

**HEG3645**

PET-GF45

Shanghai Kumho Sunny Plastics Co., Ltd.

<b>Processing/Physical Characteristics</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
Melt flow index, MFI	25	g/10min	ISO 1133
Temperature	265	°C	-
Load	2.16	kg	-
Molding shrinkage, parallel	0.6	%	ISO 294-4, 2577
<b>ASTM Data</b>			
Mold Shrinkage, MD	0.0035	mm/mm	ASTM D 955
<b>Mechanical properties</b>			
<b>ISO Data</b>			
Tensile Strength	140	MPa	ISO 527
Flexural modulus, 23°C	12000	MPa	ISO 178
Flexural strength	210	MPa	ISO 178
Charpy notched impact strength, +23°C	7.5	kJ/m <sup>2</sup>	ISO 179/1eA
Charpy notched impact strength, -30°C	5	kJ/m <sup>2</sup>	ISO 179/1eA
Izod notched impact strength, +23°C	7	kJ/m <sup>2</sup>	ISO 180/1A
<b>ASTM Data</b>			
Tensile Strength	162	MPa	ASTM D 638
Elongation at Break	2	%	ASTM D 638
Flexural Modulus	16000	MPa	ASTM D 790
Flexural Strength	220	MPa	ASTM D 790
Izod Impact notched, 1/8 in	90	J/m	ASTM D 256
<b>Thermal properties</b>			
<b>ISO Data</b>			
Temp. of deflection under load, 1.80 MPa	230	°C	ISO 75-1/-2
<b>ASTM Data</b>			
UL 94 Flame rating	HB	-	UL 94
Thickness tested	1.6	mm	-
DTUL @ 66 psi	255	°C	ASTM D 648
DTUL @ 264 psi	240	°C	ASTM D 648
<b>Electrical properties</b>			
<b>ISO Data</b>			
Volume resistivity	1E15	Ohm*m	IEC 62631-3-1
Surface resistivity	>1E15	Ohm	IEC 62631-3-2
<b>Other properties</b>			
Density	1750	kg/m <sup>3</sup>	ISO 1183
Density	1710	kg/m <sup>3</sup>	ASTM D 792
<b>Processing Recommendation Injection Molding</b>			
Pre-drying - Temperature	120 - 140	°C	-
Pre-drying - Time	4 - 6	h	-
Processing humidity	≤0.02	%	-
Melt temperature	245 - 275	°C	-
Mold temperature	100 - 120	°C	-
Zone 1	245 - 260	°C	-
Zone 2	250 - 265	°C	-
Zone 3	255 - 270	°C	-
Nozzle temperature	260 - 275	°C	-
Screw speed	20 - 100	rpm	-
Back pressure	0.2 - 0.8	MPa	-

**Characteristics**

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**Processing**

Injection Molding

**Special Characteristics**

U.V. stabilized or stable to weather, Heat stabilized or stable to heat

**Features**

Fatigue Resistance

**Applications**

Automotive, Electrical and Electronical

**Regional Availability**

Asia Pacific