Celanese
The chemistry inside innovation™

IMPET® HD250

A highly filled PET, ceramic-like feel.
A highly filled PET which has an excellent balance of mechanical properties, processability and high density. Impet HD250 is specifically designed to exhibit a ceramic-like feel.

Rheological properties

Moulding shrinkage, parallel	0.3 - 0.6	%	ISO 294-4, 2577
Moulding shrinkage, normal	0.4 - 0.6	%	ISO 294-4, 2577

Typical mechanical properties

Stress at break, 5mm/min	42	MPa	ISO 527-1/-2
Strain at break, 5mm/min	1.1	%	ISO 527-1/-2
Flexural Modulus	7750	MPa	ISO 178
Flexural Strength	72.5	MPa	ISO 178
Charpy notched impact strength, 23°C	4	kJ/m²	ISO 179/1eA
Charpy notched impact strength, -30°C	3.5	kJ/m²	ISO 179/1eA

Thermal properties

Temp. of deflection under load, 1.8 MPa	201	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	242	°C	ISO 75-1/-2
Thermal conductivity	0.6	W/(m K)	ISO 22007-2

Electrical properties

Volume resistivity	1E14	Ohm.m	IEC 62631-3-1
Surface resistivity	300	Ohm	IEC 62631-3-2
Comparative tracking index	PLC 0	PLC	UL 746A
Arc Resistance	124	s	Internal

Other properties

Density	2500	kg/m³	ISO 1183

Injection

Drying Temperature	135	°C
Drying Time, Dehumidified Dryer	4	h
Processing Moisture Content	0.01	%
Max. mould temperature	120	°C

Processing Texts

Pre-drying	If this material is to be dried overnigh, temperatures should be reduced to 102 deg C (215 deg F).