

## MRC Polymers MAXNITE™ 500 GF15 PET, 15% Glass Fiber Filled (discontinued \*\*)

Category : Polymer , Thermoplastic , Polyester, TP , Polyethylene Terephthalate (PET) , Polyethylene Terephthalate (PET), 20% Glass Reinforced

### Material Notes:

Information provided by MRC Polymers Inc.

Order this product through the following link:

[http://www.lookpolymers.com/polymer\\_MRC-Polymers-MAXNITE-500-GF15-PET-15-Glass-Fiber-Filled-nbspdiscontinued-.php](http://www.lookpolymers.com/polymer_MRC-Polymers-MAXNITE-500-GF15-PET-15-Glass-Fiber-Filled-nbspdiscontinued-.php)

| Physical Properties | Metric    | English   | Comments   |
|---------------------|-----------|-----------|------------|
| Specific Gravity    | 1.43 g/cc | 1.43 g/cc | ASTM D792  |
| Filler Content      | 13 - 17 % | 13 - 17 % | ASTM D2584 |

| Mechanical Properties     | Metric                             | English                               | Comments  |
|---------------------------|------------------------------------|---------------------------------------|-----------|
| Tensile Strength at Break | 82.7 MPa                           | 12000 psi                             | ASTM D638 |
| Elongation at Break       | 2.0 %                              | 2.0 %                                 | ASTM D638 |
| Flexural Strength         | 131 MPa                            | 19000 psi                             | ASTM D790 |
| Flexural Modulus          | 5.86 GPa                           | 850 ksi                               | ASTM D790 |
| Izod Impact, Notched      | 0.641 J/cm<br>@Temperature 22.8 °C | 1.20 ft-lb/in<br>@Temperature 73.0 °F | ASTM D256 |

| Thermal Properties                          | Metric | English | Comments  |
|---------------------------------------------|--------|---------|-----------|
| Deflection Temperature at 1.8 MPa (264 psi) | 210 °C | 410 °F  | ASTM D648 |

| Processing Properties     | Metric        | English      | Comments                    |
|---------------------------|---------------|--------------|-----------------------------|
| Rear Barrel Temperature   | 260 - 282 °C  | 500 - 540 °F |                             |
| Middle Barrel Temperature | 260 - 288 °C  | 500 - 550 °F |                             |
| Front Barrel Temperature  | 266 - 288 °C  | 510 - 550 °F |                             |
| Nozzle Temperature        | 271 - 299 °C  | 520 - 570 °F | reverse tapered recommended |
| Melt Temperature          | 271 - 293 °C  | 520 - 560 °F |                             |
| Mold Temperature          | 82.2 - 104 °C | 180 - 220 °F | thick wall - thin wall      |
| Drying Temperature        | 116 - 135 °C  | 240 - 275 °F |                             |
| Dry Time                  | 4 - 6 hour    | 4 - 6 hour   |                             |

| Processing Properties | Metric            | English                                 | Comments                    |
|-----------------------|-------------------|-----------------------------------------|-----------------------------|
| Moisture Content      | <= 0.020 %        | <= 0.010 %                              |                             |
| Dew Point             | <= -17.8 °C       | <= 0.000 °F                             |                             |
| Drying Air Flow Rate  | 22.7 - 28.3 l/min | 0.800 - 1.00 ft <sup>3</sup> /min (CFM) | per lb/hour resin processed |
| Injection Pressure    | 68.9 - 138 MPa    | 10000 - 20000 psi                       |                             |
| Back Pressure         | 0.345 - 1.21 MPa  | 50.0 - 175 psi                          | keep minimum                |
| Cushion               | 0.635 cm          | 0.250 in                                |                             |
| Screw Speed           | 20 - 50 rpm       | 20 - 50 rpm                             |                             |

| Descriptive Properties | Value                        | Comments |
|------------------------|------------------------------|----------|
| Dryer                  | Dehumidified hopper          |          |
| Fill Rate              | Moderate-Fast                |          |
| Hold Pressure          | 40-60% of injection pressure |          |
| Packing Pressure       | 50-75% of injection pressure |          |

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