

# EnCounter 245GF

PET



Product Description					
45% Glass Reinforced PET					
General Properties					
Appearance	Black, Natural or Colors				
Processing Methods	Injection Molding				
Applications	Automotive, Electrical, Electronics, General Industries				
Mechanical Properties	Test Method	English Units		S.I. Units	
Tensile Strength @ Yield	ASTM D638	25,400	psi	175	MPa
Tensile Modulus	ASTM D638	2,250,000	psi	15517	MPa
Tensile Elongation at Break	ASTM D638	2	%	2	%
Flexural Modulus	ASTM D790	2,030,000	psi	14,000	MPa
Notched Izod Impact (73°F)	ASTM D256	1.6	ft-lb/in	87	J/m
Physical Properties	Test Method	English Units		S.I. Units	
Specific Gravity	ASTM D792	1.70	sp gr	1.70	sp gr
Mold Shrink - Flow: 0.126 in (3.20 mm)	ASTM D955	0.003 - 0.009	in/in	0.076 - 0.229	mm/mm
Filler Content		45.0	%	45.0	%
Flame Rating 0.030	UL 94	HB		HB	
Flame Rating 0.059	UL 94	HB		HB	
Thermal Properties	Test Method	English Units		S.I. Units	
Heat Deflection Temperature @ 66 psi	ASTM D648	446	°F	230	°C
Injection Molding		Value			
Drying Temperature		250	°F		
Drying Time		4.00	hrs		
Suggested Maximum Moisture		0.02	%		
Rear Barrel Temperatures		500 - 520	°F		
Middle Barrel Temperatures		520 - 540	°F		
Front Barrel Temperatures		540 - 560	°F		
Nozzle Temperature		520 - 560	°F		
Melt (processing) Temperatures		520 - 560	°F		
Mold Temperatures		205 - 250	°F		
Back Pressure		50 - 100	psi		

These Data Sheet Values are Typical Values and are not intended for specification purposes. These values should only be used as a guide and no assurances by EnCom, Inc. can be granted that all molded articles will exhibit duplicate properties as those listed above. Each material user should perform their own testing for suitability.