

4PET® 9L22130 HL

Polyethylene Terephthalate

4Plas

Message:

4PET 9L22130 HL is a Standard Flow 30% Glass Fibre Reinforced Heat Stabilised, Lubricated PET

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 30% filler by weight		
Additive	heat stabilizer		
	Lubricant		
Features	Thermal Stability		
	Lubrication		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.57	g/cm ³	ISO 1183
Molding Shrinkage			
Vertical flow direction	0.90	%	
Flow direction	0.20	%	
Water Absorption ¹ (Equilibrium, 23°C, 50% RH)	0.20	%	ISO 62
Moisture Content	< 1000	ppm	ISO 960
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	11000	MPa	ISO 527-2/5
Tensile Stress (Break, 23°C)	150	MPa	ISO 527-2/5
Tensile Strain (Break, 23°C)	2.0	%	ISO 527-2/5
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			
--	9.0	kJ/m ²	ISO 179
23°C	10	kJ/m ²	ISO 179/B
Notched Izod Impact			ISO 180/1A
-30°C	8.0	kJ/m ²	ISO 180/1A
23°C	9.0	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength			ISO 180/1U
-30°C	40	kJ/m ²	ISO 180/1U
23°C	45	kJ/m ²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, not annealed	235	°C	ISO 75-2/B

1.8 MPa, not annealed	215	°C	ISO 75-2/A
Vicat Softening Temperature	225	°C	ISO 306/B
Melting Temperature ²	250	°C	ISO 11357
Electrical	Nominal Value	Unit	Test Method
Dielectric Strength	30	kV/mm	IEC 60243-1
Dissipation Factor			IEC 60250
1 Hz	0.018		IEC 60250
100 Hz	3.0E-3		IEC 60250
Comparative Tracking Index	250	V	IEC 60112
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
0.800 mm	HB		UL 94
1.60 mm	HB		UL 94
Glow Wire Ignition Temperature (2.00 mm)	750	°C	IEC 60695-2-13
Oxygen Index	21	%	ISO 4589-2
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 °C Back Pressure: Low			
NOTE			
1.	24 Hrs		
2.	10 K/min		

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