

VYPET VNT 630 FR

Polyethylene Terephthalate

Lavergne Group

Message:

Vypet 630 FR is a 30 % glass reinforced Flame retardant, PET injection molding compound designed for electrical and structural applications.

Features

Flame retardant

UL yellow card file E216152

Excellent strength and stiffness

Excellent dimensional stability

Typical Applications

Electrical parts

Appliances

Electronic Applications

General Information			
UL YellowCard	E216152-100247156		
Filler / Reinforcement	Glass fiber reinforced material, 30% filler by weight		
Features	Good dimensional stability		
	Rigidity, high		
	High strength		
	Flame retardancy		
Uses	Electrical/Electronic Applications		
	Electrical appliances		
	Components		
UL File Number	E216152		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.65	g/cm ³	ASTM D792, ISO 1183
Molding Shrinkage			
Flow: 2.00mm	0.20	%	ASTM D955
Transverse flow: 2.00mm	0.90	%	ASTM D955
Vertical flow direction: 2.00mm	0.90	%	ISO 294-4
Flow direction: 2.00mm	0.20	%	ISO 294-4
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength			
Fracture ¹	145	MPa	ASTM D638
Fracture	145	MPa	ISO 527-2/5
Flexural Modulus ²			
--	10200	MPa	ASTM D790

--	10000	MPa	ISO 178
Flexural Strength ³	215	MPa	ASTM D790, ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	90	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, not annealed	228	°C	ASTM D648
1.8 MPa, not annealed	225	°C	ISO 75-2/A
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+16	ohms · cm	ASTM D257
Dielectric Strength	29	kV/mm	ASTM D149
Dielectric Constant (1 kHz)	3.30		ASTM D150
Comparative Tracking Index (CTI)	PLC 3		UL 746
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
0.850 mm	V-0		UL 94
	V-0		
1.50 mm	5VA		UL 94
	V-0		
3.00 mm	5VA		UL 94
Glow Wire Flammability Index (1.00 mm)	960	°C	IEC 60695-2-12
Glow Wire Ignition Temperature (1.00 mm)	825	°C	IEC 60695-2-13
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 - 290	°C	
Nozzle Temperature	275 - 295	°C	
Processing (Melt) Temp	275 - 295	°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: No Back

NOTE

1.	5.0 mm/min
2.	2.0 mm/min
3.	2.0 mm/min

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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

