

# Rynite® 815ER NC010

## THERMOPLASTIC POLYESTER RESIN

Common features of Rynite® thermoplastic polyester include mechanical and physical properties such as excellent balance of strength and stiffness, dimensional stability, creep resistance, heat resistance, high surface gloss and good inherent electrical properties at elevated temperature. It can be processed over a broad temperature range and has excellent flow properties.

Rynite® thermoplastic polyester resins are typically used in demanding applications in the automotive, electrical and electronics, appliances where they successfully replace metals and thermosets, as well as other thermoplastic polymers.

Rynite® 815ER NC010 is a 15% Glass Reinforced, Toughened, Polyethylene Terephthalate Developed for Encapsulation Applications.

### Product information

Resin Identification	PET-IGF15	ISO 1043
Part Marking Code	>PET-IGF15<	ISO 11469

### Rheological properties

Moulding shrinkage, parallel	0.3 %	ISO 294-4, 2577
Moulding shrinkage, normal	0.8 %	ISO 294-4, 2577
Moulding shrinkage, parallel, annealed	0.5 %	ISO 294-4
Moulding shrinkage, normal, annealed	1.2 %	ISO 294-4

### Typical mechanical properties

Tensile modulus	4700 MPa	ISO 527-1/-2
Tensile stress at break, 5mm/min	79 MPa	ISO 527-1/-2
Tensile strain at break, 5mm/min	5 %	ISO 527-1/-2
Flexural modulus	3550 MPa	ISO 178
Charpy impact strength, 23°C	55 kJ/m <sup>2</sup>	ISO 179/1eU
Charpy impact strength, -30°C	25 kJ/m <sup>2</sup>	ISO 179/1eU
Charpy notched impact strength, 23°C	11 kJ/m <sup>2</sup>	ISO 179/1eA
Charpy notched impact strength, -30°C	8 kJ/m <sup>2</sup>	ISO 179/1eA
Izod notched impact strength, 23°C	13 kJ/m <sup>2</sup>	ISO 180/1A
Izod notched impact strength, -30°C	7.7 kJ/m <sup>2</sup>	ISO 180/1A
Hardness, Rockwell, M-scale	58	ISO 2039-2
Hardness, Rockwell, R-scale	111	ISO 2039-2
Poisson's ratio	0.36	

### Thermal properties

Melting temperature, 10°C/min	250 °C	ISO 11357-1/-3
Temperature of deflection under load, 1.8 MPa	205 °C	ISO 75-1/-2
Temperature of deflection under load, 0.45 MPa	235 °C	ISO 75-1/-2
Vicat softening temperature, 50°C/h 50N	205 °C	ISO 306
Coeff. of linear therm. expansion, parallel, -40-23°C	98 E-6/K	ISO 11359-1/-2
Coefficient of linear thermal expansion (CLTE), parallel	20 E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, parallel, 55-160°C	109 E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal, -40-23°C	40 E-6/K	ISO 11359-1/-2
Coefficient of linear thermal expansion (CLTE), normal	120 E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal, 55-160°C	32 E-6/K	ISO 11359-1/-2

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Effective thermal diffusivity, flow	9E-8 m <sup>2</sup> /s	ISO 22007-4
RTI, electrical, 0.75mm	140 °C	UL 746B
RTI, electrical, 1.5mm	140 °C	UL 746B
RTI, electrical, 3.0mm	140 °C	UL 746B
RTI, impact, 0.75mm	120 °C	UL 746B
RTI, impact, 1.5mm	120 °C	UL 746B
RTI, impact, 3.0mm	120 °C	UL 746B
RTI, strength, 0.75mm	140 °C	UL 746B
RTI, strength, 1.5mm	140 °C	UL 746B
RTI, strength, 3.0mm	140 °C	UL 746B

### Flammability

Burning Behav. at 1.5mm nom. thickn.	HB class	IEC 60695-11-10
Thickness tested	1.5 mm	IEC 60695-11-10
UL recognition	yes	UL 94
Burning Behav. at thickness h	HB class	IEC 60695-11-10
Thickness tested	0.75 mm	IEC 60695-11-10
UL recognition	yes	UL 94
Oxygen index	19 %	ISO 4589-1/-2
Glow Wire Flammability Index, 0.75mm	675 °C	IEC 60695-2-12
Glow Wire Flammability Index, 1.5mm	675 °C	IEC 60695-2-12
Glow Wire Flammability Index, 3.0mm	750 °C	IEC 60695-2-12
Glow Wire Ignition Temperature, 0.75mm	700 °C	IEC 60695-2-13
Glow Wire Ignition Temperature, 1.5mm	700 °C	IEC 60695-2-13
Glow Wire Ignition Temperature, 3.0mm	775 °C	IEC 60695-2-13
FMVSS Class	B	ISO 3795 (FMVSS 302)
Burning rate, Thickness 1 mm	36 mm/min	ISO 3795 (FMVSS 302)

### Electrical properties

Relative permittivity, 100Hz	4.5	IEC 62631-2-1
Relative permittivity, 1MHz	3.9	IEC 62631-2-1
Dissipation factor, 100Hz	654 E-4	IEC 62631-2-1
Dissipation factor, 1MHz	236 E-4	IEC 62631-2-1
Volume resistivity	1E11 Ohm.m	IEC 62631-3-1
Surface resistivity	1E13 Ohm	IEC 62631-3-2
Electric strength	38 kV/mm	IEC 60243-1
Comparative tracking index	350	IEC 60112
Comparative tracking index, 23 °C	2 PLC	UL 746A

### Physical/Other properties

Humidity absorption, 2mm	0.25 %	Sim. to ISO 62
Water absorption, 2mm	2.5 %	Sim. to ISO 62
Density	1390 kg/m <sup>3</sup>	ISO 1183

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### Injection

Drying Recommended	yes
Drying Temperature	120 °C
Drying Time, Dehumidified Dryer	4 - 6 h
Processing Moisture Content	≤0.02 <sup>[1]</sup> %
Melt Temperature Optimum	285 °C
Min. melt temperature	270 °C
Max. melt temperature	290 °C
Screw tangential speed	≤0.2 m/s
Mold Temperature Optimum	95 °C
Min. mould temperature	75 °C
Max. mould temperature	95 °C
Hold pressure range	≥80 MPa
Hold pressure time	4 s/mm
Back pressure	As low as possible
Ejection temperature	170 °C

[1]: At levels above 0.02%, strength and toughness will decrease, even though parts may not exhibit surface defects.

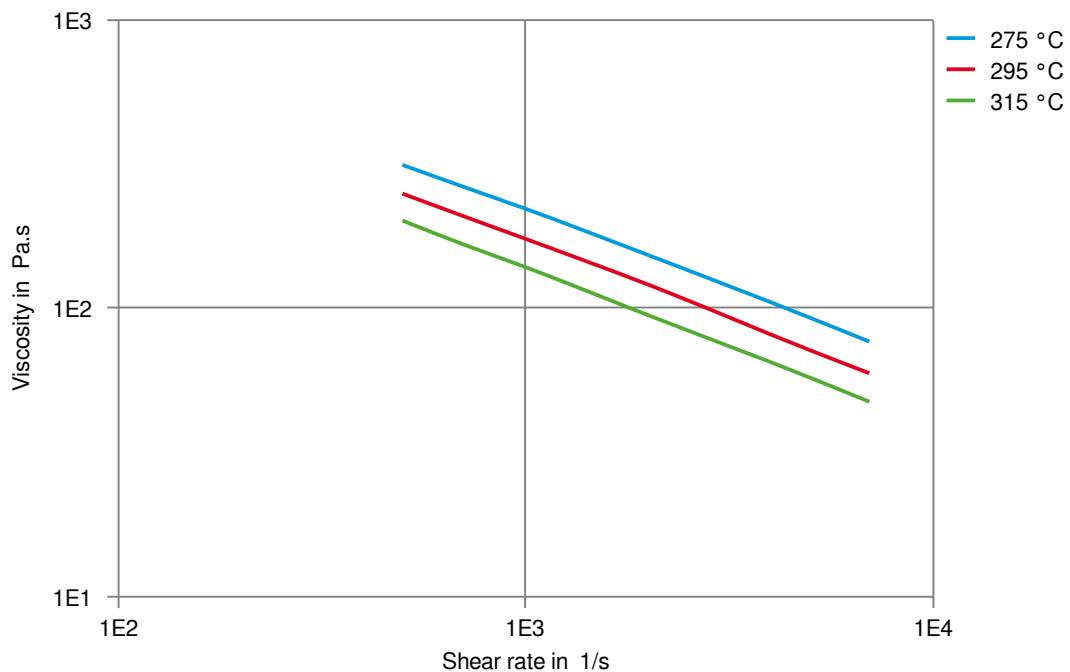
### Characteristics

Processing	Injection Moulding
Delivery form	Pellets
Additives	Release agent

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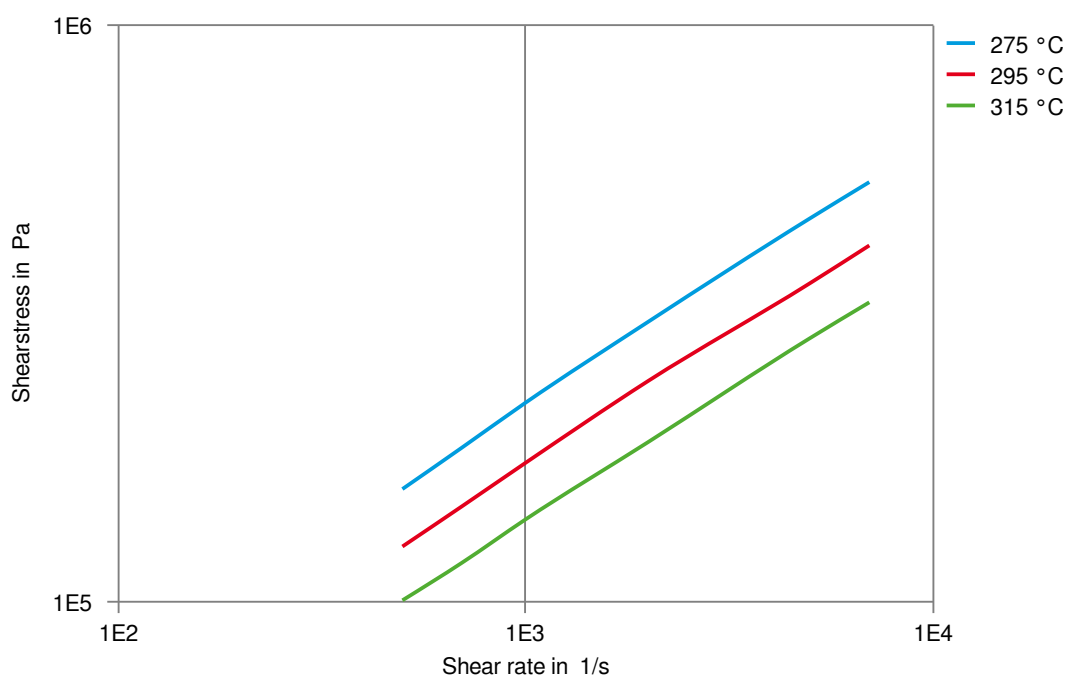
Viscosity-shear rate



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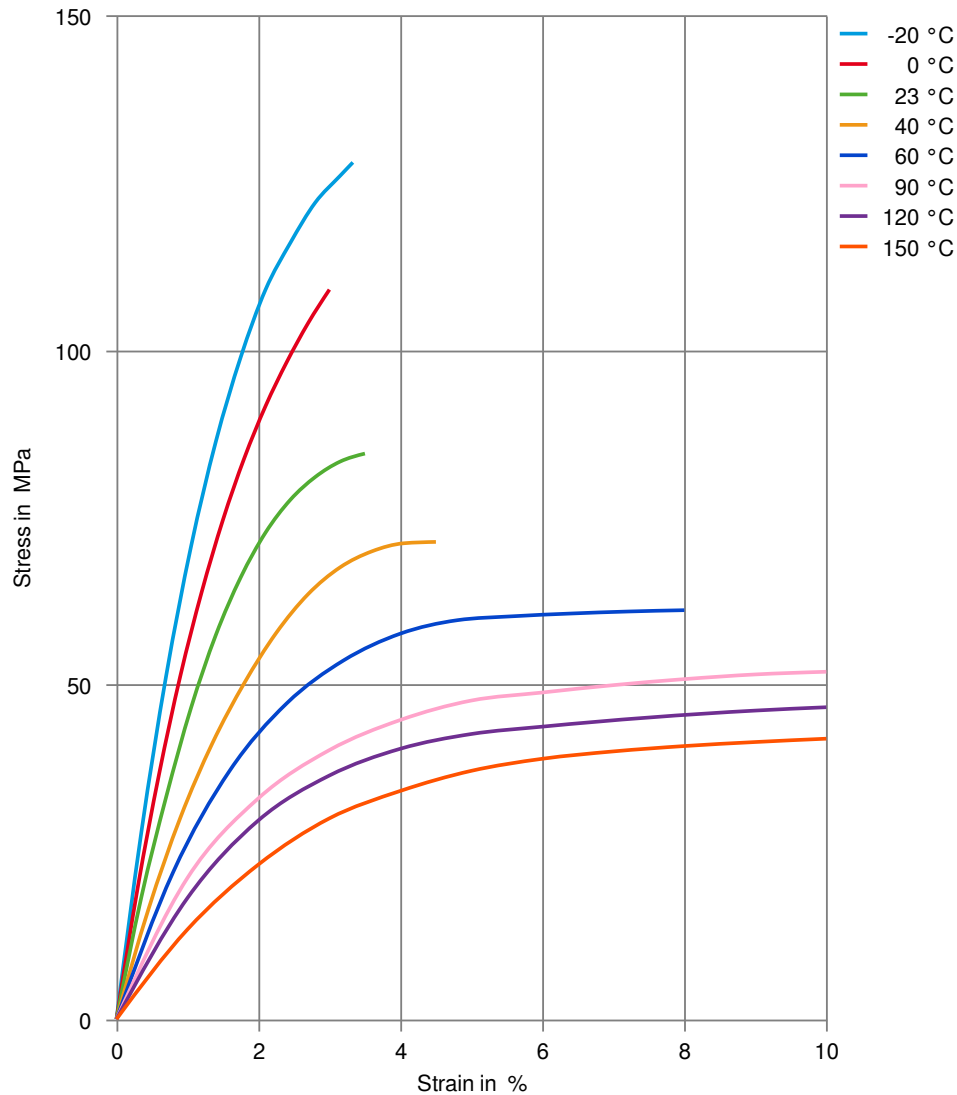
Shearstress-shear rate



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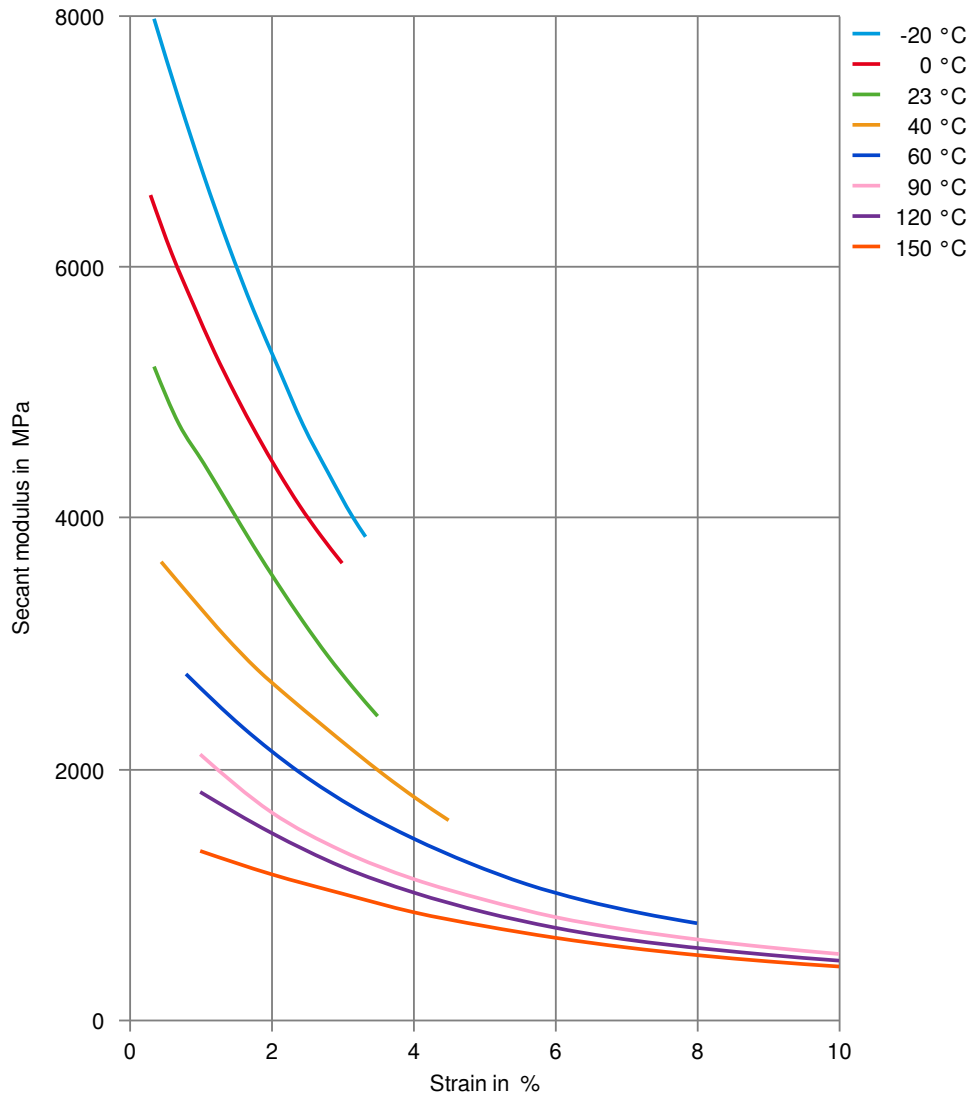
## Stress-strain



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### Secant modulus-strain



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