

4PET® 9L22115 FR1

Polyethylene Terephthalate
4Plas

Message:

4PET 9L22115 FR1 is a Standard Flow 15% Glass Fibre Reinforced FR-V0 PET

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 15% filler by weight		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.58	g/cm ³	ISO 1183
Water Absorption ¹ (Equilibrium, 23°C, 50% RH)	0.20	%	ISO 62
Moisture Content	< 800	ppm	ISO 960
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	7000	MPa	ISO 527-2/5
Tensile Stress (Break, 23°C)	110	MPa	ISO 527-2/5
Tensile Strain (Break, 23°C)	2.5	%	ISO 527-2/5
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ISO 180/1A
-30°C	5.0	kJ/m ²	ISO 180/1A
23°C	6.0	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, not annealed	225	°C	ISO 75-2/B
1.8 MPa, not annealed	195	°C	ISO 75-2/A
Vicat Softening Temperature	215	°C	ISO 306/B
Melting Temperature ²	255	°C	ISO 11357
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+14	ohms	IEC 60093
Volume Resistivity	1.0E+16	ohms · cm	IEC 60093
Comparative Tracking Index	225	V	IEC 60112
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
0.750 mm	V-0		UL 94
1.60 mm	V-0		UL 94
Glow Wire Ignition Temperature (2.00 mm)	960	°C	IEC 60695-2-13
Injection	Nominal Value	Unit	
Drying Temperature	120 - 140	°C	
Drying Time	2.0 - 4.0	hr	

Suggested Max Moisture	0.020	%
Processing (Melt) Temp	270 - 290	°C
Mold Temperature	90.0 - 140	°C
Injection Rate	Fast	
Holding Pressure	60.0 - 100	MPa
Screw Speed	200	rpm

Injection instructions

Feed Throat Temperature: 50 - 70 °CBack Pressure: Low

NOTE

1.	24 Hrs
2.	10 K/min

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