



Valox* Resin PKG1530

Europe-Africa-Middle East: COMMERCIAL

VALOX PKG1530 is compliant with food contact regulations acc. to 90/128/EEC. VALOX PKG1530 is an unreinforced PBT blend with good flow and good adhesion to polystyrene. Applications: seals, packaging.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
MECHANICAL			
Tensile Stress, yield, 50 mm/min	50	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	2.6	%	ISO 527
Tensile Strain, break, 50 mm/min	15	%	ISO 527
Tensile Modulus, 1 mm/min	2300	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	70	MPa	ISO 178
Flexural Modulus, 2 mm/min	2200	MPa	ISO 178
IMPACT			
Izod Impact, unnotched 80*10*4 +23°C	45	kJ/m ²	ISO 180/1U
Izod Impact, unnotched 80*10*4 -30°C	25	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	3	kJ/m ²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	6	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	40	kJ/m ²	ISO 179/1eU
Charpy -30°C, Unnotch Edgew 80*10*4 sp=62mm	20	kJ/m ²	ISO 179/1eU
THERMAL			
CTE, 23°C to 80°C, flow	1.1E-04	1/°C	ISO 11359-2
CTE, 23°C to 80°C, xflow	1.2E-04	1/°C	ISO 11359-2
CTE, 23°C to 150°C, flow	1.3E-04	1/°C	ISO 11359-2
CTE, 23°C to 150°C, xflow	1.4E-04	1/°C	ISO 11359-2
Ball Pressure Test, 125°C +/- 2°C	PASSES	-	IEC 60695-10-2
Vicat Softening Temp, Rate A/50	200	°C	ISO 306
Vicat Softening Temp, Rate B/50	120	°C	ISO 306



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TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
THERMAL			
Vicat Softening Temp, Rate B/120	120	°C	ISO 306
HDT/Be, 0.45MPa Edgew 120*10*4 sp=100mm	100	°C	ISO 75/Be
HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm	75	°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	1.22	g/cm ³	ISO 1183
Water Absorption, (23°C/sat)	0.32	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.09	%	ISO 62
Melt Volume Rate, MVR at 250°C/2.16 kg	8	cm ³ /10 min	ISO 1133



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PROCESSING PARAMETERS	TYPICAL VALUE	UNIT
Profile Extrusion		
Drying Temperature	110 - 120	°C
Drying Time	2 - 4	hrs
Melt Temperature	235 - 250	°C
Barrel - Zone 1 Temperature	225 - 250	°C
Barrel - Zone 2 Temperature	235 - 250	°C
Barrel - Zone 3 Temperature	235 - 250	°C
Barrel - Zone 4 Temperature	235 - 250	°C
Hopper Temperature	40 - 60	°C
Adapter Temperature	235 - 250	°C
Die Temperature	235 - 250	°C
Calibrator Temperature	25 - 80	°C