

Technical data

Privat: KEBATER PET L04 040

KEBATER PET L04 040 is a colorless, medium viscosity PET (polyethylene terephthalate) suitable for direct food contact applications. The material is supplied as crystallized granules. This grade has been specially developed for applications requiring high transparency and a low crystallization rate.

Polymer: PET

ISO designation: PET-FC

Productgroup: Our entire range

Brief description of the product family:

KEBATER is the trade name of our range of thermoplastic polyesters. KEBATER products are characterized by good stiffness and strength, excellent electrical properties, advantageous fire properties and a good price-performance ratio. The product range includes PBT and PBT blends in different variants: unreinforced and glass fiber reinforced, impact modified, flame retardant, warp optimized as well as other compounds tailored to special requirements.

Properties:

amorphous, dimensionally stable, compliant for food contact (according to 10/2011 EC), semi-crystalline

Typical areas of application:

Cover, Filter cups, Housing, industrial goods, Cosmetic packaging, Food packaging, Toys, Sports & Leisure Articles

Industries:

Household appliances, Industry, Agriculture, Food processing industry, Sanitary industry, Sports & Recreation

Physical properties

Density in kg/m ³ ISO 1183-1	1340.00
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Mechanical properties

E-modulus in MPa ISO 527-1	2.500
Yield stress in MPa ISO 527-1	60
Elongation at yield in % ISO 527-1	4,0
Elongation at break in % ISO 527-1	> 80
Impact strength (Charpy) at 23°C in kJ/m ² ISO 179-1eU	270
Notched impact strength (Charpy) at 23°C in kJ/m ² ISO 179-1eA	3,5

Rheological properties

Melt flow rate MFR (test condition)	285°C/2,16kg
Melt flow rate MFR in g/10min ISO 1133	16 g/10min

Thermal properties

Melting temperature (DSC, 10°C/min) in °C ISO 11357-1/-3	240
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Thermal properties

Heat deflection temperature HDT (1.80 MPa) in °C ISO 75-1/-2	62
Heat deflection temperature HDT (0.45 MPa) in °C ISO 75-1/-2	69
Glass transition temperature in °C DIN EN ISO 11357-1	77
Vicat softening temperature (50°C/h 50N) in °C DIN EN ISO 306	75

Processing instructions:**Pre-drying:**

Type of dryer: Dry air dryer.

Processing residual moisture: <0.005%.

drying temperature: max. 150°C

typical drying time: 4 – 7h

Processing recommendations for amorphous processing:

Melt temperature: 270 – 290°C

mold temperature: <20°C

Injection speed: slow to medium

Back pressure: 40 to 80 bar specific

Holding pressure profile: hold 50 to 70 % of the injection pressure for 1 to 2 s and then allow to fall over a ramp. For very thin-walled or thick-walled parts, the optimum holding pressure may differ from the percentage recommendation.

Legal notices:

The information in this data sheet is based on our current knowledge and experience. Due to the wide range of possible influences during processing and application of our products, they do not exempt the processor from carrying out his own tests and trials. A legally binding assurance of certain properties or suitability for a specific application cannot be derived from our information.

* FE products are development products which are still in the trial phase. Technical data may still change in the course of product and process development. No final decision has yet been made on the commercialization of FE products. We reserve the right to discontinue the manufacture of FE products without giving further reasons.

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