

Valox* Resin 815F

Americas: COMMERCIAL

PBT+PET, 15% Glass, Mold Release, Heat Stabilized, For foodcontact applications

Property

TYPICAL PROPERTIES ⁽¹⁾			
	Value	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	90	MPa	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	90	MPa	ASTM D 638
Tensile Strain, yld, Type I, 5 mm/min	3	%	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	3	%	ASTM D 638
Tensile Modulus, 5 mm/min	5000	MPa	ASTM D 638
Flexural Modulus, 1.3 mm/min, 50 mm span	4500	MPa	ASTM D 790
Tensile Stress, yield, 5 mm/min	95	MPa	ISO 527
Tensile Stress, break, 5 mm/min	95	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	145	MPa	ISO 178
Flexural Modulus, 2 mm/min	4700	MPa	ISO 178
IMPACT			
Izod Impact, notched, 23°C	35	J/m	ASTM D 256
Izod Impact, notched, -30°C	30	J/m	ASTM D 256
Instrumented Impact Total Energy, 23°C	6	J	ASTM D 3763
Izod Impact, unnotched 80*10*4 +23°C	30	kJ/m ²	ISO 180/1U
Izod Impact, unnotched 80*10*4 -30°C	25	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	6	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
THERMAL			
Vicat Softening Temp, Rate B/50	185	°C	ASTM D 1525
HDT, 1.82 MPa, 3.2mm, unannealed	160	°C	ASTM D 648
CTE, -40°C to 40°C, flow	4.5E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	5.4E-05	1/°C	ASTM E 831
CTE, 23°C to 80°C, flow	5.5E-05	1/°C	ISO 11359-2
CTE, 23°C to 80°C, xflow	8.5E-05	1/°C	ISO 11359-2
Vicat Softening Temp, Rate B/50	185	°C	ISO 306
Vicat Softening Temp, Rate B/120	190	°C	ISO 306
HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm	175	°C	ISO 75/Ae
PHYSICAL			
Specific Gravity	1.43	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	0.4 - 1	%	SABIC Method
Melt Flow Rate, 266°C/1.2 kgf	16	g/10 min	ASTM D 1238
Density	1.43	g/cm ³	ISO 1183
Water Absorption, (23°C/sat)	0.26	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.06	%	ISO 62

Melt Volume Rate, MVR at 265°C/1.2 kg	12	cm ³ /10 min	ISO 1133
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Source GMD, last updated:09/20/2006

Processing

Parameter	Value	Unit
Injection Molding		
Drying Temperature	120	°C
Drying Time	2 - 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	250 - 270	°C
Rear - Zone 1 Temperature	240 - 260	°C
Hopper Temperature	40 - 60	°C
Mold Temperature	60 - 110	°C

Source GMD, last updated:09/20/2006

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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