

VYPET VNT 930

Polyethylene Terephthalate

Lavergne Group

Message:

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

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 30% filler by weight		
Features	Good dimensional stability		
	Low warpage		
	Heat resistance, high		
Uses	Components		
	Application in Automobile Field		
	Shell		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.52	g/cm ³	ASTM D792, ISO 1183
Molding Shrinkage			
Flow: 2.00mm	0.40	%	ASTM D955
Transverse flow: 2.00mm	0.80	%	ASTM D955
Vertical flow direction: 2.00mm	0.80	%	ISO 294-4
Flow direction: 2.00mm	0.40	%	ISO 294-4
Ash Content			
--	30	%	ISO 3451-1
--	30	%	ASTM D2854
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength			
Yield ¹	132	MPa	ASTM D638
Yield	140	MPa	ISO 527-2/5
Flexural Modulus			
-- ²	9400	MPa	ASTM D790
-- ³	9100	MPa	ISO 178

Flexural Strength			
-- 4	205	MPa	ASTM D790
-- 5	210	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	100	J/m	ASTM D256
23°C	8.0	kJ/m ²	ISO 180/A
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	220	°C	ASTM D648, ISO 75-2/A
Injection	Nominal Value	Unit	
Drying Temperature	120	°C	
Drying Time	4.0	hr	
Suggested Max Moisture	0.020	%	
Rear Temperature	260 - 270	°C	
Middle Temperature	265 - 275	°C	
Front Temperature	270 - 295	°C	
Nozzle Temperature	275 - 300	°C	
Processing (Melt) Temp	275 - 300	°C	
Mold Temperature	95.0 - 120	°C	
Injection Pressure	55.0 - 85.0	MPa	
Injection Rate	Fast		
Screw Speed	50 - 75	rpm	
Injection instructions			
Back Pressure: Low			
NOTE			
1.	5.0 mm/min		
2.	1.3 mm/min		
3.	2.0 mm/min		
4.	1.3 mm/min		
5.	2.0 mm/min		

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