

Valox* Resin 368

Americas: COMMERCIAL

Flame retardant, impact modified PBT+PC with mold release. Replaces 360E.

Property

TYPICAL PROPERTIES ⁽¹⁾			
MECHANICAL	Value	Unit	Standard
Tensile Stress, yld, Type I, 50 mm/min	44	MPa	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	34	MPa	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	4	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	12	%	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	68	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	1720	MPa	ASTM D 790
IMPACT	Value	Unit	Standard
Izod Impact, notched, 23°C	480	J/m	ASTM D 256
Instrumented Impact Total Energy, 23°C	39	J	ASTM D 3763
THERMAL	Value	Unit	Standard
HDT, 0.45 MPa, 3.2 mm, unannealed	105	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	65	°C	ASTM D 648
PHYSICAL	Value	Unit	Standard
Specific Gravity	1.3	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	0.9 - 1.1	%	SABIC Method

Source GMD, last updated:01/09/1998

Processing

Parameter	Value	Unit
Injection Molding		
Drying Temperature	120	°C
Drying Time	3 - 4	hrs
Drying Time (Cumulative)	12	hrs
Maximum Moisture Content	0.02	%
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

Source GMD, last updated:01/09/1998

THESE PROPERTY VALUES ARE NOT INTENDED FOR SPECIFICATION PURPOSES.

PLEASE CHECK WITH YOUR [\(LOCAL SALES OFFICE\)](#) FOR AVAILABILITY IN YOUR REGION

- (1) Typical values only. Variations within normal tolerances are possible for various colors. All values are measured after at least 48 hours storage at 23°C/50% relative humidity. All properties, except the melt volume and melt flow rates, are measured on injection molded samples. All samples tested under ISO test standards are prepared according to ISO 294.
- (2) Only typical data for selection purposes. Not to be used for part or tool design.
- (3) This rating is not intended to reflect hazards presented by this or any other material under actual fire conditions.
- (4) Internal measurements according to UL standards.

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