



Edgetek™ ET3400-8002 NHFR RS BK001

Polyethylene Terephthalate

Key Characteristics

Product Description	
30% glass fiber reinforced PET	
General	
Material Status	• Commercial: Active
Regional Availability	• Asia Pacific
Filler / Reinforcement	• Glass Fiber
Appearance	• Black
Processing Method	• Injection Molding

Technical Properties ¹

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Density / Specific Gravity	1.57	1.57	ASTM D792
Molding Shrinkage - Flow	1.5E-3 to 2.0E-3 in/in	0.15 to 0.20 %	Internal Method
Molding Shrinkage - Across Flow	7.5E-3 to 0.011 in/in	0.75 to 1.1 %	Internal Method
Mechanical	Typical Value (English)	Typical Value (SI)	Test Method
Tensile Strength	14500 psi	100 MPa	ASTM D638
Flexural Modulus	1.60E+6 psi	11000 MPa	ASTM D790
Flexural Strength	21800 psi	150 MPa	ASTM D790
Impact	Typical Value (English)	Typical Value (SI)	Test Method
Notched Izod Impact 73°F (23°C), 0.126 in (3.20 mm)	0.94 ft·lb/in	50 J/m	ASTM D256
Thermal	Typical Value (English)	Typical Value (SI)	Test Method
Deflection Temperature Under Load 264 psi (1.8 MPa), Annealed	374 °F	190 °C	ASTM D648
Flammability	Typical Value (English)	Typical Value (SI)	Test Method
Flame Rating (0.06 in (1.6 mm))	V-0	V-0	UL 94

Processing Information

Injection	Typical Value (English)	Typical Value (SI)
Drying Temperature	230 to 266 °F	110 to 130 °C
Drying Time	4.0 to 6.0 hr	4.0 to 6.0 hr
Processing (Melt) Temp	518 to 554 °F	270 to 290 °C
Mold Temperature	158 to 230 °F	70 to 110 °C

Injection Notes

Injection Pressure: MED-HIGH
Hold Pressure: MED-HIGH
Screw Speed: MODERATE
Back Pressure: LOW

Notes

¹ Typical values are not to be construed as specifications.