

Rynite® FR531 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® FR531 NC010 is a 45% glass/mineral reinforced, flame retardant, modified polyethylene terephthalate resin, with improved CTI performance.

Product information

Resin Identification	PET-(GF+MD)38FR(17)	ISO 1043
Part Marking Code	>PET-(GF+MD)38FR(17)<	ISO 11469

Rheological properties

Moulding shrinkage, parallel	0.1 %	ISO 294-4, 2577
Moulding shrinkage, normal	0.7 %	ISO 294-4, 2577
Postmoulding shrinkage, normal, 48h at 80°C	0.2 %	ISO 294-4
Postmoulding shrinkage, parallel, 48h at 80°C	0.1 %	ISO 294-4

Typical mechanical properties

Tensile modulus	12600 MPa	ISO 527-1/-2
Tensile stress at break, 5mm/min	129 MPa	ISO 527-1/-2
Tensile strain at break, 5mm/min	1.6 %	ISO 527-1/-2
Charpy impact strength, 23°C	36 kJ/m ²	ISO 179/1eU
Charpy notched impact strength, 23°C	10 kJ/m ²	ISO 179/1eA
Poisson's ratio	0.33	

Thermal properties

Melting temperature, 10°C/min	247 °C	ISO 11357-1/-3
Glass transition temperature, 10°C/min	90 °C	ISO 11357-1/-3
Temperature of deflection under load, 1.8 MPa	218 °C	ISO 75-1/-2
RTI, electrical, 0.75mm	155 °C	UL 746B
RTI, electrical, 1.5mm	155 °C	UL 746B
RTI, electrical, 3.0mm	155 °C	UL 746B
RTI, impact, 0.75mm	155 °C	UL 746B
RTI, impact, 1.5mm	155 °C	UL 746B
RTI, impact, 3.0mm	155 °C	UL 746B
RTI, strength, 0.75mm	155 °C	UL 746B
RTI, strength, 1.5mm	155 °C	UL 746B
RTI, strength, 3.0mm	155 °C	UL 746B

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Flammability

Burning Behav. at 1.5mm nom. thickn.	V-0 class	IEC 60695-11-10
Thickness tested	1.5 mm	IEC 60695-11-10
UL recognition	yes	UL 94
Burning Behav. at thickness h	V-0 class	IEC 60695-11-10
Thickness tested	0.75 mm	IEC 60695-11-10
UL recognition	yes	UL 94
Burning Behav. 5V at thickness h	5VA class	IEC 60695-11-20
Thickness tested	2 mm	IEC 60695-11-20
UL recognition	yes	UL 94
Glow Wire Flammability Index, 0.75mm	960 °C	IEC 60695-2-12
Glow Wire Flammability Index, 1.5mm	960 °C	IEC 60695-2-12
Glow Wire Flammability Index, 2.0mm	960 °C	IEC 60695-2-12
Glow Wire Flammability Index, 3.0mm	960 °C	IEC 60695-2-12
Glow Wire Ignition Temperature, 0.75mm	900 °C	IEC 60695-2-13
Glow Wire Ignition Temperature, 1.5mm	900 °C	IEC 60695-2-13
Glow Wire Ignition Temperature, 2.0mm	900 °C	IEC 60695-2-13
Glow Wire Ignition Temperature, 3.0mm	875 °C	IEC 60695-2-13
Glow Wire Temperature, No Flame, 1mm	850 °C	IEC 60335-1
Glow Wire Temperature, No Flame, 2mm	800 °C	IEC 60335-1
FMVSS Class	DNI	ISO 3795 (FMVSS 302)

Electrical properties

Relative permittivity, 100Hz	4.6	IEC 62631-2-1
Relative permittivity, 1MHz	4.3	IEC 62631-2-1
Dissipation factor, 100Hz	43.7 E-4	IEC 62631-2-1
Dissipation factor, 1MHz	135 E-4	IEC 62631-2-1
Volume resistivity	>1E13 Ohm.m	IEC 62631-3-1
Surface resistivity	1E13 Ohm	IEC 62631-3-2
Electric strength	34 kV/mm	IEC 60243-1
Comparative tracking index	325	IEC 60112
Comparative tracking index, 23°C	2 PLC	UL 746A

Physical/Other properties

Density	1830 kg/m ³	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 ^[1] %
Melt Temperature Optimum	280 °C
Min. melt temperature	270 °C
Max. melt temperature	290 °C
Screw tangential speed	≤0.2 m/s
Mold Temperature Optimum	110 °C
Min. mould temperature	100 °C
Max. mould temperature	120 ^[2] °C

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Hold pressure range	≥80 MPa
Hold pressure time	4 s/mm
Back pressure	As low as MPa possible
Ejection temperature	170 °C

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

[2]: (6mm - 1mm thickness)

Characteristics

Processing	Injection Moulding
Delivery form	Pellets
Additives	Flame retardant
Special characteristics	Flame retardant