VALOX™ RESIN HX312C

REGION EUROPE

DESCRIPTION

Unreinforced PBT with release. For medical devices and pharmaceutical applications. Healthcare management of change, biocompatible (ISO 10993 or USP Class VI), food contact compliant. EtO and steam sterilizable.

TYPICAL PROPERTY VALUES

Revision 20190925

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	51	MPa	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	30	MPa	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	6	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	25	%	ASTM D 638
Tensile Modulus, 50 mm/min	2500	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	82	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	2340	MPa	ASTM D 790
Tensile Stress, yield, 50 mm/min	58	MPa	ISO 527
Tensile Stress, break, 50 mm/min	30	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	6	%	ISO 527
Tensile Strain, break, 50 mm/min	25	%	ISO 527
Tensile Modulus, 1 mm/min	2500	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	85	MPa	ISO 178
Flexural Modulus, 2 mm/min	2400	MPa	ISO 178
IMPACT			
Izod Impact, notched, 23°C	53	J/m	ASTM D 256
Izod Impact, notched, -30°C	53	J/m	ASTM D 256
Instrumented Impact Total Energy, 23°C	40	J	ASTM D 3763
Izod Impact, unnotched 80*10*4 +23°C	NB	kJ/m²	ISO 180/1U
Izod Impact, unnotched 80*10*4 -30°C	NB	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	3	kJ/m²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	3	kJ/m²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	3	kJ/m²	ISO 179/1eA
Charpy -30°C, V-notch Edgew 80*10*4 sp=62mm	2	kJ/m²	ISO 179/1eA
Charpy 23°C, Unnotch Edgew 80*10*4 sp=62mm	NB	kJ/m²	ISO 179/1eU
Charpy -30°C, Unnotch Edgew 80*10*4 sp=62mm	NB	kJ/m²	ISO 179/1eU
THERMAL			
Vicat Softening Temp, Rate B/50	175	°C	ASTM D 1525
HDT, 1.82 MPa, 3.2mm, unannealed	54	°C	ASTM D 648
CTE, -40°C to 40°C, flow	1.E-04	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	1.E-04	1/°C	ASTM E 831
CTE, 23°C to 80°C, flow	1.E-04	1/°C	ISO 11359-2
CTE, 23°C to 80°C, xflow	1.E-04	1/°C	ISO 11359-2
Vicat Softening Temp, Rate B/50	175	°C	ISO 306

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Vicat Softening Temp, Rate B/120	165	°C	ISO 306
HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm	58	°C	ISO 75/Ae
PHYSICAL			
Specific Gravity	1.31	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	0.9 – 1.6	%	SABIC method
Melt Flow Rate, 250°C/1.2 kgf	35	g/10 min	ASTM D 1238
Density	1.31	g/cm³	ISO 1183
Water Absorption, (23°C/sat)	0.35	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.08	%	ISO 62
Melt Volume Rate, MVR at 250°C/1.2 kg	31	cm³/10 min	ISO 1133
INJECTION MOLDING			
Drying Temperature	110 – 120	°C	
Drying Time	2 – 4	hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	250 – 270	°C	
Nozzle Temperature	240 – 260	°C	
Front - Zone 3 Temperature	245 – 265	°C	
Middle - Zone 2 Temperature	240 – 255	°C	
Rear - Zone 1 Temperature	230 – 245	°C	
Hopper Temperature	40 – 60	°C	
Mold Temperature	40 – 100	°C	

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