

Valox* Resin 325MR

Europe-Africa-Middle East: LIMITED USE

VALOX 325MR is an unreinforced general purpose injection moulding PBT resin with medium flow characteristics and internal mould release. Applications : key buttons for business machines. This grade is a 325 with release.

Property

TYPICAL PROPERTIES ⁽¹⁾			
MECHANICAL	Value	Unit	Standard
Taber Abrasion, CS-17, 1 kg	9	mg/1000cy	SABIC Method
Tensile Stress, yield, 50 mm/min	55	MPa	ISO 527
Tensile Stress, break, 50 mm/min	50	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	6	%	ISO 527
Tensile Strain, break, 50 mm/min	25	%	ISO 527
Tensile Modulus, 1 mm/min	2400	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	80	MPa	ISO 178
Flexural Modulus, 2 mm/min	2300	MPa	ISO 178
Hardness, H358/30	85	MPa	ISO 2039-1
Hardness, Rockwell R	117	-	ISO 2039-2
IMPACT	Value	Unit	Standard
Izod Impact, unnotched 80*10*4 +23°C	NB	kJ/m ²	ISO 180/1U
Izod Impact, unnotched 80*10*4 -30°C	NB	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	6	kJ/m ²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	6	kJ/m ²	ISO 179/1eA
Charpy Impact, notched, 23°C	3	kJ/m ²	ISO 179/2C
Charpy -30°C, V-notch Edgew 80*10*4 sp=62mm	3	kJ/m ²	ISO 179/1eA
Charpy 23°C, Unnotch Edgew 80*10*4 sp=62mm	NB	kJ/m ²	ISO 179/1eU
Charpy -30°C, Unnotch Edgew 80*10*4 sp=62mm	NB	kJ/m ²	ISO 179/1eU
THERMAL	Value	Unit	Standard
Thermal Conductivity	0.16	W/m-°C	ISO 8302
CTE, 23°C to 80°C, flow	1.3E-04	1/°C	ISO 11359-2
CTE, 23°C to 80°C, xflow	1.3E-04	1/°C	ISO 11359-2
Ball Pressure Test, 125°C +/- 2°C	PASSES	-	IEC 60695-10-2
Vicat Softening Temp, Rate B/50	175	°C	ISO 306
Vicat Softening Temp, Rate B/120	175	°C	ISO 306
HDT/Be, 0.45MPa Edgew 120*10*4 sp=100mm	110	°C	ISO 75/Be
HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm	50	°C	ISO 75/Ae
Relative Temp Index, Elec	120	°C	UL 746B
Relative Temp Index, Mech w/impact	120	°C	UL 746B
Relative Temp Index, Mech w/o impact	140	°C	UL 746B
PHYSICAL	Value	Unit	Standard
Mold Shrinkage on Tensile Bar, flow (2)	1.1 - 1.8	%	SABIC Method
Mold Shrinkage on Tensile Bar, xflow (2)	0.9 - 1.8	%	SABIC Method
Density	1.31	g/cm ³	ISO 1183
Water Absorption, (23°C/sat)	0.34	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.08	%	ISO 62

Melt Volume Rate, MVR at 250°C/2.16 kg	15	cm ³ /10 min	ISO 1133
ELECTRICAL	Value	Unit	Standard
Volume Resistivity	>1.E+14	Ohm-cm	IEC 60093
Surface Resistivity, ROA	>1.E+15	Ohm	IEC 60093
Dielectric Strength, in oil, 3.2 mm	18	kV/mm	IEC 60243-1
Relative Permittivity, 50/60 Hz	3.3	-	IEC 60250
Relative Permittivity, 1 MHz	3.1	-	IEC 60250
Dissipation Factor, 50/60 Hz	0.002	-	IEC 60250
Dissipation Factor, 1 MHz	0.02	-	IEC 60250
Comparative Tracking Index	600	V	IEC 60112
FLAME CHARACTERISTICS	Value	Unit	Standard
UL Recognized, 94HB Flame Class Rating (3)	1.5	mm	UL 94
UL Recognized, 94HB Flame Class Rating 2nd value (3)	3	mm	UL 94
Oxygen Index (LOI)	20	%	ISO 4589

Source GMD, last updated:07/29/1999

Processing

Parameter	Value	Unit
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

Source GMD, last updated:07/29/1999

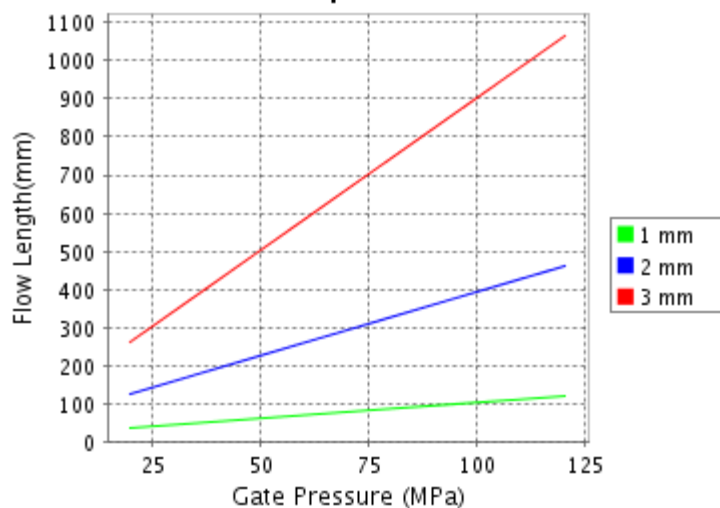
CALCULATED FLOW LENGTH INDICATION

Moldflow® Radial Flow Analysis

Valox® 212HPR

Melt Temperature : 260°C

Mold Temperature : 70°C



Note: Technical support is recommended if Gate Pressure is greater than 80 MPa. Contact your local representative.

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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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