



Valox* Resin HR326

Europe-Africa-Middle East: COMMERCIAL

VALOX HR326 is an unreinforced PBT resin with high viscosity, good hydrolitical stability and chemical resistance. Applications: extrusion, fibre optic buffer tubes.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
MECHANICAL			
Tensile Stress, yield, 50 mm/min	55	MPa	ISO 527
Tensile Stress, break, 50 mm/min	30	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	3	%	ISO 527
Tensile Strain, break, 50 mm/min	50	%	ISO 527
Tensile Modulus, 1 mm/min	2600	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	80	MPa	ISO 178
Flexural Modulus, 2 mm/min	2500	MPa	ISO 178
Hardness, H358/30	85	MPa	ISO 2039-1
IMPACT			
Izod Impact, unnotched 80*10*4 +23°C	NB	kJ/m ²	ISO 180/1U
Izod Impact, unnotched 80*10*4 -30°C	NB	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	5	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*4 -10°C	5	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	3	kJ/m ²	ISO 179/1eA
Charpy 23°C, Unnotch Edgew 80*10*4 sp=62mm	NB	kJ/m ²	ISO 179/1eU
Charpy -30°C, Unnotch Edgew 80*10*4 sp=62mm	NB	kJ/m ²	ISO 179/1eU
THERMAL			
CTE, 23°C to 80°C, flow	1.3E-04	1/°C	ISO 11359-2
CTE, 23°C to 80°C, xflow	1.3E-04	1/°C	ISO 11359-2
Ball Pressure Test, 125°C +/- 2°C	PASSES	-	IEC 60695-10-2
Vicat Softening Temp, Rate A/50	215	°C	ISO 306



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TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
THERMAL			
Vicat Softening Temp, Rate B/50	180	°C	ISO 306
Vicat Softening Temp, Rate B/120	175	°C	ISO 306
HDT/Be, 0.45MPa Edgew 120*10*4 sp=100mm	150	°C	ISO 75/Be
HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm	85	°C	ISO 75/Ae
PHYSICAL			
Mold Shrinkage on Tensile Bar, flow (2)	1.1 - 1.8	%	GE Method
Mold Shrinkage on Tensile Bar, xflow (2)	0.9 - 1.8	%	GE Method
Density	1.31	g/cm ³	ISO 1183
Water Absorption, (23°C/sat)	0.35	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.08	%	ISO 62
Melt Volume Rate, MVR at 250°C/5.0 kg	24	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	16	kV/mm	IEC 60243-1
Relative Permittivity, 50/60 Hz	2.9	-	IEC 60250
Relative Permittivity, 1 MHz	2.7	-	IEC 60250
Dissipation Factor, 50/60 Hz	0	-	IEC 60250
Dissipation Factor, 1 MHz	0.02	-	IEC 60250
Comparative Tracking Index	600	V	IEC 60112
Comparative Tracking Index, M	350	V	IEC 60112
FLAME CHARACTERISTICS			
UL Compliant, 94HB Flame Class Rating 2nd value (3)(4)	1.6	mm	UL 94 by GE



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PROCESSING PARAMETERS	TYPICAL VALUE	UNIT
Profile Extrusion		
Drying Temperature	70 - 80	°C
Drying Time	6 - 8	hrs
Melt Temperature	240 - 270	°C
Barrel - Zone 1 Temperature	260 - 270	°C
Barrel - Zone 2 Temperature	260 - 270	°C
Barrel - Zone 3 Temperature	260 - 270	°C
Barrel - Zone 4 Temperature	260 - 270	°C
Hopper Temperature	40 - 60	°C
Adapter Temperature	250 - 260	°C
Die Temperature	250 - 260	°C
Calibrator Temperature	50 - 100	°C