

VYPET VNT 835B

Polyethylene Terephthalate
Lavergne Group

Message:

VYPET VNT 835B is a 35% mineral and fiberglass reinforced PET injection molded compound designed for structural applications quality surface enhanced.

Features

- High temperature performance
- Low warp
- Excellent dimensional stability

Typical Applications

- Grill retainers
- Lamp holders

General Information			
Filler / Reinforcement	Glass \mineral, 35% filler by weight		
Features	Good dimensional stability		
	Low warpage		
	Heat resistance, high		
Uses	Components		
	Application in Automobile Field		
	Shell		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.56	g/cm ³	ASTM D792
Molding Shrinkage			ASTM D955
Flow: 2.00mm	0.40	%	ASTM D955
Transverse flow: 2.00mm	0.80	%	ASTM D955
Ash Content	35	%	ASTM D2854
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield)	120	MPa	ASTM D638
Flexural Modulus ²	9900	MPa	ASTM D790
Flexural Strength ³	185	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	75	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	213	°C	ASTM D648
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. | 1.3 mm/min |

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