

Valox* Resin 310SE0

Asia Pacific: COMMERCIAL

VALOX 310SE0 is an unreinforced, flame retardant PBT injection moulding resin. Applications: electrical industry, bobbins, keyboard, switches and switch components and appliance housings.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	590	kgf/cm ²	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	590	kgf/cm ²	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	20	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	20	%	ASTM D 638
Tensile Modulus, 5 mm/min	28700	kgf/cm ²	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	1020	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	26700	kgf/cm ²	ASTM D 790
Taber Abrasion, CS-17, 1 kg	19	mg/1000cy	SABIC Method
Tensile Stress, yield, 50 mm/min	55	MPa	ISO 527
Tensile Stress, break, 50 mm/min	40	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	6	%	ISO 527
Tensile Strain, break, 50 mm/min	20	%	ISO 527
Tensile Modulus, 1 mm/min	2800	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	80	MPa	ISO 178
Flexural Modulus, 2 mm/min	2600	MPa	ISO 178
Hardness, H358/30	105	MPa	ISO 2039-1
Hardness, Rockwell R	120	-	ISO 2039-2
IMPACT			
Izod Impact, unnotched, 23°C	163	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	3	cm-kgf/cm	ASTM D 256
Izod Impact, notched, -30°C	2	cm-kgf/cm	ASTM D 256
Instrumented Impact Total Energy, 23°C	2039	cm-kgf	ASTM D 3763

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2) Only typical data for material selection purpose. Not to be used for part or tool design.

3) This rating is not intended to reflect hazards presented by this or any other material under actual fire conditions.

4) Own measurement according to UL.

Source, GMD, Last Update: 07/27/2007

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IMPACT			
Izod Impact, unnotched 80*10*4 +23°C	NB	kJ/m ²	ISO 180/1U
Izod Impact, unnotched 80*10*4 -30°C	NB	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	5	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	3	kJ/m ²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	8	kJ/m ²	ISO 179/1eA
Charpy Impact, notched, 23°C	4	kJ/m ²	ISO 179/2C
Charpy -30°C, V-notch Edgew 80*10*4 sp=62mm	4	kJ/m ²	ISO 179/1eA
Charpy 23°C, Unnotch Edgew 80*10*4 sp=62mm	NB	kJ/m ²	ISO 179/1eU
Charpy -30°C, Unnotch Edgew 80*10*4 sp=62mm	NB	kJ/m ²	ISO 179/1eU
THERMAL			
Vicat Softening Temp, Rate B/50	165	°C	ASTM D 1525
HDT, 1.82 MPa, 3.2mm, unannealed	74	°C	ASTM D 648
HDT, 0.45 MPa, 6.4 mm, unannealed	162	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	71	°C	ASTM D 648
CTE, -40°C to 40°C, flow	7.92E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	7.92E-05	1/°C	ASTM E 831
CTE, 60°C to 138°C, flow	1.31E-04	1/°C	ASTM E 831
Thermal Conductivity	0.24	W/m-°C	ISO 8302
CTE, 23°C to 60°C, flow	1.E-04	1/°C	ISO 11359-2
CTE, 23°C to 60°C, xflow	1.E-04	1/°C	ISO 11359-2
Ball Pressure Test, 125°C +/- 2°C	PASSES	-	IEC 60695-10-2
Vicat Softening Temp, Rate A/50	212	°C	ISO 306
Vicat Softening Temp, Rate B/50	165	°C	ISO 306
Vicat Softening Temp, Rate B/120	165	°C	ISO 306

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TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
THERMAL			
HDT/Be, 0.45MPa Edgew 120*10*4 sp=100mm	135	°C	ISO 75/Be
HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm	60	°C	ISO 75/Ae
Relative Temp Index, Elec	120	°C	UL 746B
Relative Temp Index, Mech w/impact	120	°C	UL 746B
Relative Temp Index, Mech w/o impact	140	°C	UL 746B
PHYSICAL			
Specific Gravity	1.4	-	ASTM D 792
Specific Volume	0.71	cm ³ /g	ASTM D 792
Mold Shrinkage on Tensile Bar, flow (2)	1.1 - 1.8	%	SABIC Method
Mold Shrinkage, flow, 3.2 mm	1.5 - 2.3	%	SABIC Method
Mold Shrinkage, flow, 0.75-2.3 mm	0.9 - 1.6	%	SABIC Method
Mold Shrinkage, flow, 2.3-4.6 mm	1.5 - 2.3	%	SABIC Method
Mold Shrinkage on Tensile Bar, xflow (2)	0.9 - 1.9	%	SABIC Method
Mold Shrinkage, xflow, 0.75-2.3 mm	1 - 1.7	%	SABIC Method
Mold Shrinkage, xflow, 2.3-4.6 mm	1.6 - 2.4	%	SABIC Method
Melt Flow Rate, 250°C/2.16 kgf	8.6	g/10 min	ASTM D 1238
Density	1.4	g/cm ³	ISO 1183
Water Absorption, (23°C/sat)	0.36	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.08	%	ISO 62
Melt Volume Rate, MVR at 250°C/2.16 kg	8	cm ³ /10 min	ISO 1133
ELECTRICAL			
Dielectric Strength, in air, 3.2 mm	18.4	kV/mm	ASTM D 149
Dielectric Strength, in oil, 1.6 mm	22	kV/mm	ASTM D 149
Arc Resistance, Tungsten {PLC}	6	PLC Code	ASTM D 495
Hot Wire Ignition {PLC}	2	PLC Code	UL 746A
High Voltage Arc Track Rate {PLC}	4	PLC Code	UL 746A
High Voltage Arc Resistance {PLC}	6	PLC Code	UL 746A
High Ampere Arc Ign, surface {PLC}	0	PLC Code	UL 746A

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TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
ELECTRICAL			
Comparative Tracking Index (UL) (PLC)	3	PLC Code	UL 746A
Volume Resistivity	>1.E+15	Ohm-cm	IEC 60093
Surface Resistivity, ROA	>1.E+15	Ohm	IEC 60093
Dielectric Strength, shorttime, 1.0mm	18	kV/mm	IEC 60243-1
Dielectric Strength, in oil, 0.8 mm	31	kV/mm	IEC 60243-1
Dielectric Strength, in oil, 1.6 mm	24	kV/mm	IEC 60243-1
Dielectric Strength, in oil, 3.2 mm	15	kV/mm	IEC 60243-1
Relative Permittivity, 50/60 Hz	2.9	-	IEC 60250
Relative Permittivity, 100 Hz	3.1	-	IEC 60250
Relative Permittivity, 1 MHz	2.8	-	IEC 60250
Dissipation Factor, 50/60 Hz	0.001	-	IEC 60250
Dissipation Factor, 100 Hz	0.002	-	IEC 60250
Dissipation Factor, 1 MHz	0.01	-	IEC 60250
Comparative Tracking Index	175	V	IEC 60112
Comparative Tracking Index, M	100	V	IEC 60112
FLAME CHARACTERISTICS			
UL Recognized, 94V-0 Flame Class Rating (3)	0.71	mm	UL 94
UL Recognized, 94-5VA Rating (3)	3	mm	UL 94
Glow Wire Flammability Index 960°C, passes at	1	mm	IEC 60695-2-12
Oxygen Index (LOI)	30	%	ISO 4589

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PROCESSING PARAMETERS	TYPICAL VALUE	UNIT
Injection Molding		
Drying Temperature	120	°C
Drying Time	3 - 4	hrs
Drying Time (Cumulative)	12	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	245 - 260	°C
Nozzle Temperature	240 - 255	°C
Front - Zone 3 Temperature	245 - 260	°C
Middle - Zone 2 Temperature	240 - 255	°C
Rear - Zone 1 Temperature	230 - 250	°C
Mold Temperature	50 - 75	°C
Back Pressure	0.3 - 0.7	MPa
Screw Speed	50 - 100	rpm
Shot to Cylinder Size	40 - 80	%
Vent Depth	0.013 - 0.025	mm

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