

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			
Filler / Reinforcement	Glass Fiber,40% Filler by Weight		
Features	Pleasing Surface Appearance		
Uses	Business Equipment		
	Furniture		
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
Molding Shrinkage			Internal Method
Flow : 3.20 mm	0.20 to 0.50	%	
Across Flow : 3.20 mm	0.50 to 0.80	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ¹	12800	MPa	ASTM D638
Tensile Strength ²			ASTM D638
Yield	145	MPa	
Break	145	MPa	
Tensile Elongation ³			ASTM D638
Yield	2.2	%	
Break	2.2	%	
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, 3.20 mm	216	°C	
1.8 MPa, Unannealed, 3.20 mm	193	°C	
Vicat Softening Temperature	221	°C	ASTM D1525 ⁶
CLTE			ASTM E831

Flow : -40 to 40°C	1.4E-5	cm/cm/°C
Transverse : -40 to 40°C	7.4E-5	cm/cm/°C
Injection	Nominal Value	Unit
Drying Temperature	135	°C
Drying Time	4.0 to 6.0	hr
Drying Time, Maximum	12	hr
Suggested Max Moisture	0.020	%
Suggested Shot Size	40 to 80	%
Rear Temperature	260 to 277	°C
Middle Temperature	271 to 282	°C
Front Temperature	271 to 282	°C
Nozzle Temperature	271 to 282	°C
Processing (Melt) Temp	271 to 282	°C
Mold Temperature	37.8 to 65.6	°C
Back Pressure	0.345 to 0.689	MPa
Screw Speed	50 to 80	rpm
Vent Depth	0.025 to 0.038	mm
NOTE		
1.	5.0 mm/min	
2.	Type I, 5.0 mm/min	
3.	Type I, 5.0 mm/min	
4.	1.3 mm/min	
5.	1.3 mm/min	
6.	Rate B (120°C/h), Loading 2 (50 N)	

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