

4PET® 9L22120 H

Polyethylene Terephthalate
4Plas

Message:

4PET 9L22120 H is a Standard Flow 20% Glass Fibre Reinforced Heat Stabilised PET

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 20% filler by weight		
Additive	heat stabilizer		
Features	Thermal Stability		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.48	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (270°C/2.16 kg)	45	g/10 min	ISO 1133
Molding Shrinkage			
Vertical flow direction	1.0	%	
Flow direction	0.30	%	
Water Absorption ¹ (Equilibrium, 23°C, 50% RH)	0.20	%	ISO 62
Moisture Content	< 1000	ppm	ISO 960
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	8000	MPa	ISO 527-2/5
Tensile Stress (Break, 23°C)	120	MPa	ISO 527-2/5
Tensile Strain (Break, 23°C)	2.5	%	ISO 527-2/5
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ISO 180/1A
-30°C	6.0	kJ/m ²	ISO 180/1A
23°C	7.0	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength			ISO 180/1U
-30°C	25	kJ/m ²	ISO 180/1U
23°C	30	kJ/m ²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, not annealed	225	°C	ISO 75-2/B
1.8 MPa, not annealed	200	°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+16	ohms · cm	IEC 60093

Comparative Tracking Index	225	V	IEC 60112
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
1.60 mm	HB		UL 94
3.20 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 °C Back Pressure: Low			
NOTE			
1.	24 Hrs		
2.	10 K/min		

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