

**Technical Data Sheet**

**Material Information:** EPIMIX PET, reinforced with 50% of glass fiber, heat stabilized, lubricated for injection moulding.

**Notes:** EPIMIX PET glass fiber compounds are used in all sectors of industry, offering a perfect balance of thermal and mechanical properties with an excellent surface quality.  
This material is available in natural and colours on request.

Properties	Test Method	Unit	Value
<b>Physical properties</b>			<b>Dry</b>
Density (23°C)	ISO 1183	g/cm <sup>3</sup>	1,75
Ash content	ISO 3451-4	%	50
Mold shrinkage- parallel/normal (3mm)	ISO 294-4	%	0,2/0,8
<b>Mechanical properties</b>			
Tensile modulus (1mm/min) (23°C)	ISO 527-2	MPa	16500
Tensile stress at break (5mm/min) (23°C)	ISO 527-2	MPa	185
Tensile strain at break (5mm/min) (23°C)	ISO 527-2	%	2
Flexural modulus (2mm/min) (23°C)	ISO 178	MPa	14800
Flexural strength (2mm/min) (23°C)	ISO 178	MPa	280
Notched izod impact (23°C)	ISO 180/1A	kJ/m <sup>2</sup>	14
Unnotched izod impact (23°C)	ISO 180/1U	kJ/m <sup>2</sup>	68
Notched charpy impact (23°C)	ISO 179/1eA	kJ/m <sup>2</sup>	15
Unnotched charpy impact (23°C)	ISO 179/1eU	kJ/m <sup>2</sup>	75
<b>Thermal properties</b>			
Melting point	ISO 3146	°C	255
Temp. of deflection under load (0,45 MPa)	ISO 75-2/B	°C	245
Temp. of deflection under load (1,80 MPa)	ISO 75-2/A	°C	225
<b>Flammability &amp; electrical properties</b>			
Flammability classification (0,8mm) - UL 94	EN 60695-11-10	-	HB
Comparative tracking index - CTI (Solution A)	EN 60112	V	250
Surface resistivity	ASTM D257	Ω/sq	1,00E+14

**Test conditions**

Laboratory conditions are 23 ±2°C and 45-55 % RH.

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**EPIMIX PET GRADES PROCESSING CONDITIONS**

**Injection moulding of EPIMIX PET**

PET is easy to mould material, with a very wide processing window. A few general guidelines are given here.

**Pre-drying**

PET is hygroscopic and moisture sensitive, so pre-drying is recommended as a matter of rule. Material that is not pre-dried to a moisture level below 0,1 % will degrade, causing surface defects, parts that are out of dimension and brittle parts. It is recommended to dry material for 4 hours at 120°C to 130°C in a desiccant dryer with more than one desiccant element.

A few tips to ensure proper operation of the dryer:

\* Ensure the thermocouple that regulates the temperature is placed immediately before the entry of the air into the dryer. There can be a significant temperature drop in the air-conveyance system.

\* The temperature of the air going out of the dryer silo should not be more than 30°C lower than the air entering the system. If this is the case, you have insufficient air capacity.

\* From time to time, monitor the dew point of the dry air to ensure the desiccant elements are functioning properly.

\* Often, less air runs through the very bottom part of a dryer silo. Therefore, it is recommended that you take the material out of the bottom of the dryer and feed back into the top when you start up your process.

**Moulding temperatures**

PET can be processed between 260 and 300°C, depending on the grade used.

The following barrel settings are recommended:

Material	Zone 1 (Hopper)	Zone 2	Zone 3	Zone 4 (Nozzle)
Impact M. Grades	260-275°C	260-280°C	270-280°C	275-285°C
Flame Ret. Grades	260-280°C	260-280°C	270-280°C	275-285°C
Unfilled Grades	260-295°C	270-295°C	275-290°C	275-295°C
Reinforced Grades	270-290°C	270-295°C	270-295°C	275-295°C

**Tool temperature**

Mould temperature is always a compromise. On the one hand, tool temperature should be as high as possible to give optimum crystallization and dimensional, optimal surface finish and optimal mechanical performance. On the other hand, lower tool temperature can significantly cut cycle time. For PET, 80°C should be maintained as a minimum. For different grades values of 90-110°C are preferred.

**Pressure and speed**

Injection pressure should generally be around 70 to 100 Mpa; this results in a minimum clamping force of the moulding machine in tonnes of 0,7 times the projected surface area in cm<sup>2</sup>.

Holding pressure is generally in the area of 80 Mpa.

For glassfibre reinforced compounds, the screw speed should be kept low, a rough indication is as follows:

Screw diameter (mm)	Maximum rpm
20	100
30	95
40	70
50	60
60	50
70	40
80	35
>80	30

Back pressure should be kept to a practical minimum.

**Use of regrind**

Regrind sprues and runners can be used on most materials. It is not recommended to use regrind on FR grades. When regrind is used, observe these simple rules:

\* Use a constant ratio of regrind and virgin material. When a material has been processed once, its viscosity and fibre length have been decreased. Using varying ratios of regrind can lead to variations in dimensions, mechanical performance and processing characteristics.

\* Either feed the regrind straight back into the machine or pre-dry the regrind before usage.

\* Store regrind in a dry, clean place to avoid contamination and excess moisture.

\* Ensure sharp cutting blades to keep dust generation to a minimum; cut glass fibre reinforced material when it is still hot.

\* Clean the grinder regularly to avoid build up of dust.

\* Do not use splayed, discoloured or degraded parts and runners.

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