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VALOX™ RESIN 337

REGION AMERICAS

DESCRIPTION

Low temperature impact PBT. Automotive applications: underhood power distribution boxes and covers.

TYPICAL PROPERTY VALUES

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	39	MPa	ASTM D638
Tensile Strain, yld, Type I, 50 mm/min	3.9	%	ASTM D638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	56	MPa	ASTM D790
Flexural Modulus, 1.3 mm/min, 50 mm span	1790	MPa	ASTM D790
IMPACT			
Izod Impact, unnotched, 23°C	3204	J/m	ASTM D4812
Izod Impact, unnotched, -30°C	3204	J/m	ASTM D4812
Izod Impact, notched, 23°C	870	J/m	ASTM D256
Izod Impact, notched, -30°C	801	J/m	ASTM D256
THERMAL			
HDT, 0.45 MPa, 6.4 mm, unannealed	98	°C	ASTM D648
HDT, 1.82 MPa, 6.4 mm, unannealed	47	°C	ASTM D648
PHYSICAL			
Specific Gravity	1.22	-	ASTM D792
Water Absorption, (23°C/24hrs)	0.1	%	ASTM D570
Mold Shrinkage, flow, 3.2 mm	2.4 – 2.7	%	SABIC method
Mold Shrinkage, xflow, 3.2 mm	2.4 – 2.7	%	SABIC method
Melt Flow Rate, 250°C/5.0 kgf	12.7	g/10 min	ASTM D1238
Melt Viscosity	1200	Pa-s	SABIC method
INJECTION MOLDING			
Drying Temperature	120	°C	
Drying Time	3 – 4	Hrs	
Drying Time (Cumulative)	12	Hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	245 – 260	°C	
Nozzle Temperature	240 – 255	°C	
Front - Zone 3 Temperature	245 – 260	°C	
Middle - Zone 2 Temperature	240 – 255	°C	
Rear - Zone 1 Temperature	230 – 250	°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	0.013 – 0.025	mm	