

4PET® 9L22130 FR1

Polyethylene Terephthalate

4Plas

Message:

4PET 9L22130 FR1 is a Standard Flow 30% Glass Fibre Reinforced FR-V0 PET

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 30% filler by weight		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.68	g/cm ³	ISO 1183
Molding Shrinkage			
Vertical flow direction	0.90	%	
Flow direction	0.20	%	
Water Absorption ¹ (Equilibrium, 23°C, 50% RH)	0.17	%	ISO 62
Moisture Content	< 1000	ppm	ISO 960
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	10500	MPa	ISO 527-2/5
Tensile Stress (Break, 23°C)	130	MPa	ISO 527-2/5
Tensile Strain (Break, 23°C)	2.0	%	ISO 527-2/5
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-30°C	8.0	kJ/m ²	ISO 179/1eA
23°C	9.0	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength			ISO 179/1eU
-30°C	30	kJ/m ²	ISO 179/1eU
23°C	45	kJ/m ²	ISO 179/1eU
Notched Izod Impact			ISO 180/1A
-30°C	7.0	kJ/m ²	ISO 180/1A
23°C	8.0	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, not annealed	235	°C	ISO 75-2/B
1.8 MPa, not annealed	210	°C	ISO 75-2/A
Vicat Softening Temperature	215	°C	ISO 306/B
Melting Temperature ²	250	°C	ISO 11357
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+14	ohms	IEC 60093
Volume Resistivity	1.0E+15	ohms · cm	IEC 60093

Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
1.60 mm	V-0		UL 94
3.20 mm	V-0		UL 94
Glow Wire Ignition Temperature (2.00 mm)	960	°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 °C Back Pressure: Low

NOTE

1. 24 Hrs
2. 10 K/min

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