



GROMAX ENTERPRISES CORP.

17335 Daimler Street, Irvine, CA 92614

Tel: 949-833-1199 . Toll Free: 800-343-3508 . Fax: 949-833-0099

e-mail: info@gromax-usa.com website: www.gromaxchemical.com

Engineering Plastics Polyethylene Terephthalate

Technical Data

CCP PET 9130-104

PET glass fiber 30% reinforced injection molding grade.

Characteristics

- 1)excellent electrical property
- 2)excellent mechanic and chemical property
- 3)excellent weatherability
- 4)excellent wear property
- 5)excellent moldability
- 6)low warp age
- 7)high resistance to fuels, oil, fats and many solvents

Injection Molding Condition

Cylinder temperatures	: 250-270°C
Nozzle temperature	: 260-280°C
Mold temperature	: 80-140°C, suitable temperature 100-120°C
Injection rate	: middle – fast
Screw speed	: 100-200 rpm, to be chosen in such a way that plasticizing time is just within cooling time.
Pressure	Injection pressure : 500-1200 kg/cm ²
	Holding pressure : 300-800 kg/cm ²
	Back pressure : 0-3 kg/cm ²
Mold shrinkage	Mold shrinkage 1.6 mm thickness horizon is 0.1-0.3% and vertical is 0.4-1.1% under the test method ASTM D955.

Packaging

25 kg/ paper bag

Material handling

Moisture pick-up from ambient air should be avoided. Keep hopper properly closed.



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Property	Value	Unit	Test method ASTM
Glass fiber Content	30	%	
Specific gravity	1.70	-	D792
Melting point	255	°C	DSC
Coef. Of linear thermal expansion	2.0	10 ⁻⁵ cm/cm°C	D696
Heat deflection temperature under load			
--- 18.6 kg/cm ²	227	°C	D648
--- 4.6 kg/cm ²	247	°C	D648
Moisture absorption (24h)	0.05	%	D570
Flammability acc. to UL94, 0.8 mm thickness	V-0	-	UL94
Tensile strength	1275	kg/cm ²	D638
Tensile elongation	3.0	%	D638
Flexural strength	1950	kg/cm ²	D790
Flexural modulus	100000	kg/cm ²	D790
Izod impact strength - notched 1/4"	9.0	kg-cm/cm	D256
Dielectric strength, 2 mm thickness	22	KV/mm	D149
Volume resistivity	10 ¹⁵	Ω-cm	D257
Surface resistivity	10 ¹³	Ω	D257
Dielectric constant	3.8	60Hz	D150
Dielectric dissipation factor	0.011	60Hz	D150
Arc resistance	100	SEC	D495

(1) For reference only

(2) All data in the table are the typical values of the material and not the minimum values of the material specifications.