

Rynite® 935 NC010

THERMOPLASTIC POLYESTER RESIN

Common features of Rynite® thermoplastic polyester include mechanical and physical properties such as excellent balance of strength and stiffness, dimensional stability, creep resistance, heat resistance, high surface gloss and good inherent electrical properties at elevated temperature. It can be processed over a broad temperature range and has excellent flow properties.

Rynite® thermoplastic polyester resins are typically used in demanding applications in the automotive, electrical and electronics, appliances where they successfully replace metals and thermosets, as well as other thermoplastic polymers.

Rynite® 935 NC010 is a 35% mica/glass reinforced modified polyethylene terephthalate resin with low warpage and excellent electrical properties.

Product information

Resin Identification	PET-(MD+GF)3	ISO 1043
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Part Marking Code	>PET-(MD+GF)35<	ISO 11469

Rheological properties

Moulding shrinkage, parallel	0.3 %	ISO 294-4, 2577
Moulding shrinkage, normal	0.7 %	ISO 294-4, 2577

Typical mechanical properties

Tensile Modulus	10200 MPa	ISO 527-1/-2
Stress at break, 5mm/min	85 MPa	ISO 527-1/-2
Strain at break, 5mm/min	2 %	ISO 527-1/-2
Flexural Modulus	9100 MPa	ISO 178
Compressive strength	140 MPa	ISO 604
Shear Strength	55 MPa	ASTM D 732
Tensile creep modulus, 1h	9350 MPa	ISO 899-1
Tensile creep modulus, 1000h	7690 MPa	ISO 899-1
Charpy impact strength, 23°C	25 kJ/m ²	ISO 179/1eU
Charpy impact strength, -30°C	20 kJ/m ²	ISO 179/1eU
Charpy notched impact strength, 23°C	6 kJ/m ²	ISO 179/1eA
Charpy notched impact strength, -30°C	4 kJ/m ²	ISO 179/1eA
Hardness, Rockwell, M-scale	75	ISO 2039-2
Hardness, Rockwell, R-scale	115	ISO 2039-2
Poisson's ratio	0.34	



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Thermal properties

Melting temperature, 10°C/min	252 °C	ISO 11357-1/-3
Temp. of deflection under load, 1.8 MPa	200 °C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	235 °C	ISO 75-1/-2
Vicat softening temperature, 50°C/h, 50N	205 °C	ISO 306
Coeff. of linear therm. expansion, parallel, -40-23°C	26 E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, parallel	16 E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal, -40-23°C	53 E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal	52 E-6/K	ISO 11359-1/-2
Thermal conductivity	0.26 W/(m K)	ISO 22007-2
Thermal conductivity of melt	0.32 W/(m K)	Internal
Eff. thermal diffusivity	1.4E-7 m²/s	Internal
Spec. heat capacity of melt	1790 J/(kg K)	Internal
RTI, electrical, 0.75mm	140 °C	UL 746B
RTI, electrical, 1.5mm	140 °C	UL 746B
RTI, electrical, 3mm	140 °C	UL 746B
RTI, impact, 0.75mm	140 °C	UL 746B
RTI, impact, 1.5mm	140 °C	UL 746B
RTI, impact, 3mm	140 °C	UL 746B
RTI, strength, 0.75mm	140 °C	UL 746B
RTI, strength, 1.5mm	140 °C	UL 746B
RTI, strength, 3mm	140 °C	UL 746B

Flammability

Burning Behav. at 1.5mm nom. thickn.	HB class	UL 94
Thickness tested	1.5 mm	UL 94
UL recognition	yes	UL 94
Burning Behav. at thickness h	HB class	UL 94
Thickness tested	0.75 mm	UL 94
UL recognition	yes	UL 94
Oxygen index	21 %	ISO 4589-1/-2
Glow Wire Flammability Index, 0.75mm	775 °C	IEC 60695-2-12
Glow Wire Flammability Index, 1.5mm	775 °C	IEC 60695-2-12
Glow Wire Flammability Index, 3mm	825 °C	IEC 60695-2-12
Glow Wire Ignition Temperature, 0.75mm	800 °C	IEC 60695-2-13
Glow Wire Ignition Temperature, 1.5mm	800 °C	IEC 60695-2-13
Glow Wire Ignition Temperature, 3mm	850 °C	IEC 60695-2-13
Glow Wire Temperature, No Flame, 0.75mm	750 °C	IEC 60335-1
Glow Wire Temperature, No Flame, 1mm	750 °C	IEC 60335-1
Glow Wire Temperature, No Flame, 1.5mm	750 °C	IEC 60335-1
Glow Wire Temperature, No Flame, 3mm	850 °C	IEC 60335-1
FMVSS Class	B	ISO 3795 (FMVSS 302)
Burning rate, Thickness 1 mm	<80 mm/min	ISO 3795 (FMVSS 302)



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Electrical properties

Relative permittivity, 100Hz	4.5	IEC 62631-2-1
Relative permittivity, 1MHz	4.1	IEC 62631-2-1
Dissipation factor, 100Hz	300 E-4	IEC 62631-2-1
Dissipation factor, 1MHz	140 E-4	IEC 62631-2-1
Volume resistivity	1E13 Ohm.m	IEC 62631-3-1
Surface resistivity	1E14 Ohm	IEC 62631-3-2
Electric strength	39 kV/mm	IEC 60243-1
Comparative tracking index	300	IEC 60112

Other properties

Humidity absorption, 2mm	0.13 %	Sim. to ISO 62
Water absorption, 2mm	0.83 %	Sim. to ISO 62
Density	1580 kg/m ³	ISO 1183
Density of melt	1320 kg/m ³	Internal

VDA Properties

Fogging, G-value (condensate)	0.1 mg	ISO 6452
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Injection

Drying Recommended	yes	
Drying Temperature	120 °C	
Drying Time, Dehumidified Dryer	4 - 6 h	
Processing Moisture Content	≤0.02 ^[1] %	
Melt Temperature Optimum	285 °C	Internal
Min. melt temperature	280 °C	
Max. melt temperature	300 °C	
Screw tangential speed	≤0.2 m/s	
Mold Temperature Optimum	110 °C	
Min. mould temperature	100 °C	
Max. mould temperature	120 ^[2] °C	
Hold pressure range	≥80 MPa	
Hold pressure time	4 s/mm	
Back pressure	As low as possible	
Ejection temperature	170 °C	Internal

[1]: At levels above 0.02%, strength and toughness will decrease, even though parts may not exhibit surface defects.

[2]: (6mm - 1mm thickness)

Characteristics

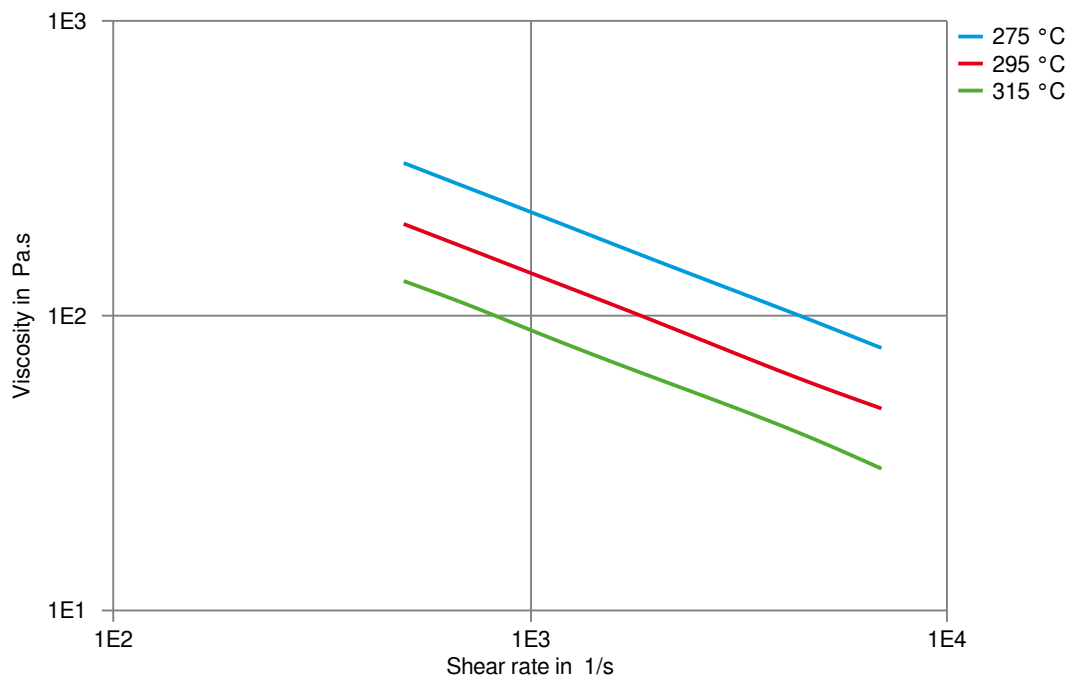
Additives	Release agent
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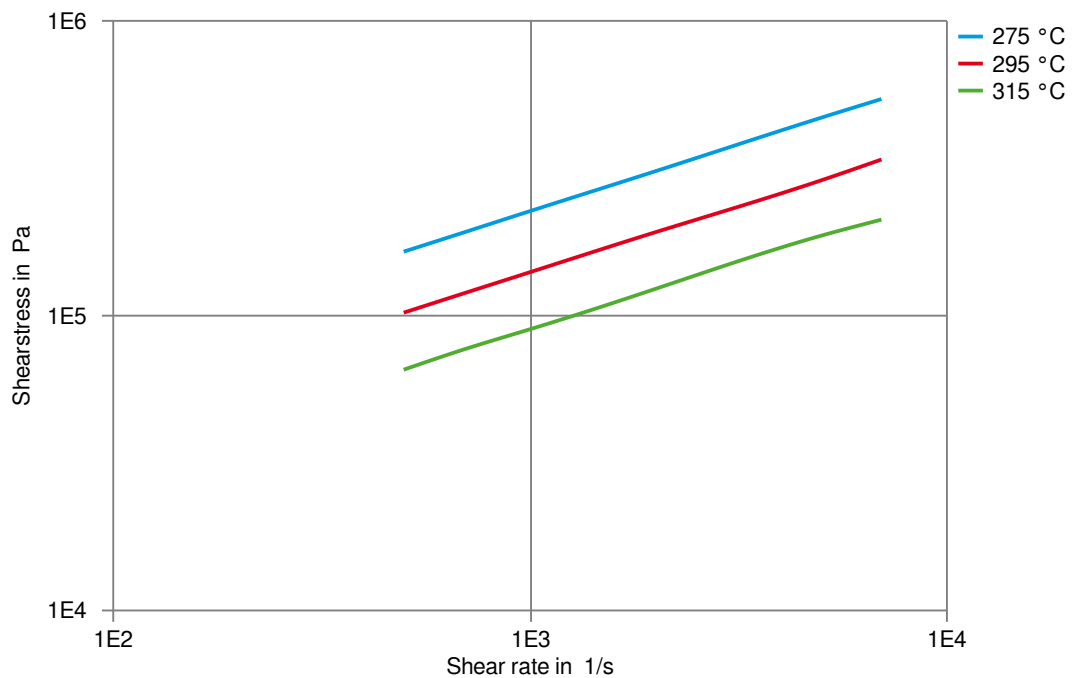
Viscosity-shear rate



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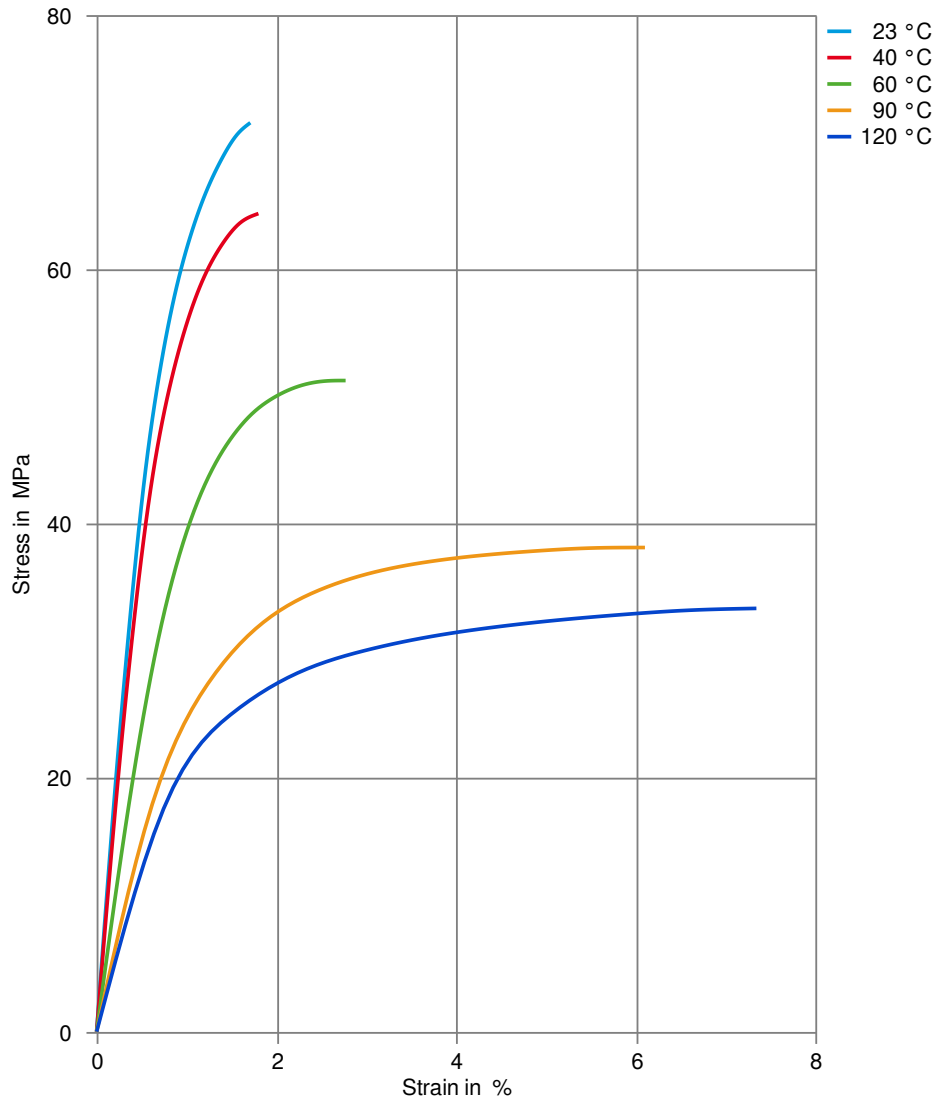
Shearstress-shear rate



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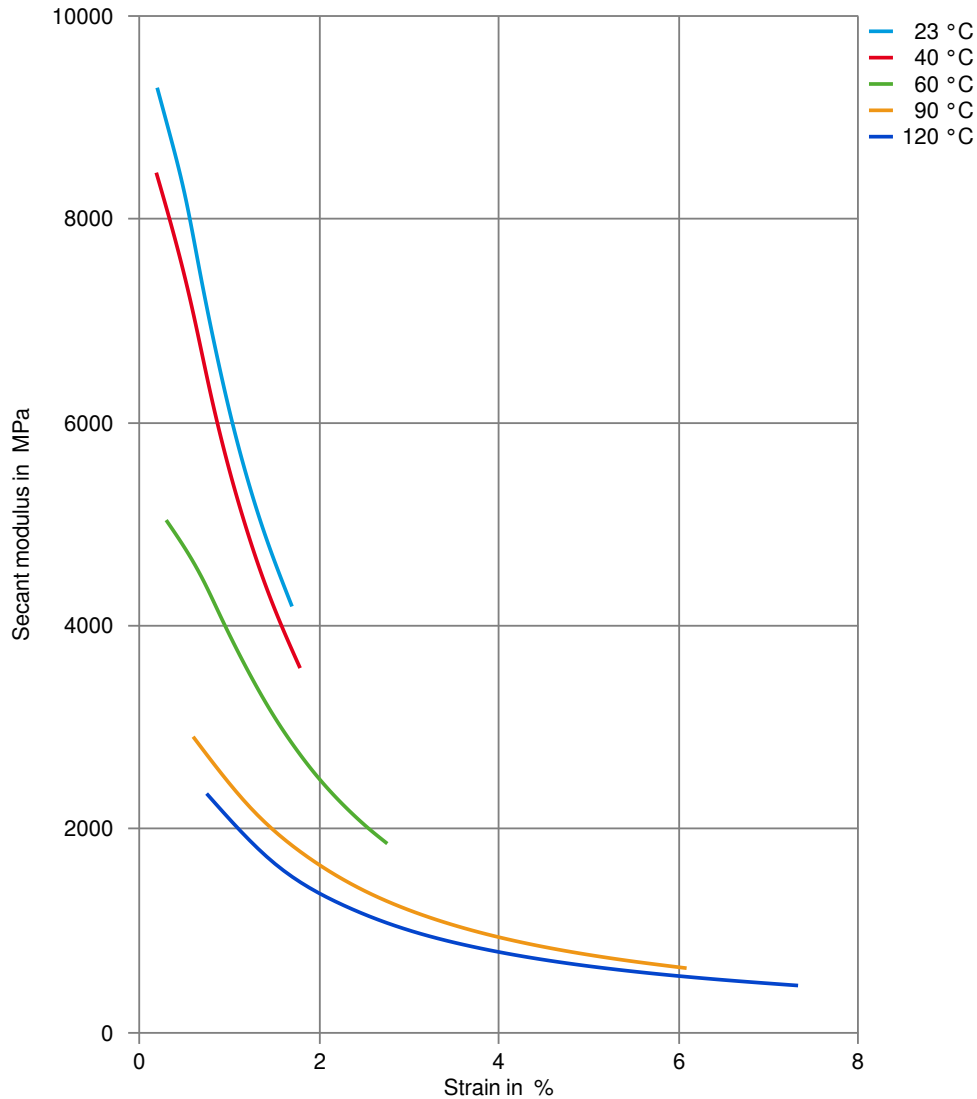
Stress-strain



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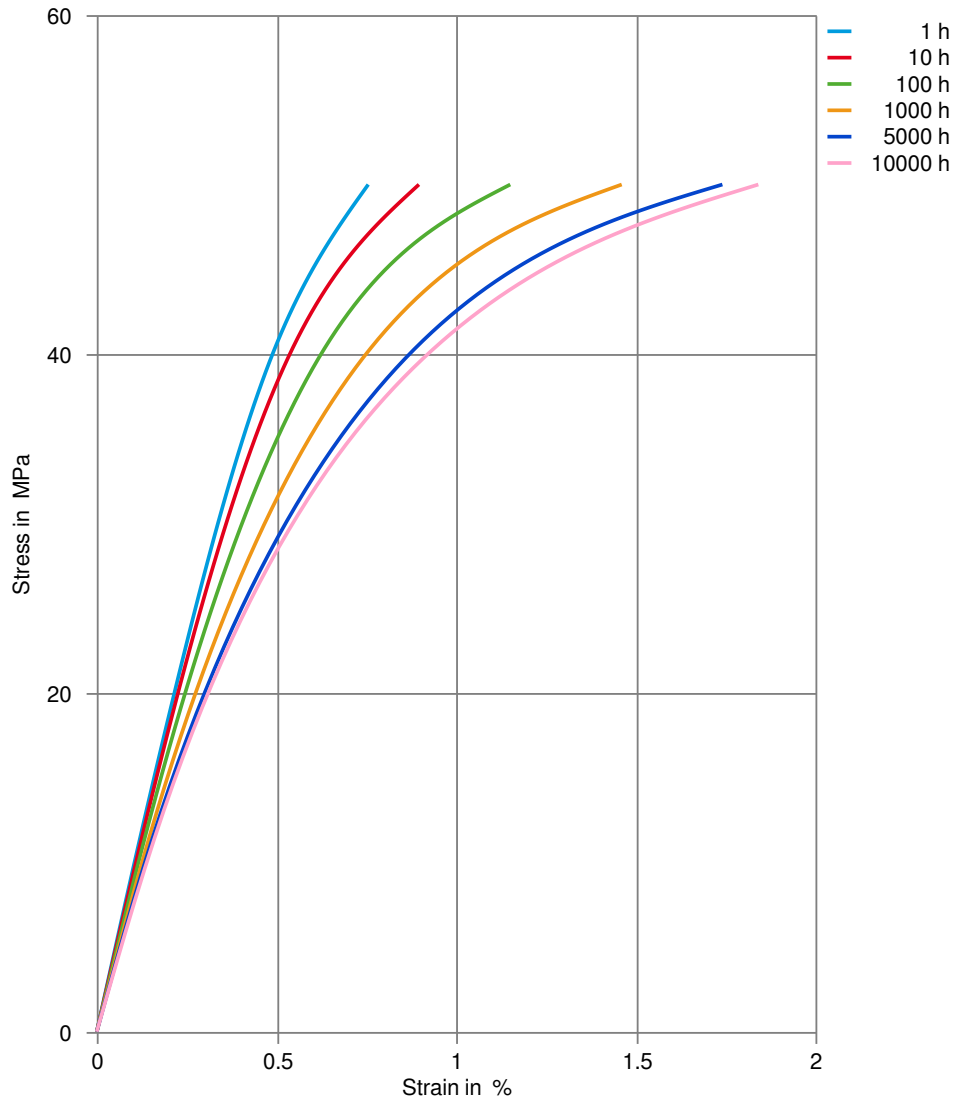
Secant modulus-strain



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Stress-strain (isochronous) 23°C



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Creep modulus-time 23°C

