

VYPET VNT 325

Polyethylene Terephthalate
Lavergne Group

Message:

Vypet 325 is a 25 % glass/mineral reinforced PET injection molding compound designed for electrical and structural applications.

- Features
- High temperature performance
 - Good balance resilience-stiffness
 - Low warpage
- Typical Applications
- Electric parts
 - Brackets/Connectors
 - Heat resistant handles

General Information			
Filler / Reinforcement	Glass \mineral, 25% filler by weight		
Features	Low warpage		
	Rigidity, high		
	Heat resistance, high		
	Elastic		
Uses	Handle		
	Electrical/Electronic Applications		
	Components		
	Connector		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density (23°C)	1.50	g/cm³	ISO 1183
Molding Shrinkage			ISO 294-4
Vertical flow direction: 2.00mm	0.90	%	ISO 294-4
Flow direction: 2.00mm	0.50	%	ISO 294-4
Ash Content	25	%	ISO 3451-1
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Break)	95.0	MPa	ISO 527-2/5
Flexural Modulus ¹	7000	MPa	ISO 178
Flexural Stress ²	150	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	5.0	kJ/m²	ISO 179/1eA
Notched Izod Impact (23°C)	6.0	kJ/m²	ISO 180
Thermal	Nominal Value	Unit	Test Method

Heat Deflection Temperature (1.8 MPa, Unannealed)	215	°C	ISO 75-2/A
Melting Temperature	250	°C	ISO 11357-3
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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