

PENTESTER ET GV30 H schwarz

Polyethylene Terephthalate

PENTAC Polymer GmbH

Message:

Normal viscosity, heat stabilised polyester PET, 30% glass fiber reinforced

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 30% filler by weight		
Additive	heat stabilizer		
Features	Rigid, good		
	Thermal Stability		
Agency Ratings	EC 1907/2006 (REACH)		
Appearance	Black		
Forms	Particle		
Physical	Nominal Value	Unit	Test Method
Density	1.56	g/cm ³	ISO 1183
Molding Shrinkage			ISO 294-4
Vertical flow direction	0.80	%	ISO 294-4
Flow direction	0.40	%	ISO 294-4
Water Absorption			ISO 62
Saturated, 23°C	0.50	%	ISO 62
Equilibrium, 23°C, 50% RH	0.18	%	ISO 62
Hardness	Nominal Value	Unit	Test Method
Ball Indentation Hardness (H 961/30)	235	MPa	ISO 2039-1
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	11400	MPa	ISO 527-2/1
Tensile Stress (Break)	155	MPa	ISO 527-2
Tensile Strain (Break)	2.1	%	ISO 527-2
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	10	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	45	kJ/m ²	ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, not annealed	245	°C	ISO 75-2/B
1.8 MPa, not annealed	225	°C	ISO 75-2/A
Melting Temperature (DSC)	255	°C	ISO 3146
Electrical	Nominal Value	Unit	Test Method
Dielectric Strength (1.00 mm)	32	kV/mm	IEC 60243-1
Relative Permittivity (1 MHz)	3.90		IEC 60250

Comparative Tracking Index	250	V	IEC 60112
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
1.60 mm	HB		UL 94
3.20 mm	HB		UL 94

Additional Information

ISO Description: PET, MPRMC, 13-110; GF30The value listed as Melting Point, ISO 3146, was tested in accordance with ISO 11357.

Injection	Nominal Value	Unit
Drying Temperature	90.0	°C
Drying Time	4.0	hr
Suggested Max Moisture	0.014	%
Suggested Max Regrind	20	%
Rear Temperature	265 - 290	°C
Middle Temperature	280 - 295	°C
Front Temperature	280 - 290	°C
Processing (Melt) Temp	285	°C
Mold Temperature	130	°C
Injection Pressure	78.0	MPa
Holding Pressure	46.8	MPa
Screw L/D Ratio	20.0:1.0	
Screw Compression Ratio	2.2:1.0 to 2.8:1.0	

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