



Valox* Resin 830X

Europe-Africa-Middle East: COMMERCIAL

VALOX 830X is a 30% glass fibre reinforced PBT+PET blend with improved surface finish, containing a high percentage of rework. VALOX 830X is available in black colour only.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
MECHANICAL			
Tensile Stress, break, 5 mm/min	105	MPa	ISO 527
Tensile Strain, break, 5 mm/min	3	%	ISO 527
Tensile Modulus, 1 mm/min	8000	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	150	MPa	ISO 178
Flexural Modulus, 2 mm/min	7000	MPa	ISO 178
IMPACT			
Izod Impact, unnotched 80*10*4 +23°C	40	kJ/m ²	ISO 180/1U
Izod Impact, unnotched 80*10*4 -30°C	30	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 -30°C	5	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	35	kJ/m ²	ISO 179/1eU
Charpy -30°C, Unnotch Edgew 80*10*4 sp=62mm	25	kJ/m ²	ISO 179/1eU
THERMAL			
Vicat Softening Temp, Rate B/120	175	°C	ISO 306
PHYSICAL			
Mold Shrinkage on Tensile Bar, flow (2)	0.4 - 0.9	%	GE Method
Mold Shrinkage on Tensile Bar, xflow (2)	0.6 - 1.1	%	GE Method
Density	1.54	g/cm ³	ISO 1183
Water Absorption, (23°C/sat)	0.2	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.08	%	ISO 62
Melt Volume Rate, MVR at 265°C/1.2 kg	8	cm ³ /10 min	ISO 1133
FLAME CHARACTERISTICS			
UL Recognized, 94HB Flame Class Rating (3)	1.5	mm	UL 94



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UL Recognized, 94HB Flame Class Rating 2nd value (3)	3	mm	UL 94



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PROCESSING PARAMETERS	TYPICAL VALUE	UNIT
Injection Molding		
Drying Temperature	110 - 120	°C
Drying Time	4 - 6	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	260 - 285	°C
Nozzle Temperature	265 - 275	°C
Front - Zone 3 Temperature	260 - 280	°C
Middle - Zone 2 Temperature	255 - 280	°C
Rear - Zone 1 Temperature	240 - 260	°C
Hopper Temperature	40 - 60	°C
Mold Temperature	60 - 110	°C