

VYPET VNT 630

Polyethylene Terephthalate

Lavergne Group

Message:

Vypet 630 is a 30 % glass reinforced PET injection molding compound designed for electrical and structural applications.

Features

High temperature performance

Excellent strength and stiffness

Excellent dimensional stability

Typical Applications

Electric motors

Brackets/Connectors

Grills

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 30% filler by weight		
Features	Good dimensional stability		
	Rigidity, high		
	High strength		
	Heat resistance, high		
Uses	Electrical/Electronic Applications		
	Components		
	Connector		
	Automotive exterior parts		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
--	1.56	g/cm ³	ASTM D792
23°C	1.56	g/cm ³	ISO 1183
Molding Shrinkage			
Flow: 2.00mm	0.40	%	ASTM D955
Transverse flow: 2.00mm	0.80	%	ASTM D955
Vertical flow direction: 2.00mm	0.80	%	ISO 294-4
Flow direction: 2.00mm	0.40	%	ISO 294-4
Ash Content			
--	30	%	ASTM D2854
--	30	%	ISO 3451-1
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength			
Yield ¹	145	MPa	ASTM D638

Yield	140	MPa	ISO 527-2/5
Flexural Modulus			
-- ²	9200	MPa	ASTM D790
-- ³	9000	MPa	ISO 178
Flexural Strength			
-- ⁴	210	MPa	ASTM D790
-- ⁵	210	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	9.0	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	225	°C	ASTM D648, ISO 75-2/A
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.	5.0 mm/min		
2.	1.3 mm/min		
3.	2.0 mm/min		
4.	1.3 mm/min		
5.	2.0 mm/min		

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