

DuPont™ Rynite® 545 BK504

THERMOPLASTIC POLYESTER RESIN

Product Information

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® 545 BK504 is a 45% glass reinforced modified polyethylene terephthalate resin.

General information	Value	Unit	Test Standard
Resin Identification	PET-GF45	-	ISO 1043
Part Marking Code	PET-GF45	-	ISO 11469
Rheological properties	Value	Unit	Test Standard
Moulding shrinkage, parallel	0.2	%	ISO 294-4, 2577
Moulding shrinkage, normal	0.8	%	ISO 294-4, 2577
Mechanical properties	Value	Unit	Test Standard
Tensile Modulus	15500	MPa	ISO 527-1/-2
Stress at break	175	MPa	ISO 527-1/-2
Strain at break	1.9	%	ISO 527-1/-2
Flexural Modulus	14000	MPa	ISO 178
Poisson's ratio	0.33	-	ISO 527-1/-2
Charpy impact strength, 23°C	60	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, 23°C	11	kJ/m ²	ISO 179/1eA
Thermal properties	Value	Unit	Test Standard
Melting temperature, 10°C/min	249	°C	ISO 11357-1/-3
Temp. of deflection under load, 1.8 MPa	230	°C	ISO 75-1/-2
Coeff. of linear therm. expansion, parallel	17	E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal	85	E-6/K	ISO 11359-1/-2
RTI, electrical			UL 746B
0.75mm	140	°C	
1.5mm	140	°C	
3mm	140	°C	
RTI, impact			UL 746B
0.75mm	140	°C	
1.5mm	140	°C	
3mm	140	°C	
RTI, strength			UL 746B
0.75mm	140	°C	
1.5mm	140	°C	
3mm	140	°C	
Flammability	Value	Unit	Test Standard
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
Glow Wire Flammability Index, 3mm	900	°C	IEC 60695-2-12
Glow Wire Ignition Temperature, 3mm	825	°C	IEC 60695-2-13
FMVSS Class	B	-	ISO 3795 (FMVSS 302)
Burning rate, Thickness 1 mm	<100	mm/min	ISO 3795 (FMVSS 302)

To find out more, visit [DuPont Performance Polymers](#) or contact nearest DuPont location.

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Electrical properties	Value	Unit	Test Standard
Relative permittivity			IEC 62631-2-1
100Hz	4.5	-	
1MHz	4.2	-	
Dissipation factor			IEC 62631-2-1
100Hz	214	E-4	
1MHz	136	E-4	
Volume resistivity	>1E13	Ohm*m	IEC 62631-3-1
Surface resistivity	1E15	Ohm	IEC 62631-3-2
Electric strength	32	kV/mm	IEC 60243-1
Comparative tracking index	225	-	IEC 60112
Other properties	Value	Unit	Test Standard
Density	1700	kg/m ³	ISO 1183
VDA Properties	Value	Unit	Test Standard
Fogging, G-value (condensate)	0	mg	ISO 6452
Injection	Value	Unit	Test Standard
Drying Recommended	yes	-	-
Drying Temperature	≥120	°C	-
Drying Time, Dehumidified Dryer	4 - 6	h	-
Processing Moisture Content	≤0.02 ^[1]	%	-
Melt Temperature Optimum	285	°C	-
Min. melt temperature	280	°C	-
Max. melt temperature	300	°C	-
Max. screw tangential speed	0.2	m/s	-
Mold Temperature Optimum	120	°C	-
Min. mould temperature	110	°C	-
Max. mould temperature	130 ^[2]	°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. 2: (6mm - 1mm thickness)

Characteristics

Processing	• Injection Moulding		
Regional Availability	• North America	• Asia Pacific	• Near East/Africa
	• Europe	• South and Central America	• Global

Contact DuPont for Material Safety Data Sheet, general guides and/or additional information about ventilation, handling, purging, drying, etc. ISO Mechanical properties measured at 4mm (Hytrel® measured at 2 mm), IEC Electrical properties measured at 2mm, all ASTM properties measured at 3.2mm, and test temperatures are 23°C unless otherwise stated.

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