

4PET® 9L22130 HIUV

Polyethylene Terephthalate

4Plas

Message:

4PET 9L22130 HIUV is a Standard Flow 30% Glass Fibre Reinforced Heat Stabilised, Impact Modified, UV Stabilised PET

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 30% filler by weight		
Additive	Impact modifier heat stabilizer UV stabilizer		
Features	Impact modification Good UV resistance Thermal Stability		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.50	g/cm ³	ISO 1183
Molding Shrinkage			
Vertical flow direction	1.0	%	
Flow direction	0.30	%	
Water Absorption			
Saturation	0.60	%	ASTM D570
Equilibrium, 23°C, 50% RH ¹	0.18	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	9000	MPa	ISO 527-2/5
Tensile Stress (Break, 23°C)	130	MPa	ISO 527-2/5
Tensile Strain (Break, 23°C)	3.0	%	ISO 527-2/5
Flexural Modulus ² (23°C)	8000	MPa	ISO 178
Flexural Stress ³ (23°C)	180	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-30°C	12	kJ/m ²	ISO 179/1eA
23°C	14	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength			ISO 179/1eU
-30°C	60	kJ/m ²	ISO 179/1eU
23°C	70	kJ/m ²	ISO 179/1eU
Notched Izod Impact			ISO 180/1A
-30°C	10	kJ/m ²	ISO 180/1A

23°C	13	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, not annealed	230	°C	ISO 75-2/B
1.8 MPa, not annealed	210	°C	ISO 75-2/A
Vicat Softening Temperature	220	°C	ISO 306/B
Melting Temperature ⁴	255	°C	ISO 11357
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+14	ohms	IEC 60093
Volume Resistivity	1.0E+15	ohms·cm	IEC 60093
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
Glow Wire Ignition Temperature (2.00 mm)	650	°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	260 - 290	°C	
Mold Temperature	90.0 - 140	°C	
Injection Rate	Moderate-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.	2.0 mm/min		
3.	2.0 mm/min		
4.	10 K/min		

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