

SCHULADUR® E GF 30 FR5

Polyethylene Terephthalate

A. Schulman Europe

Message:

Flame retardant PET reinforced with 30% glass fiber, without PBDE; high CTI

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 30% filler by weight		
Features	Halogenated		
	Fill		
	No antimony		
	Flame retardancy		
UL File Number	E86615		
Processing Method	Injection molding		
Resin ID (ISO 1043)	PET GF 30 FR 16		
Physical	Nominal Value	Unit	Test Method
Density	2.00	g/cm ³	ISO 1183/A
Melt Volume-Flow Rate (MVR) (280°C/2.16 kg)	6.00	cm ³ /10min	ISO 1133
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	12300	MPa	ISO 527-2/1A/1
Tensile Stress (Break)	135	MPa	ISO 527-2/1A/5
Tensile Strain (Break)	1.7	%	ISO 527-2/1A/5
Flexural Modulus ¹	12400	MPa	ISO 178
Flexural Stress ² (1.7% strain)	220	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-30°C	10	kJ/m ²	ISO 179/1eA
23°C	10	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength			ISO 179/1eU
-30°C	30	kJ/m ²	ISO 179/1eU
23°C	30	kJ/m ²	ISO 179/1eU
Electrical	Nominal Value	Unit	Test Method
Comparative Tracking Index	300	V	IEC 60112
Flammability	Nominal Value	Unit	Test Method
Flame Rating			
0.800 mm	V-0		UL 94, IEC 60695-11-10, -20
1.60 mm	V-0		UL 94, IEC 60695-11-10, -20

3.20 mm	V-0		UL 94, IEC 60695-11-10, -20
1.50 mm, internal	5VA		UL 94
3.00 mm, internal	5VA		UL 94
1.50 mm	5VA		IEC 60695-11-10, -20
3.00 mm	5VA		IEC 60695-11-10, -20
Glow Wire Flammability Index			IEC 60695-2-12
0.750 mm	960	°C	IEC 60695-2-12
1.50 mm	960	°C	IEC 60695-2-12
3.00 mm	960	°C	IEC 60695-2-12
Glow Wire Ignition Temperature			IEC 60695-2-13
0.750 mm	930	°C	IEC 60695-2-13
1.50 mm	930	°C	IEC 60695-2-13
3.00 mm	960	°C	IEC 60695-2-13

Additional Information

1.)

Not for use in food contact applications2.)

Not for use in medical or pharmaceutical applicationsCharacteristic propertiesSCHULADUR possesses good rigidity, cold impact strength, dimensional stability and high heat deflection temperature.

Injection	Nominal Value	Unit
Drying Temperature	120	°C
Drying Time	4.0 - 6.0	hr
Suggested Max Moisture	0.020	%
Suggested Max Regrind	10	%
Hopper Temperature	70.0	°C
Rear Temperature	240	°C
Middle Temperature	260	°C
Front Temperature	280	°C
Nozzle Temperature	280	°C
Processing (Melt) Temp	270 - 280	°C
Mold Temperature	140 - 150	°C
Injection Pressure	80.0 - 120	MPa
Injection Rate	Moderate	
Holding Pressure	40.0 - 70.0	MPa
Back Pressure	5.00 - 10.0	MPa
Cushion	2.00 - 5.00	mm
Vent Depth	0.020	mm
Screw Speed		mm/sec

Injection instructions

PredryingA dehumidifying dryer has to be used for drying. Unless a drying hopper is in use, material for no more than one hours processing should be placed in the hopper.ReprocessingUp to 20% regrind may be used, in which case use of additional stabilization is recommended as a safety precaution. Use only well dried regrind.Shut downAfter breaks >2 minutes purge with fresh material. For shut down purge with polyolefin. For breaks in production reduce the temperature to 210° C.FinishingSCHULADUR is suitable for machining. Varnishing, printing, gluing and embossing can be carried out using commercially available products after pretreatment. This is often achieved by washing the surface with an organic solvent.It can be laser marked without special Additives. For improved contrast use specific laser printable types.

NOTE

- | | |
|----|------------|
| 1. | 2.0 mm/min |
| 2. | 2.0 mm/min |

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