



Valox* Resin IQ4860HR

Europe-Africa-Middle East: COMMERCIAL

Valox iQ* Resin IQ4860HR: Environmentally responsible iQ* PBT resin with 30% Glass reinforcement + UL94 V-0. Hydrolytically stable and impact modified.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	1100	kgf/cm ²	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	1100	kgf/cm ²	ASTM D 638
Tensile Stress, brk, Type I, 10 mm/min	1210	kgf/cm ²	GEPJ Method
Tensile Strain, yld, Type I, 5 mm/min	1.7	%	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	1.7	%	ASTM D 638
Tensile Strain, brk, Type I, 10 mm/min	8	%	GEPJ Method
Tensile Modulus, 5 mm/min	113100	kgf/cm ²	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	1830	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	91400	kgf/cm ²	ASTM D 790
Tensile Stress, yield, 5 mm/min	97	MPa	ISO 527
Tensile Stress, break, 5 mm/min	97	MPa	ISO 527
Tensile Strain, yield, 5 mm/min	1	%	ISO 527
Tensile Strain, break, 5 mm/min	1	%	ISO 527
Tensile Modulus, 1 mm/min	10700	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	180	MPa	ISO 178
Flexural Modulus, 2 mm/min	9180	MPa	ISO 178
IMPACT			
Izod Impact, unnotched, 23°C	80	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	9	cm-kgf/cm	ASTM D 256
Izod Impact, notched, -30°C	7	cm-kgf/cm	ASTM D 256
Instrumented Impact Total Energy, 23°C	101	cm-kgf	ASTM D 3763
Izod Impact, notched 80*10*4 +23°C	9	kJ/m ²	ISO 180/1A



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IMPACT			
Izod Impact, notched 80*10*4 -30°C	8	kJ/m ²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	21	kJ/m ²	ISO 179/1eA
THERMAL			
Vicat Softening Temp, Rate B/50	157	°C	ASTM D 1525
HDT, 1.82 MPa, 3.2mm, unannealed	192	°C	ASTM D 648
CTE, -40°C to 40°C, flow	2.03E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	1.02E-04	1/°C	ASTM E 831
CTE, -40°C to 40°C, flow	2.03E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	1.02E-04	1/°C	ISO 11359-2
Vicat Softening Temp, Rate B/50	157	°C	ISO 306
Vicat Softening Temp, Rate B/120	157	°C	ISO 306
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	209	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	187	°C	ISO 75/Af
PHYSICAL			
Specific Gravity	1.65	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	1.04 - 1.1	%	GE Method
Mold Shrinkage, xflow, 3.2 mm	1.2 - 1.24	%	GE Method
Melt Flow Rate, 250°C/5.0 kgf	40	g/10 min	ASTM D 1238
Density	1.65	g/cm ³	ISO 1183
Water Absorption, (23°C/sat)	0.19	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.06	%	ISO 62
Melt Volume Rate, MVR at 220°C/5.0 kg	27	cm ³ /10 min	ISO 1133
Melt Volume Rate, MVR at 250°C/5.0 kg	27	cm ³ /10 min	ISO 1133



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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	230 - 260	°C
Nozzle Temperature	240 - 260	°C
Front - Zone 3 Temperature	240 - 260	°C
Middle - Zone 2 Temperature	230 - 250	°C
Rear - Zone 1 Temperature	220 - 240	°C
Mold Temperature	60 - 120	°C
Back Pressure	5 - 10	MPa
Screw Speed	20 - 100	rpm
Shot to Cylinder Size	30 - 70	%
Vent Depth	0.025 - 0.038	mm