

Impet® 330

Polyethylene Terephthalate

Ticona

Product Description			
Impet 330 is a 30% glass-reinforced injection moldable PET polyester. It provides an excellent combination of strength, stiffness, and high temperature resistance.			
General			
Filler / Reinforcement	• Glass Fiber Reinforcement, 30% Filler by Weight		
Features	• Good Stiffness	• Good Strength	• High Heat Resistance
RoHS Compliance	• Contact Manufacturer		
Processing Method	• Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.58	g/cm ³	ASTM D792 ISO 1183
Molding Shrinkage - Flow			
--	0.70	%	ASTM D955
--	0.10 to 0.30	%	ISO 294-4
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	11000	MPa	ISO 527-2/1A/1
Tensile Strength			
Break, 23°C	161	MPa	ASTM D638
Break	170	MPa	ISO 527-2/1A/5
Tensile Elongation			
Break, 23°C	2.4	%	ASTM D638
Break	2.6	%	ISO 527-2/1A/5
Flexural Modulus (23°C)	11000	MPa	ISO 178
Flexural Strength (23°C)	270	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength (23°C)	11.0	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, Unannealed	240	°C	ISO 75-2/B
1.8 MPa, Unannealed	222	°C	ASTM D648
1.8 MPa, Unannealed	224	°C	ISO 75-2/A
Melting Temperature (DSC)	250	°C	ISO 11357
CLTE			ISO 11359-2
Flow	0.000032	cm/cm/°C	
Transverse	0.000077	cm/cm/°C	
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	3.1E+14	ohms	ASTM D257
Volume Resistivity	3.3E+15	ohm·cm	ASTM D257
Dielectric Constant			ASTM D150
1000 Hz	3.20		
10000 Hz	3.20		
1E+6 Hz	3.10		
Dissipation Factor			ASTM D150
1000 Hz	0.010		
10000 Hz	0.012		
Arc Resistance	129	sec	ASTM D495
Flammability	Nominal Value	Unit	Test Method
Flame Rating - UL (0.780 mm)	HB		UL 94
Additional Information	Nominal Value	Unit	Test Method
Comparative Tracking Index	175	V	ASTM D3638

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Injection	Nominal Value	Unit
Suggested Max Regrind	25	%
Rear Temperature	260 to 271	°C
Middle Temperature	271 to 277	°C
Front Temperature	277 to 282	°C
Nozzle Temperature	277 to 288	°C
Processing (Melt) Temp	271 to 299	°C
Mold Temperature	110 to 121	°C
Injection Rate	Moderate-Fast	
Back Pressure	0.00 to 0.172	MPa
Screw Speed	50 to 75	rpm

Notes

¹ Typical properties: these are not to be construed as specifications.