



VALOX™ Resin 771

Americas: COMMERCIAL

35% mineral/glass reinforced flame retardant grade with a CTI performance level class of 0 rating. Applications which may see electrical arcing.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, brk, Type I, 5 mm/min	730	kgf/cm ²	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	2.3	%	ASTM D 638
Flexural Stress, brk, 1.3 mm/min, 50 mm span	1120	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	59700	kgf/cm ²	ASTM D 790
IMPACT			
Izod Impact, unnotched, 23°C	38	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	4	cm-kgf/cm	ASTM D 256
THERMAL			
HDT, 0.45 MPa, 6.4 mm, unannealed	217	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	196	°C	ASTM D 648
Ball Pressure Test, 125°C +/- 2°C	PASSES	-	IEC 60695-10-2
Relative Temp Index, Elec	140	°C	UL 746B
Relative Temp Index, Mech w/impact	125	°C	UL 746B
Relative Temp Index, Mech w/o impact	140	°C	UL 746B
PHYSICAL			
Specific Gravity	1.72	-	ASTM D 792
Mold Shrinkage on Tensile Bar, flow (2) (5)	0.65 - 0.85	%	SABIC Method
Mold Shrinkage on Tensile Bar, xflow (2) (5)	1 - 1.2	%	SABIC Method
ELECTRICAL			
Arc Resistance, Tungsten {PLC}	4	PLC Code	ASTM D 495
Hot Wire Ignition {PLC}	0	PLC Code	UL 746A
High Voltage Arc Track Rate {PLC}	0	PLC Code	UL 746A
High Ampere Arc Ign, surface {PLC}	0	PLC Code	UL 746A
Comparative Tracking Index (UL) {PLC}	0	PLC Code	UL 746A
FLAME CHARACTERISTICS			
UL Recognized, 94V-2 Flame Class Rating (3)	0.61	mm	UL 94



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TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
FLAME CHARACTERISTICS			
UL Recognized, 94V-0 Flame Class Rating (3)	0.76	mm	UL 94
UL Recognized, 94-5VA Rating (3)	2.01	mm	UL 94
Glow Wire Flammability Index 960°C, passes at	1	mm	IEC 60695-2-12
Glow Wire Flammability Index 960°C, passes at, by VDE	3	mm	IEC 60695-2-12
Glow Wire Ignitability Temperature, 1.0 mm	750	°C	IEC 60695-2-13
Glow Wire Ignitability Temperature, 3.0 mm	800	°C	IEC 60695-2-13



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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	120	°C
Drying Time	3 - 4	hrs
Drying Time (Cumulative)	12	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	255 - 275	°C
Nozzle Temperature	255 - 270	°C
Front - Zone 3 Temperature	255 - 265	°C
Middle - Zone 2 Temperature	250 - 260	°C
Rear - Zone 1 Temperature	245 - 255	°C
Mold Temperature	65 - 95	°C
Back Pressure	0.3 - 0.7	MPa
Screw Speed	50 - 80	rpm
Shot to Cylinder Size	40 - 80	%
Vent Depth	0.025 - 0.038	mm