VALOX™ RESIN SHF4330

REGION EUROPE

DESCRIPTION

15% GF reinforced PBT/ASA, High Flow version

TYPICAL PROPERTY VALUES

Revision 20181114

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	85	MPa	ASTM D638
Tensile Stress, brk, Type I, 5 mm/min	85	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	5300	MPa	ASTM D638
Tensile Stress, yield, 5 mm/min	85	MPa	ISO 527
Tensile Stress, break, 5 mm/min	85	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	5400	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	120	MPa	ISO 178
Flexural Stress, break, 2 mm/min	120	MPa	ISO 178
Flexural Strain, break, 2 mm/min	3	%	ISO 178
Flexural Modulus, 2 mm/min	4800	MPa	ISO 178
Ball Indentation Hardness, H358/30	160	MPa	ISO 2039-1
Hardness, Rockwell R	120	-	ISO 2039-2
IMPACT			
Charpy Impact, unnotched, 23°C	30	kJ/m²	ISO 179/2C
Charpy Impact, unnotched, -30°C	20	kJ/m²	ISO 179/2C
Izod Impact, unnotched 80*10*4 +23°C	28	kJ/m²	ISO 180/1U
Izod Impact, unnotched 80*10*4 -30°C	20	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	4	kJ/m²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	4	kJ/m²	ISO 180/1A
Charpy Impact, notched, 23°C	4	kJ/m²	ISO 179/2C
Charpy Impact, notched, -30°C	4	kJ/m²	ISO 179/2C
THERMAL			
Ball Pressure Test, 125°C +/- 2°C	PASSES	-	IEC 60695-10-2
Vicat Softening Temp, Rate A/50	215	°C	ISO 306
Vicat Softening Temp, Rate B/50	157	°C	ISO 306
Vicat Softening Temp, Rate B/120	159	°C	ISO 306
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	204	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	152	°C	ISO 75/Af
PHYSICAL			
Specific Gravity	1.39	-	ASTM D792
Filler Content	15	%	ASTM D229

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Mold Shrinkage on Tensile Bar, flow	0.2 – 0.6	%	SABIC method
Density	1.39	g/cm³	ISO 1183
Melt Volume Rate, MVR at 250°C/5.0 kg	40	cm³/10 min	ISO 1133
Melt Viscosity, 260°C, 1500 sec-1	90	Pa-s	ISO 11443
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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