

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

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|------------------------------|-------------|-----------------|
| 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

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|---------------------------------------|-----------------------|--------------|
| 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/m ² | ISO 179/1eA |
| Charpy notched impact strength, -30°C | 3.5 kJ/m ² | ISO 179/1eA |

Thermal properties

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|--|-------------|-------------|
| 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

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|----------------------------|------------|---------------|
| 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

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|---------|------------------------|----------|
| Density | 2500 kg/m ³ | ISO 1183 |
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Injection

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

Processing Texts

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