

VALOX™ V8280 resin

Polybutylene Terephthalate + PET

SABIC Innovative Plastics

Message:

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

General Information			
RoHS Compliance	RoHS compliance		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.64	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (266°C/5.0 kg)	33	g/10 min	ASTM D1238
Melt Volume-Flow Rate (MVR) (265°C/5.0 kg)	22.0	cm ³ /10min	ISO 1133
Molding Shrinkage			Internal method
Flow: 3.20mm	0.20 - 0.50	%	Internal method
Transverse flow: 3.20mm	0.50 - 0.80	%	Internal method
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ¹	12800	MPa	ASTM D638
Tensile Strength ²			ASTM D638
Yield	145	MPa	ASTM D638
Fracture	145	MPa	ASTM D638
Tensile Elongation ³			ASTM D638
Yield	2.2	%	ASTM D638
Fracture	2.2	%	ASTM D638
Flexural Modulus ⁴ (50.0 mm Span)	10700	MPa	ASTM D790
Flexural Strength ⁵ (Break, 50.0 mm Span)	221	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	110	J/m	ASTM D256
Unnotched Izod Impact (23°C)	830	J/m	ASTM D4812
Instrumented Dart Impact (23°C, Total Energy)	7.91	J	ASTM D3763
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, unannealed, 3.20mm	216	°C	ASTM D648
1.8 MPa, unannealed, 3.20mm	193	°C	ASTM D648
Vicat Softening Temperature	221	°C	ASTM D1525 ⁶
Linear thermal expansion coefficient			ASTM E831
Flow: -40 to 40°C	1.4E-5	cm/cm/°C	ASTM E831
Lateral: -40 to 40°C	7.4E-5	cm/cm/°C	ASTM E831
Injection	Nominal Value	Unit	

Drying Temperature	135	°C
Drying Time	4.0 - 6.0	hr
Drying Time, Maximum	12	hr
Suggested Max Moisture	0.020	%
Suggested Shot Size	40 - 80	%
Rear Temperature	260 - 277	°C
Middle Temperature	271 - 282	°C
Front Temperature	271 - 282	°C
Nozzle Temperature	271 - 282	°C
Processing (Melt) Temp	271 - 282	°C
Mold Temperature	37.8 - 65.6	°C
Back Pressure	0.345 - 0.689	MPa
Screw Speed	50 - 80	rpm
Vent Depth	0.025 - 0.038	mm

NOTE

1. 5.0 mm/min
2. Type 1, 5.0 mm/min
3. Type 1, 5.0 mm/min
4. 1.3 mm/min
5. 1.3 mm/min
6. 标准 B (120°C/h), 载荷2 (50N)

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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China



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