VALOX™ RESIN K3501

REGION EUROPE

DESCRIPTION

Unfilled PBT, Hydrollytically Stable, Heat Stabilized, Impact Modified. A hydrollytically stable grade designed for improved performance under heat/humidity environments. Targeted at automotive underhood applications requiring USCAR-2 Class III humidity/heat performance.

TYPICAL PROPERTY VALUES

Revision 20190815

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	50	MPa	ASTM D638
Tensile Stress, brk, Type I, 50 mm/min	25	MPa	ASTM D638
Tensile Strain, yld, Type I, 50 mm/min	3.3	%	ASTM D638
Tensile Strain, brk, Type I, 50 mm/min	50	%	ASTM D638
Tensile Modulus, 50 mm/min	2400	MPa	ASTM D638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	70	MPa	ASTM D790
Flexural Modulus, 1.3 mm/min, 50 mm span	2100	MPa	ASTM D790
Tensile Stress, yield, 50 mm/min	50	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	3.5	%	ISO 527
Tensile Strain, break, 50 mm/min	40	%	ISO 527
Tensile Modulus, 1 mm/min	2100	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	73	MPa	ISO 178
Flexural Modulus, 2 mm/min	2000	MPa	ISO 178
IMPACT			
Izod Impact, unnotched, -30°C	NB	J/m	ASTM D4812
Izod Impact, notched, 23°C	90	J/m	ASTM D256
Izod Impact, notched, 0°C	83	J/m	ASTM D256
Izod Impact, notched, -20°C	75	J/m	ASTM D256
Izod Impact, unnotched 80*10*4 -30°C	NB	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	8	kJ/m²	ISO 180/1A
THERMAL			
HDT, 1.82 MPa, 3.2mm, unannealed	46	°C	ASTM D648
CTE, -40°C to 40°C, flow	9.1E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	9.7E-05	1/°C	ISO 11359-2
Ball Pressure Test, 75°C +/- 2°C	NA	-	IEC 60695-10-2
Vicat Softening Temp, Rate B/120	165	°C	ISO 306
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	46	°C	ISO 75/Af
PHYSICAL			
Density	1.28	g/cm³	ISO 1183
Water Absorption, (23°C/saturated)	0.34	%	ISO 62-1
Moisture Absorption (23°C / 50% RH)	0.08	%	ISO 62
Melt Volume Rate, MVR at 250°C/2.16 kg	26	cm³/10 min	ISO 1133
FLAME CHARACTERISTICS			
UL Yellow Card Link	E45329-101938116	-	-

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
INJECTION MOLDING			
Drying Temperature	60 – 75	°C	
Drying Time	4 – 5	Hrs	
Drying Time (Cumulative)	8	Hrs	
Maximum Moisture Content	0.05	%	
Melt Temperature	250 – 265	°C	
Nozzle Temperature	245 – 260	°C	
Front - Zone 3 Temperature	250 – 265	°C	
Middle - Zone 2 Temperature	245 – 260	°C	
Rear - Zone 1 Temperature	240 – 255	°C	
Mold Temperature	65 – 90	°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	

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