VALOX™ RESIN PDR4922

REGION ASIA

DESCRIPTION

GF filled PBT grade

TYPICAL PROPERTY VALUES

Revision 20190925

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	85	MPa	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	81	MPa	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	2.4	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	3.3	%	ASTM D 638
Tensile Modulus, 50 mm/min	5410	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	133	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	4580	MPa	ASTM D 790
Tensile Stress, yield, 50 mm/min	85	MPa	ISO 527
Tensile Stress, break, 50 mm/min	81	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	3	%	ISO 527
Tensile Strain, break, 50 mm/min	3.6	%	ISO 527
Tensile Modulus, 1 mm/min	5230	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	130	MPa	ISO 178
Flexural Modulus, 2 mm/min	4860	MPa	ISO 178
IMPACT			
Izod Impact, notched, 23°C	102	J/m	ASTM D 256
Izod Impact, notched, -30°C	58	J/m	ASTM D 256
Instrumented Impact Total Energy, 23°C	8	J	ASTM D 3763
Izod Impact, notched 80*10*4 +23°C	10	kJ/m²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	6	kJ/m²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	8	kJ/m²	ISO 179/1eA
THERMAL			
Vicat Softening Temp, Rate B/50	200	°C	ASTM D 1525
HDT, 0.45 MPa, 3.2 mm, unannealed	216	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	184	°C	ASTM D 648
CTE, -40°C to 40°C, flow	4.18E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	1.14E-04	1/°C	ASTM E 831
CTE, -40°C to 40°C, flow	4.39E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	1.18E-04	1/°C	ISO 11359-2
Vicat Softening Temp, Rate B/50	195	°C	ISO 306
Vicat Softening Temp, Rate B/120	196	°C	ISO 306
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	170	°C	ISO 75/Af
PHYSICAL			
Specific Gravity	1.4	-	ASTM D 792

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Mold Shrinkage, flow, 3.2 mm	0.16	%	SABIC method
Mold Shrinkage, xflow, 3.2 mm	0.94	%	SABIC method
Melt Flow Rate, 250°C/2.16 kgf	13.4	g/10 min	ASTM D 1238
Density	1.4	g/cm³	ISO 1183
Water Absorption, (23°C/sat)	0.03	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.03	%	ISO 62
Melt Volume Rate, MVR at 250°C/2.16 kg	12	cm³/10 min	ISO 1133
INJECTION MOLDING			
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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