



VYPET VNT 915

PET 15% Fiberglass Reinforced Resin

Vypet VNT 915 is a 15% fiberglass reinforced PET injection molding compound designed for structural applications.

Features

- High temperature performance
- Low warp
- Excellent dimensional stability

Typical Applications

- Office equipment
- Appliances

Typical Resin Properties ^(a)	ASTM Method	Typical values
Density at 23°C, g/cm ³	D792	1.39
Izod, notched, 73°F, ft-lb/in	D256	1.37
Izod, notched, 73°F, J/m	D256	72.6
Tensile Strength @Yield	D638	13.6 Kpsi (93.8 MPa)
Elongation @ Break, %	D638	4.1
Flexural Strength	D790	19.8 Kpsi (136.5 MPa)
Flexural Modulus (1.3mm/min)	D790	780 Kpsi (5380 MPa)
HDT, @ 264psi	D648	410°F (210°C)

(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: 270-280°C (520-530°F)
- Front zone: 280-285°C (530-540°F)
- Nozzle: 280-290°C (530-550°F)
- Melt temperature: 280-290°C (530-550°F)
- Mold temperature: 100-121°C (212-250°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
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