



VALOX™ Resin V8280
Americas: COMMERCIAL

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

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	1480	kgf/cm ²	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	1480	kgf/cm ²	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	130000	kgf/cm ²	ASTM D 638
Flexural Stress, brk, 1.3 mm/min, 50 mm span	2240	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	108900	kgf/cm ²	ASTM D 790
IMPACT			
Izod Impact, unnotched, 23°C	84	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	10	cm-kgf/cm	ASTM D 256
Instrumented Impact Total Energy, 23°C	80	cm-kgf	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 (5)	0.2 - 0.5	%	SABIC Method
Mold Shrinkage, xflow, 3.2 mm (5)	0.5 - 0.8	%	SABIC Method
Melt Flow Rate, 266°C/5.0 kgf	33	g/10 min	ASTM D 1238



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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
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
Screw Speed	50 - 80	rpm
Shot to Cylinder Size	40 - 80	%
Vent Depth	0.025 - 0.038	mm