PBT | KEPEX 3330GF | Glass fiber reinforced grade

- KEPEX 3330GF is a glass fiber 30%-reinforced grade.
- It has superior mechanical, thermal, and electrical properties.
- It is suitable for automotive, electrical & electronics, and industrial parts.

Physical properties	Test Standard	Unit	Value
Filler contents	ISO 1172	%	30
Specific gravity	ISO 1183	-	1.54
Water absorption(23 ℃, 50 %RH)	ISO 62	%	0.03~0.07

Thermal properties	Test Standard	Unit	Value
Melting point(10 ℃/min)	ISO 11357	℃	220
Heat deflection temperature(0.45 MPa)	ISO 75	℃	220
Heat deflection temperature(1.8 MPa)	ISO 75	℃	210
Flammability(t = 0.8 mm)	UL 94	Class	HB

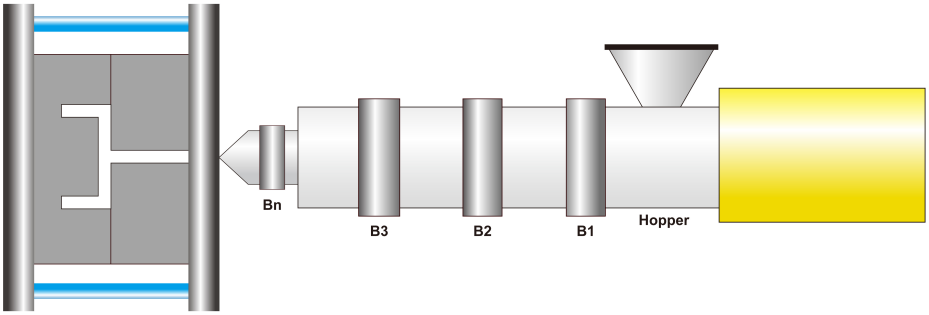
Mechanical properties	Test Standard	Unit	Value
Tensile stress	ISO 527	MPa	155
Elongation at break	ISO 527	%	3.0
Tensile modulus	ISO 527	MPa	9100
Flexural strength	ISO 178	MPa	240
Flexural modulus	ISO 178	MPa	9200
Charpy impact strength(Notched) @ 23℃	ISO 179/1eA	kJ/m^2	11.0
Charpy impact strength(Notched) @ -30℃	ISO 179/1eA	kJ/m^2	7.0
Rockwell Hardness(R-Scale)	ISO 2039	-	119

Electrical properties	Test Standard	Unit	Value
Permittivity(60 Hz)	ASTM D150	-	3.4
Volume resistivity	IEC 60093	Ω/ cm	10^{16}

Revision No : 1 (2015-02-13)

Print Date : 2019-12-31

Injection molding condition



Pre-drying (Suggested max. moisture : 0.05%)

It is recommend to dry material at 120℃ ~ 130℃(248℉ ~ 266℉) for 3 h ~ 5 h at dryer.

Temperature

Mold temperature : 70 ℃ ~ 90 ℃(158 ℉ ~ 194 ℉)
Barrel temperature : 230 ℃ ~ 250 ℃(446 ℉ ~ 482 ℉)

Mold	Bn(Nozzle)	B3(Metering)	B2(Compression)	B1(Feeding)	Hopper
70 ~ 90 ℃	250 ℃	250 ℃	240 ℃	230 ℃	60 ~ 80 ℃
158 ~ 194 ℉	482 ℉	482 ℉	464 ℉	446 ℉	140 ~ 176 ℉

Plastification

Screw speed : 80 ~ 120 rpm
Back pressure : 5 ~ 10 kgf/cm^2

Disclaimer