LAVERGNE

VYPET VNT 930

PET 30% Glass Reinforced

Vypet VNT 930 is a 30% fiberglass reinforced PET injection molding compound designed for structural applications.

Features

- High temperature performance
- Low warp
- Excellent dimensional stability

Typical Applications

- Grill retainers
- Lamp holders

Typical Resin Properties[(a)]	ASTM Method	Typical values
Density at 23°C, g/cm^3	D792	1.52
Izod, notched, 23°C, J/m	D256	110.6
Tensile Strength @Yield (5mm/min), MPa	D638	131.9
Elongation @ Break, %	D638	4.1
Flexural Strength (1.3mm/min), MPa	D790	204.5
Flexural Modulus (1.3mm/min), MPa	D790	9,478
HDT, @ 1820 KPa, °C	D648	217

(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 930 grades process easily but must be thoroughly dried before molding, preferably in a dehumidifying desiccant hopper dryer, operating with an air flow rate of min 1.0 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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