



Valox* Resin 4014

Europe-Africa-Middle East: COMMERCIAL

VALOX 4014 is a 6% glass fibre reinforced PBT injection moulding resin with good flow characteristics.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
MECHANICAL			
Tensile Stress, break, 5 mm/min	70	MPa	ISO 527
Tensile Strain, break, 5 mm/min	3	%	ISO 527
Tensile Modulus, 1 mm/min	3600	MPa	ISO 527
Flexural Stress, break, 2 mm/min	110	MPa	ISO 178
Flexural Modulus, 2 mm/min	3400	MPa	ISO 178
Hardness, H358/30	115	MPa	ISO 2039-1
IMPACT			
Izod Impact, unnotched 80*10*4 +23°C	20	kJ/m ²	ISO 180/1U
Izod Impact, unnotched 80*10*4 -30°C	20	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	4	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	4	kJ/m ²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	5	kJ/m ²	ISO 179/1eA
Charpy -30°C, V-notch Edgew 80*10*4 sp=62mm	4	kJ/m ²	ISO 179/1eA
Charpy 23°C, Unnotch Edgew 80*10*4 sp=62mm	25	kJ/m ²	ISO 179/1eU
Charpy -30°C, Unnotch Edgew 80*10*4 sp=62mm	25	kJ/m ²	ISO 179/1eU
THERMAL			
CTE, 23°C to 80°C, flow	8.E-05	1/°C	ISO 11359-2
CTE, 23°C to 80°C, xflow	1.E-04	1/°C	ISO 11359-2
Ball Pressure Test, 125°C +/- 2°C	PASSES	-	IEC 60695-10-2
Vicat Softening Temp, Rate B/50	190	°C	ISO 306
Vicat Softening Temp, Rate B/120	195	°C	ISO 306
HDT/Be, 0.45MPa Edgew 120*10*4 sp=100mm	190	°C	ISO 75/Be
HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm	135	°C	ISO 75/Ae



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THERMAL			
Relative Temp Index, Elec	75	°C	UL 746B
Relative Temp Index, Mech w/impact	75	°C	UL 746B
Relative Temp Index, Mech w/o impact	75	°C	UL 746B
PHYSICAL			
Mold Shrinkage on Tensile Bar, flow (2)	0.7 - 1	%	GE Method
Mold Shrinkage on Tensile Bar, xflow (2)	0.7 - 1.2	%	GE Method
Density	1.36	g/cm ³	ISO 1183
Water Absorption, (23°C/sat)	0.25	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.09	%	ISO 62
Melt Volume Rate, MVR at 250°C/2.16 kg	18	cm ³ /10 min	ISO 1133
ELECTRICAL			
Volume Resistivity	>1.E+15	Ohm-cm	IEC 60093
Surface Resistivity, ROA	>1.E+15	Ohm	IEC 60093
Dielectric Strength, in oil, 3.2 mm	17	kV/mm	IEC 60243-1
Relative Permittivity, 50/60 Hz	3.1	-	IEC 60250
Relative Permittivity, 1 MHz	3	-	IEC 60250
Dissipation Factor, 50/60 Hz	0.001	-	IEC 60250
Dissipation Factor, 1 MHz	0.014	-	IEC 60250
Comparative Tracking Index	250	V	IEC 60112
FLAME CHARACTERISTICS			
UL Recognized, 94HB Flame Class Rating (3)	1.5	mm	UL 94
UL Recognized, 94HB Flame Class Rating 2nd value (3)	3	mm	UL 94
Glow Wire Flammability Index 750°C, passes at	1	mm	IEC 60695-2-12



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PROCESSING PARAMETERS	TYPICAL VALUE	UNIT
Injection Molding		
Drying Temperature	110 - 120	°C
Drying Time	2 - 4	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	250 - 270	°C
Nozzle Temperature	240 - 260	°C
Front - Zone 3 Temperature	245 - 265	°C
Middle - Zone 2 Temperature	240 - 255	°C
Rear - Zone 1 Temperature	230 - 245	°C
Hopper Temperature	40 - 60	°C
Mold Temperature	40 - 100	°C