

Compound No.: 8327

PRECITE® PRELIMINARY E GF 15 ECO black (8327)

E GF 15 ECO

PRECITE® E GF 15 ECO black (8327) is a 15% glass fibre reinforced, medium viscous polyethylene terephthalate (PET) with very high stiffness and toughness even at elevated temperatures. Due to its low moisture absorption, this material is particularly dimensionally stable and therefore perfectly suitable for precision parts in the automotive, E&E and household goods industries, where a very good surface finish is required. The formulations of the sustainable ECO products are partly based on regenerated post-consumer feedstock and thus contribute to reducing the consumption of valuable raw materials.

Properties

Modulus	Strength	Impact	
6.300 MPa	110 MPa	35 kJ/m²	

Sustainability

Recycled content	25 %

Mechanical Properties

1 mm/min d.a.m.	6300 MPa
5 mm/min d.a.m.	110 MPa
5 mm/min d.a.m.	2,1 %
23°C d.a.m.	35 kJ/m²
23°C d.a.m.	4 kJ/m²
	5 mm/min d.a.m. 5 mm/min d.a.m. 23°C d.a.m.



Compound No.: 8327

Thermal Properties

Temperature of deflection under load HDT/A ISO 75	1,8 MPa	210 °C
Melting temperature ISO 11357-3	DSC, 10K/min	255 °C

Flammability

Flammability UL 94	0,8 mm Wall thickness	HB Class

General Properties

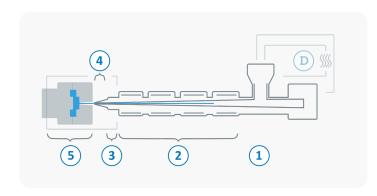
Molding shrinkage	flow	0,2 - 0,4 %
ISO 294-4	transverse	0,8 - 1,0 %





Processing

The values mentioned are recommendations. We only recommend desiccant / dry air dryers or vacuum dryers. Too long a drying time and the resulting residual moisture content below the lower limit can lead to filling problems and surface defects. The specified drying time refers to closed and undamaged bagged material. When processing from previously opened bags or from octabins with polyolefin inliners, a longer drying time may be necessary. It is recommended to check the residual moisture content after the drying process.



D	Drying time	3 - 4 h
	Drying temperature (τ <= -30°C)	120 - 140 °C
	Processing moisture	0 ,02 %
1	Feed section	60 - 80 °C
2	Temperature Zone 1 - Zone 4	270 - 290 °C
3	Nozzle temperature	270 - 295 °C
4	Melt temperature	270 - 290 °C
5	Mold temperature	130 - 160 °C
\Rightarrow	Holding pressure, spec.	300 - 800 bar
	Back pressure, spec.	30 - 100 bar
	Injection speed	medium to high
	Screw speed	8 - 15 m/min