430              |
| D150        | 3.3              |
| D955        | 0.2              |
| D955        | 0.9              |
| UL94        | V0               |

(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: 266-280°C (510-530°F)
- Front zone: 272-294°C (520-560°F)
- Nozzle: 280-299°C (530-570°F)
- Melt temperature: 280-299°C (530-570°F)
- Mold temperature: 94-122°C (200-250°F)

#### Other Molding Parameters

- Injection Pressure: 8000-12000 psi
- Injection Speed: Fast to improve aesthetics and reduce stress
- Back Pressure: No Back
- Screw Speed: 50-75 rpm



ISO 17025



Conseil canadien des normes  
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