

KumhoSunny PET HEG3645

Polyethylene Terephthalate
Shanghai KumhoSunny Plastics Co., Ltd.

Message:
HEG3645 is a 45% glass fiber reinforced, modified polyethylene terephtalate for injection molding. offering high rigidity,high heat resistance, good surface quality and dimensional stability.

General Information			
Filler / Reinforcement	Glass Fiber,45% Filler by Weight		
Features	Fatigue Resistant		
	Good Dimensional Stability		
	Good UV Resistance		
	High Heat Resistance		
	High Rigidity		
	Low to No Odor		
Uses	Automotive Applications		
	Automotive Interior Parts		
	Electrical Parts		
	Electrical/Electronic Applications		
	Household Goods		
UL File Number	E254819		
	E65424		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
--	1.71	g/cm ³	ASTM D792
--	1.75	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (265°C/2.16 kg)	25	g/10 min	ISO 1133
Molding Shrinkage			
Flow	0.20 to 0.50	%	ASTM D955
--	0.40 to 0.80	%	ISO 294-4
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength			
--	162	MPa	ASTM D638
--	140	MPa	ISO 527-2/5
Tensile Elongation (Break)	2.0	%	ASTM D638

Flexural Modulus			
--	16000	MPa	ASTM D790
-- ¹	12000	MPa	ISO 178
Flexural Strength			
--	220	MPa	ASTM D790
-- ²	210	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179
-30°C	5.0	kJ/m ²	
23°C	7.5	kJ/m ²	
Notched Izod Impact			
3.20 mm	90	J/m	ASTM D256
23°C	7.0	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed	255	°C	ASTM D648
1.8 MPa, Unannealed	240	°C	ASTM D648
1.8 MPa, Unannealed ³	230	°C	ISO 75-2/A
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	> 1.0E+15	ohms	IEC 60093
Volume Resistivity	> 1.0E+15	ohms·cm	IEC 60093
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.60 mm)	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	120 to 140	°C	
Drying Time	4.0 to 6.0	hr	
Suggested Max Moisture	< 0.020	%	
Rear Temperature	245 to 260	°C	
Middle Temperature	250 to 265	°C	
Front Temperature	255 to 270	°C	
Nozzle Temperature	260 to 275	°C	
Processing (Melt) Temp	245 to 275	°C	
Mold Temperature	100 to 120	°C	
Back Pressure	0.200 to 0.800	MPa	
Screw Speed	20 to 100	rpm	
NOTE			
1.	2.0 mm/min		
2.	2.0 mm/min		
3.	120°C/h		

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