VALOX™ RESIN 4022

REGION EUROPE

DESCRIPTION

VALOX 4022 is a 20% high strength glass fibre reinforced PBT injection moulding resin, with improved mechanical properties. Applications : Spotlights, appliance housings and handles.

TYPICAL PROPERTY VALUES

Revision 20180807

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	120	MPa	ASTM D638
Tensile Stress, brk, Type I, 5 mm/min	120	MPa	ASTM D638
Tensile Strain, yld, Type I, 5 mm/min	3	%	ASTM D638
Tensile Strain, brk, Type I, 5 mm/min	3	%	ASTM D638
Tensile Modulus, 5 mm/min	7400	MPa	ASTM D638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	170	MPa	ASTM D790
Flexural Stress, brk, 1.3 mm/min, 50 mm span	170	MPa	ASTM D790
Flexural Modulus, 1.3 mm/min, 50 mm span	5900	MPa	ASTM D790
Tensile Stress, yield, 5 mm/min	120	MPa	ISO 527
Tensile Stress, break, 5 mm/min	120	MPa	ISO 527
Tensile Strain, yield, 5 mm/min	3	%	ISO 527
Tensile Strain, break, 5 mm/min	3	%	ISO 527
Tensile Modulus, 1 mm/min	7300	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	180	MPa	ISO 178
Flexural Stress, break, 2 mm/min	175	MPa	ISO 178
Flexural Strain, break, 2 mm/min	3	%	ISO 178
Flexural Modulus, 2 mm/min	6200	MPa	ISO 178
Ball Indentation Hardness, H358/30	130	MPa	ISO 2039-1
Hardness, Rockwell R	122	-	ISO 2039-2
IMPACT			
Charpy Impact, unnotched, 23°C	42	kJ/m²	ISO 179/2C
Charpy Impact, unnotched, -30°C	42	kJ/m²	ISO 179/2C
Izod Impact, unnotched, 23°C	560	J/m	ASTM D4812
Izod Impact, unnotched, -30°C	560	J/m	ASTM D4812
Izod Impact, notched, 23°C	75	J/m	ASTM D256
Izod Impact, notched, 0°C	75	J/m	ASTM D256
Izod Impact, notched, -30°C	75	J/m	ASTM D256
Izod Impact, unnotched 80*10*4 +23°C	40	kJ/m²	ISO 180/1U
Izod Impact, unnotched 80*10*4 -30°C	35	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	8	kJ/m²	ISO 180/1A
Izod Impact, notched 80*10*4 0°C	8	kJ/m²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	8	kJ/m²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	6	kJ/m²	ISO 179/1eA
Charpy Impact, notched, 23°C	9	kJ/m²	ISO 179/2C

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Charpy -30°C, V-notch Edgew 80*10*4 sp=62mm	5	kJ/m²	ISO 179/1eA
Charpy Impact, notched, -30°C	9	kJ/m²	ISO 179/2C
Charpy 23°C, Unnotch Edgew 80*10*4 sp=62mm	40	kJ/m²	ISO 179/1eU
Charpy -30°C, Unnotch Edgew 80*10*4 sp=62mm	30	kJ/m²	ISO 179/1eU
THERMAL			
Vicat Softening Temp, Rate A/50	220	°C	ASTM D1525
Vicat Softening Temp, Rate B/50	215	°C	ASTM D1525
HDT, 0.45 MPa, 3.2 mm, unannealed	220	°C	ASTM D648
HDT, 1.82 MPa, 3.2mm, unannealed	200	°C	ASTM D648
CTE, -40°C to 40°C, flow	3.07E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	7.32E-05	1/°C	ISO 11359-2
CTE, 23°C to 80°C, flow	4.E-05	1/°C	ISO 11359-2
CTE, 23°C to 80°C, xflow	8.E-05	1/°C	ISO 11359-2
CTE, 23°C to 150°C, flow	3.04E-05	1/°C	ISO 11359-2
CTE, 23°C to 150°C, xflow	1.78E-04	1/°C	ISO 11359-2
Ball Pressure Test, 125°C +/- 2°C	PASSES	-	IEC 60695-10-2
Vicat Softening Temp, Rate A/50	220	°C	ISO 306
Vicat Softening Temp, Rate B/50	215	°C	ISO 306
Vicat Softening Temp, Rate B/120	210	°C	ISO 306
HDT/Be, 0.45MPa Edgew 120*10*4 sp=100mm	220	°C	ISO 75/Be
HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm	205	°C	ISO 75/Ae
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	220	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	200	°C	ISO 75/Af
PHYSICAL			
Specific Gravity	1.45	-	ASTM D792
Filler Content	20	%	ASTM D229
Mold Shrinkage on Tensile Bar, flow	0.3 – 0.7	%	SABIC method
Mold Shrinkage on Tensile Bar, xflow	0.4 – 1	%	SABIC method
Melt Flow Rate, 266°C/5.0 kgf	40	g/10 min	ASTM D1238
Density	1.45	g/cm³	ISO 1183
Water Absorption, (23°C/saturated)	0.15	%	ISO 62-1
Moisture Absorption (23°C / 50% RH)	0.03	%	ISO 62
Melt Volume Rate, MVR at 250°C/2.16 kg	16	cm³/10 min	ISO 1133
Melt Volume Rate, MVR at 250°C/5.0 kg	23	cm³/10 min	ISO 1133
Melt Volume Rate, MVR at 265°C/5.0 kg	30	cm³/10 min	ISO 1133
Melt Viscosity, 260°C, 1500 sec-1	140	Pa-s	ISO 11443
ELECTRICAL			
Volume Resistivity	>1.E+15	Ω.cm	ASTM D257
Dielectric Strength, in oil, 0.8 mm	26	kV/mm	ASTM D149
Dielectric Strength, in oil, 1.6 mm	24	kV/mm	ASTM D149
Dielectric Strength, in oil, 3.2 mm	18	kV/mm	ASTM D149
Relative Permittivity, 1 MHz	3.6	-	ASTM D150
Dissipation Factor, 1 MHz	0.015	-	ASTM D150
Volume Resistivity	>1.E+15	Ω.cm	IEC 60093
Surface Resistivity, ROA	>1.E+15	Ω	IEC 60093

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Dielectric Strength, in oil, 0.8 mm	26	kV/mm	IEC 60243-1
Dielectric Strength, in oil, 1.6 mm	24	kV/mm	IEC 60243-1
Dielectric Strength, in oil, 3.2 mm	18	kV/mm	IEC 60243-1
Relative Permittivity, 1 MHz	3.6	-	IEC 60250
Dissipation Factor, 50/60 Hz	0.001	-	IEC 60250
Dissipation Factor, 1 MHz	0.015	-	IEC 60250
Comparative Tracking Index	250	V	IEC 60112
Relative Permittivity, 50/60 Hz	3.2	-	IEC 60250
FLAME CHARACTERISTICS			
UL Compliant, 94HB Flame Class Rating	0.84	mm	UL 94 by SABIC-IP
Glow Wire Flammability Index 750°C, passes at	1	mm	IEC 60695-2-12
INJECTION MOLDING			
Drying Temperature	110 – 120	°C	
Drying Time	2 – 4	Hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	250 – 270	°C	
Nozzle Temperature	240 – 260	°C	
Front - Zone 3 Temperature	245 – 265	°C	
Middle - Zone 2 Temperature	240 – 255	°C	
Rear - Zone 1 Temperature	230 – 245	°C	
Hopper Temperature	40 – 60	°C	
Mold Temperature	40 – 100	°C	

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