4PET® 9L22130 HHR

Polyethylene Terephthalate

4Plas

Message:

4PET 9L22130 HHR is a Standard Flow 30% Glass Fibre Reinforced High Heat Resistant PET

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 30% filler by weight		
Features	Heat resistance, high		
Processing Method	Injection molding		
Physical	**Nominal Value**	**Unit**	**Test Method**
Density	1.59	g/cm³	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	< 800	ppm	ISO 960
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus (23°C)	11000	MPa	ISO 527-2/5
Tensile Stress (Break, 23°C)	135	MPa	ISO 527-2/5
Tensile Strain (Break, 23°C)	2.0	%	ISO 527-2/5
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact			ISO 180/1A
-30°C	7.0	kJ/m²	ISO 180/1A
23°C	8.0	kJ/m²	ISO 180/1A
Thermal	**Nominal Value**	**Unit**	**Test Method**
Heat Deflection Temperature			
0.45 MPa, not annealed	245	°C	ISO 75-2/B
1.8 MPa, not annealed	220	°C	ISO 75-2/A
Vicat Softening Temperature	215	°C	ISO 306/B
Melting Temperature [2]	255	°C	ISO 11357
Electrical	**Nominal Value**	**Unit**	**Test Method**
Surface Resistivity	1.0E+14	ohms	IEC 60093
Volume Resistivity	1.0E+16	ohms·cm	IEC 60093
Comparative Tracking Index	250	V	IEC 60112
Flammability	**Nominal Value**	**Unit**	**Test Method**
Flame Rating			UL 94
0.750 mm	HB		UL 94
1.60 mm	HB		UL 94

Glow Wire Ignition Temperature (2.00 mm)	750	°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	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 °CBack Pressure: Low

NOTE	
1.	24 Hrs
2.	10 K/min

Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China