+135-3858-6433 (GuangDong)
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VALOX™ RESIN V8280

REGION EUROPE

DESCRIPTION

40% GR PBT+PET. High stiffness. Excellent surface aesthetics. Applications include office furniture.

TYPICAL PROPERTY VALUES

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	145	MPa	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	145	MPa	ASTM D 638
Tensile Strain, yld, Type I, 5 mm/min	2.2	%	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	2.2	%	ASTM D 638
Tensile Modulus, 5 mm/min	12750	MPa	ASTM D 638
Flexural Stress, brk, 1.3 mm/min, 50 mm span	220	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	10680	MPa	ASTM D 790
IMPACT			
Izod Impact, unnotched, 23°C	827	J/m	ASTM D 4812
Izod Impact, notched, 23°C	106	J/m	ASTM D 256
Instrumented Impact Total Energy, 23°C	7	J	ASTM D 3763
THERMAL			
Vicat Softening Temp, Rate B/50	221	°C	ASTM D 1525
HDT, 0.45 MPa, 3.2 mm, unannealed	215	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	193	°C	ASTM D 648
CTE, -40°C to 40°C, flow	1.44E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	7.38E-05	1/°C	ASTM E 831
PHYSICAL			
Specific Gravity	1.64	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	0.2 – 0.5	%	SABIC method
Mold Shrinkage, xflow, 3.2 mm	0.5 – 0.8	%	SABIC method
Melt Flow Rate, 266°C/5.0 kgf	33	g/10 min	ASTM D 1238
Melt Volume Rate, MVR at 265°C/5.0 kg	22	cm³/10 min	ISO 1133
INJECTION MOLDING			
Drying Temperature	135	°C	
Drying Time	4 – 6	hrs	
Drying Time (Cumulative)	12	hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	270 – 280	°C	
Nozzle Temperature	270 – 280	°C	
Front - Zone 3 Temperature	270 – 280	°C	
Middle - Zone 2 Temperature	270 – 280	°C	
Rear - Zone 1 Temperature	260 – 275	°C	
Mold Temperature	40 – 65	°C	
Back Pressure	0.3 – 0.7	MPa	

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Screw Speed	50 – 80	rpm	
Shot to Cylinder Size	40 – 80	%	
Vent Depth	0.025 – 0.038	mm	