

VYPET VNT 615HP

Polyethylene Terephthalate
Lavergne Group

Message:

Vypet VNT 615 HP is a modified 15% fiberglass reinforced PET injection molding compound designed for automotive structural applications.

- Features
- Easy, fast processing
 - Excellent strength and stiffness
 - Excellent dimensional stability
- Typical Applications
- Automotive structural parts
 - Automotive sun roof frames

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 15% filler by weight		
Features	Good dimensional stability		
	Rigid, good		
	Workability, good		
	Good strength		
Uses	Components		
	Application in Automobile Field		
UL File Number	E216152		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density (23°C)	1.40	g/cm ³	ISO 1183
Molding Shrinkage			ASTM D955
Flow: 2.00mm	0.40	%	ASTM D955
Transverse flow: 2.00mm	0.80	%	ASTM D955
Ash Content	15	%	ISO 3451
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Break)	100	MPa	ISO 527-2/5
Flexural Modulus ¹	6000	MPa	ISO 178
Flexural Stress ²	150	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	6.0	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	210	°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 - 290	°C
Nozzle Temperature	275 - 295	°C
Processing (Melt) Temp	270 - 290	°C
Mold Temperature	95.0 - 120	°C
Injection Rate	Moderate	

Injection instructions

Injection Pressure: Medium Back Pressure: Low Screw Speed: Medium

NOTE

1. 2.0 mm/min
2. 2.0 mm/min

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