

## Valox\* Resin V8280

Americas: DEVELOPMENTAL

40% GR PBT+PET. High stiffness. Excellent surface aesthetics. Applications include office furniture.

### Property

TYPICAL PROPERTIES <sup>(1)</sup>			
MECHANICAL	Value	Unit	Standard
Tensile Stress, yld, Type I, 5 mm/min	145	MPa	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	145	MPa	ASTM D 638
Tensile Strain, yld, Type I, 5 mm/min	2.2	%	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	2.2	%	ASTM D 638
Tensile Modulus, 5 mm/min	12750	MPa	ASTM D 638
Flexural Stress, brk, 1.3 mm/min, 50 mm span	220	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	10680	MPa	ASTM D 790
IMPACT	Value	Unit	Standard
Izod Impact, unnotched, 23°C	827	J/m	ASTM D 4812
Izod Impact, notched, 23°C	106	J/m	ASTM D 256
Instrumented Impact Total Energy, 23°C	7	J	ASTM D 3763
THERMAL	Value	Unit	Standard
Vicat Softening Temp, Rate B/50	221	°C	ASTM D 1525
HDT, 0.45 MPa, 3.2 mm, unannealed	215	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	193	°C	ASTM D 648
CTE, -40°C to 40°C, flow	1.44E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	7.38E-05	1/°C	ASTM E 831
PHYSICAL	Value	Unit	Standard
Specific Gravity	1.64	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	0.2 - 0.5	%	SABIC Method
Mold Shrinkage, xflow, 3.2 mm	0.5 - 0.8	%	SABIC Method
Melt Flow Rate, 266°C/5.0 kgf	33	g/10 min	ASTM D 1238

Source GMD, last updated:03/19/2004

### Processing

Parameter	Value	Unit
Injection Molding		
Drying Temperature	135	°C
Drying Time	4 - 6	hrs
Drying Time (Cumulative)	12	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	270 - 280	°C
Nozzle Temperature	270 - 280	°C
Front - Zone 3 Temperature	270 - 280	°C
Middle - Zone 2 Temperature	270 - 280	°C
Rear - Zone 1 Temperature	260 - 275	°C
Mold Temperature	40 - 65	°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:03/19/2004

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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