

VYPET VNT 635A

Polyethylene Terephthalate

Lavergne Group

Message:

Vypet 635A is a 35 % glass reinforced PET injection molding compound designed for electrical and structural applications with a very glossy surface

Features

- High temperature performance
- Excellent strength and stiffness
- Quality A surface

Typical Applications

- Furniture
- Brackets/Connectors
- Grills

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 35% filler by weight		
Features	Rigid, good		
	Good strength		
	Heat resistance, high		
	Excellent appearance		
Uses	Electrical/Electronic Applications		
	Components		
	Furniture		
	Connector		
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)	140	MPa	ASTM D638
Flexural Modulus ²	10000	MPa	ASTM D790
Flexural Strength ³	210	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)	225	°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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