

KIMIDUR® PET (730GN)

MATERIAL NAME: PET COLOR: NATURAL CODE: PET 730GN

MATERIAL DESCRIPTION: Kimiadur® 730GN is a 30% glass fiber reinforced, prime, natural Polyethylene terephthalate resin for injection molding.

No.	PROPERTIES		METHOD	UNIT	VALUE
PHYSICAL PROPERTIES					
1	ASH CONTENT		ISO 3451	%	30±1.5
2	RELATIVE DENSITY		ISO 1183	g/cm ³	1.56
3	VISCOSITY NUMBER		ISO 307	Cm ³ /gr	-
4	MOISTURE CONTENT		ISO 62	%	0.21
MECHANICAL PROPERTIES					
5	TENSILE STRENGTH AT BREAK (5mm/min)		ASTM/D638	MPa	133
6	ELONGATION AT BREAK (5mm/min)		ASTM/D638	%	8.0
7	TENSILE MODULUS (5mm/min)		ASTM/D638	MPa	9800
8	NOTCHED IMPACT STRENGTH-IZOD		ISO 180	Kj/m ²	8
9	UN NOTCHED IMPACT STRENGTH-IZOD		ISO 180	Kj/m ²	50.8
THERMAL PROPERTIES					
10	HARDNESS		ISO 868	Shore D	76
11	MFI		ASTM/D1238	g/10min	-
12	VICAT(50° C/h)	10N	ASTM/D1238	° C	-
		50N			-
FLAMMABILITY					
13	HDT (120° C/h)	264psi	ASTM/D648	° C	214
		66psi			233
14	Flammability	Class	UL94	-	-
INJECTION PROCESS PARAMETERS					
<i>Loading</i>		<i>Injection</i>		<i>Degassing</i>	
<i>Speed</i>	<i>Pressure (Bar)</i>	<i>Speed</i>	<i>Pressure (Bar)</i>	<i>Temperature</i>	<i>Time</i>
60	80	60	80	80 °C	0.5h
<i>Mold Releasing</i>		<i>Zone</i>			
Good		5	4	3	2
		- °C	250 °C	255 °C	260 °C