

PENTESTER ET GV20 L H RC schwarz

Polyethylene Terephthalate

PENTAC Polymer GmbH

Message:

Normal viscosity, heat stabilised polyester PET, 20% glass fiber reinforced, impact modified, Recompound

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 20% filler by weight		
Additive	Impact modifier heat stabilizer		
Recycled Content	Yes		
Features	Impact modification Rigid, good Thermal Stability		
Uses	Parts under the hood of a car Shell		
Agency Ratings	EC 1907/2006 (REACH)		
Appearance	Black		
Forms	Particle		
Physical	Nominal Value	Unit	Test Method
Density	1.43	g/cm ³	ISO 1183
Water Absorption			ISO 62
Saturated, 23°C	0.50	%	ISO 62
Equilibrium, 23°C, 50% RH	0.10	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	8600	MPa	ISO 527-2/1
Tensile Stress (Break)	110	MPa	ISO 527-2
Tensile Strain (Break)	2.3	%	ISO 527-2
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-30°C	5.0	kJ/m ²	ISO 179/1eA
23°C	6.0	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength			ISO 179/1eU
-30°C	25	kJ/m ²	ISO 179/1eU
23°C	35	kJ/m ²	ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			

0.45 MPa, not annealed	220	°C	ISO 75-2/B
1.8 MPa, not annealed	180	°C	ISO 75-2/A
Melting Temperature (DSC)	245	°C	ISO 3146
Flammability	Nominal Value	Test Method	
Flame Rating		UL 94	
1.60 mm	HB	UL 94	
3.20 mm	HB	UL 94	

Additional Information

ISO Description: PET, MPRMC, 13-090; GF20The 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	0.016	%
Suggested Max Regrind	20	%
Rear Temperature	260 - 285	°C
Middle Temperature	275 - 290	°C
Front Temperature	275 - 285	°C
Processing (Melt) Temp	280	°C
Mold Temperature	130	°C
Injection Pressure	72.0	MPa
Holding Pressure	36.0	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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