

Valox* Resin 830F

Asia Pacific: COMMERCIAL

PBT+PET, 30% Glass, Mold Release, Heat Stabilized, For foodcontact applications

TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	1010	kgf/cm ²	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	1070	kgf/cm ²	ASTM D 638
Tensile Strain, yld, Type I, 5 mm/min	2.5	%	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	2.5	%	ASTM D 638
Tensile Modulus, 5 mm/min	81500	kgf/cm ²	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	1730	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	71300	kgf/cm ²	ASTM D 790
Tensile Stress, yield, 5 mm/min	140	MPa	ISO 527
Tensile Stress, break, 5 mm/min	140	MPa	ISO 527
Tensile Strain, yield, 5 mm/min	2.5	%	ISO 527
Tensile Strain, break, 5 mm/min	2.5	%	ISO 527
Tensile Modulus, 1 mm/min	9000	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	200	MPa	ISO 178
Flexural Modulus, 2 mm/min	8000	MPa	ISO 178
IMPACT			
Izod Impact, notched, 23°C	8	cm-kgf/cm	ASTM D 256
Izod Impact, notched, -30°C	7	cm-kgf/cm	ASTM D 256
Instrumented Impact Total Energy, 23°C	71	cm-kgf	ASTM D 3763
Izod Impact, notched 80*10*4 +23°C	9	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	8	kJ/m ²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	9	kJ/m ²	ISO 179/1eA
THERMAL			
Vicat Softening Temp, Rate B/50	200	°C	ASTM D 1525

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: 09/15/2006

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TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
THERMAL			
HDT, 1.82 MPa, 3.2mm, unannealed	195	°C	ASTM D 648
CTE, -40°C to 40°C, flow	2.5E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	8.E-05	1/°C	ASTM E 831
CTE, 23°C to 80°C, flow	2.5E-05	1/°C	ISO 11359-2
CTE, 23°C to 80°C, xflow	8.1E-05	1/°C	ISO 11359-2
Vicat Softening Temp, Rate B/50	200	°C	ISO 306
Vicat Softening Temp, Rate B/120	205	°C	ISO 306
HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm	202	°C	ISO 75/Ae
PHYSICAL			
Specific Gravity	1.54	-	ASTM D 792
Water Absorption, (23°C/sat)	0.15	%	ASTM D 570
Moisture absorption (23°C/50%)	0.06	%	-
Mold Shrinkage, flow, 3.2 mm	0.3 - 0.8	%	SABIC Method
Melt Flow Rate, 265°C/2.16kg	18	g/10 min	ASTM D 1238
Density	1.54	g/cm ³	ISO 1183
Water Absorption, (23°C/sat)	0.15	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.06	%	ISO 62
Melt Volume Rate, MVR at 260°C/2.16 kg	13	cm ³ /10 min	ISO 1133

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PROCESSING PARAMETERS	TYPICAL VALUE	UNIT
Injection Molding		
Drying Temperature	110 - 120	°C
Drying Time	4 - 6	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	260 - 285	°C
Nozzle Temperature	265 - 275	°C
Front - Zone 3 Temperature	260 - 280	°C
Middle - Zone 2 Temperature	255 - 280	°C
Rear - Zone 1 Temperature	240 - 260	°C
Hopper Temperature	40 - 60	°C
Mold Temperature	60 - 110	°C

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