

VYPET VNT 645

Polyethylene Terephthalate

Lavergne Group

Message:

Vypet VNT 645 is a 45% glass reinforced PET injection molding compound designed for electrical and structural applications.

Features

High temperature performance

Excellent strength and stiffness

Excellent dimensional stability

Typical Applications

Electric motors

Brackets

Connectors

Grills

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 45% filler by weight		
Features	Good dimensional stability		
	Rigidity, high		
	High strength		
	High temperature strength		
Uses	Electrical/Electronic Applications		
	Components		
	Connector		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.68	g/cm ³	ISO 1183
Molding Shrinkage			ISO 294-4
Vertical flow direction: 2.00mm	1.0	%	ISO 294-4
Flow direction: 2.00mm	0.40	%	ISO 294-4
Ash Content	45	%	ISO 3451-1
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Break)	160	MPa	ISO 527-2/5
Flexural Modulus ¹	15000	MPa	ISO 178
Flexural Stress ²	250	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	8.5	kJ/m ²	ISO 180/A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	230	°C	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. 2.0 mm/min
2. 2.0 mm/min

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