



## Valox\* Resin 357

### Americas: COMMERCIAL

Unreinforced, impact modified, UL94V-0 rated. Applications like bobbins, switches and enclosures.

TYPICAL PROPERTIES <sup>1</sup>	TYPICAL VALUE	UNIT	STANDARD
<b>MECHANICAL</b>			
Tensile Stress, yld, Type I, 50 mm/min	490	kgf/cm <sup>2</sup>	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	490	kgf/cm <sup>2</sup>	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	110	%	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	840	kgf/cm <sup>2</sup>	ASTM D 790
Flexural Stress, brk, 1.3 mm/min, 50 mm span	840	kgf/cm <sup>2</sup>	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	21000	kgf/cm <sup>2</sup>	ASTM D 790
Hardness, Rockwell R	117	-	ASTM D 785
<b>IMPACT</b>			
Izod Impact, unnotched, 23°C	326	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	54	cm-kgf/cm	ASTM D 256
Gardner, 23°C	442	cm-kgf	ASTM D 3029
Modified Gardner, 23°C	442	cm-kgf	ASTM D 3029
<b>THERMAL</b>			
HDT, 0.45 MPa, 6.4 mm, unannealed	137	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	98	°C	ASTM D 648
CTE, -40°C to 40°C, flow	9.18E-05	1/°C	ASTM E 831
CTE, 60°C to 138°C, flow	1.24E-04	1/°C	ASTM E 831
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
<b>PHYSICAL</b>			
Specific Gravity	1.34	-	ASTM D 792
Specific Volume	0.75	cm <sup>3</sup> /g	ASTM D 792
Water Absorption, 24 hours	0.08	%	ASTM D 570
Mold Shrinkage, flow, 0.75-2.3 mm	0.8 - 1.1	%	GE Method

1) Typical values only. Variations within normal tolerances are possible for various colours. All values are measured at least after 48 hours storage at 23°C/50% relative humidity. All properties, except the melt volume rate are measured on injection moulded samples. All samples are prepared according to ISO 294.

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:10/31/2000

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TYPICAL PROPERTIES <sup>1</sup>	TYPICAL VALUE	UNIT	STANDARD
<b>PHYSICAL</b>			
Mold Shrinkage, flow, 0.75-2.3 mm	0.8 - 1.1	%	GE Method
Mold Shrinkage, flow, 2.3-4.6 mm	1 - 1.4	%	GE Method
Mold Shrinkage, xflow, 0.75-2.3 mm	0.9 - 1.3	%	GE Method
Mold Shrinkage, xflow, 2.3-4.6 mm	1.2 - 1.6	%	GE Method
<b>ELECTRICAL</b>			
Volume Resistivity	>1.2E+16	Ohm-cm	ASTM D 257
Dielectric Strength, in air, 3.2 mm	18.5	kV/mm	ASTM D 149
Dielectric Strength, in oil, 1.6 mm	25.1	kV/mm	ASTM D 149
Dielectric Strength, in oil, 3.2 mm	18.5	kV/mm	ASTM D 149
Relative Permittivity, 100 Hz	3.2	-	ASTM D 150
Relative Permittivity, 1 MHz	3.2	-	ASTM D 150
Dissipation Factor, 100 Hz	0.003	-	ASTM D 150
Dissipation Factor, 1 MHz	0.03	-	ASTM D 150
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}	3	PLC Code	UL 746A
High Ampere Arc Ign, surface {PLC}	3	PLC Code	UL 746A
Comparative Tracking Index (UL) {PLC}	2	PLC Code	UL 746A
<b>FLAME CHARACTERISTICS</b>			
UL Recognized, 94HB Flame Class Rating (3)	0.45	mm	UL 94
UL Recognized, 94V-0 Flame Class Rating (3)	0.63	mm	UL 94
UL Recognized, 94-5VA Rating (3)	2.99	mm	UL 94
CSA (See File for complete listing)	LS88480	File No.	CSA LISTED
Oxygen Index (LOI)	30	%	ASTM D 2863
UV-light, water exposure/immersion	F2	-	UL 746C

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PROCESSING PARAMETERS	TYPICAL VALUE	UNIT
<b>Injection Molding</b>		
Drying Temperature	120	°C
Drying Time	3 - 4	hrs
Drying Time (Cumulative)	12	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	250 - 265	°C
Nozzle Temperature	245 - 260	°C
Front - Zone 3 Temperature	250 - 265	°C
Middle - Zone 2 Temperature	245 - 260	°C
Rear - Zone 1 Temperature	240 - 255	°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	0.025 - 0.038	mm

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