



VALOXTM RESIN 315

REGION AMERICAS

DESCRIPTION

Unreinforced, For extrusion/compounding only (not for injection molding). High viscosity. Melt viscosity between 7500 and 9500 poise.

TYPICAL PROPERTY VALUES

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	51	MPa	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	300	%	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
Hardness, Rockwell R	117	-	ASTM D 785
IMPACT			
Izod Impact, unnotched, 23°C	1602	J/m	ASTM D 4812
Izod Impact, notched, 23°C	53	J/m	ASTM D 256
Modified Gardner, 23°C	40	J	ASTM D 3029
THERMAL			
HDT, 0.45 MPa, 6.4 mm, unannealed	154	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	54	°C	ASTM D 648
CTE, -40°C to 40°C, flow	8.1E-05	1/°C	ASTM E 831
CTE, 60°C to 138°C, flow	1.39E-04	1/°C	ASTM E 831
PHYSICAL			
Specific Gravity	1.31	-	ASTM D 792
Specific Volume	0.76	cm ³ /g	ASTM D 792
Water Absorption, 24 hours	0.08	%	ASTM D 570
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, 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 Volume Rate, MVR at 250°C/2.16 kg	9	cm ³ /10 min	ASTM D 1238
Melt Volume Rate, MVR at 250°C/2.16 kg	9	cm ³ /10 min	ISO 1133
ELECTRICAL			
Volume Resistivity	>4.E+16	Ohm-cm	ASTM D 257
Dielectric Strength, in air, 3.2 mm	15.7	kV/mm	ASTM D 149
Dielectric Strength, in oil, 1.6 mm	23.2	kV/mm	ASTM D 149
Relative Permittivity, 100 Hz	3.3	-	ASTM D 150
Relative Permittivity, 1 MHz	3.1	-	ASTM D 150
Dissipation Factor, 100 Hz	0.002	-	ASTM D 150
Dissipation Factor, 1 MHz	0.02	-	ASTM D 150
COMPOUNDING EXTRUSION			
Drying Temperature	110 – 120	°C	

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Drying Time	4 – 6	hrs	
Drying Time (Cumulative)	8	hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	245 – 260	°C	
Barrel - Zone 1 Temperature	200 – 230	°C	
Barrel - Zone 2 Temperature	240 – 255	°C	
Barrel - Zone 3 Temperature	240 – 275	°C	
Barrel - Zone 4 Temperature	240 – 275	°C	
Adapter Temperature	240 – 275	°C	
Die Temperature	240 – 275	°C	
Waterbath Temperature	25 – 35	°C	