

VALOX™ EH7020 resin

Polybutylene Terephthalate

SABIC Innovative Plastics

Message:

MINERAL FILLED, METALLIZABLE

General Information	
Filler / Reinforcement	Mineral
Features	Metallizable
Processing Method	Injection Molding
Multi-Point Data	Elastic Modulus vs Temperature (ASTM D4065)
	Flexural DMA (ASTM D4065)
	Instrumented Impact (Energy) (ASTM D3763)
	Instrumented Impact (Load) (ASTM D3763)
	Pressure-Volume-Temperature (PVT - Zoller Method)
	Shear DMA (ASTM D4065)
	Specific Heat vs. Temperature (ASTM D3417)
	Tensile Creep (ASTM D2990)
	Tensile Fatigue
	Tensile Stress vs. Strain (ASTM D638)
	Thermal Conductivity vs. Temperature (ASTM E1530)
	Viscosity vs. Shear Rate (ASTM D3835)

Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.49	g/cm ³	ASTM D792
Molding Shrinkage			Internal Method
Flow ¹	1.4 to 1.6	%	
Flow ²	1.5 to 1.6	%	
Across Flow ³	1.3 to 1.4	%	
Across Flow ⁴	1.4 to 1.5	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ⁵ (Break)	57.9	MPa	ASTM D638
Flexural Modulus ⁶ (50.0 mm Span)	4140	MPa	ASTM D790
Flexural Strength ⁷ (Break, 50.0 mm Span)	103	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	32	J/m	ASTM D256
Unnotched Izod Impact (23°C)	390	J/m	ASTM D4812
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed, 6.40 mm	188	°C	

1.8 MPa, Unannealed, 6.40 mm	105	°C	
CLTE - Flow (-40 to 40°C)	5.6E-5	cm/cm/°C	ASTM E831
Electrical	Nominal Value	Unit	Test Method
Dielectric Strength (3.20 mm, in Oil)	17	kV/mm	ASTM D149
Dielectric Constant			ASTM D150
50 Hz	3.10		
60 Hz	3.10		
1 MHz	2.90		
Dissipation Factor			ASTM D150
50 Hz	3.9E-3		
60 Hz	3.9E-3		
1 MHz	0.014		
Injection	Nominal Value	Unit	
Drying Temperature	121	°C	
Drying Time	3.0 to 4.0	hr	
Drying Time, Maximum	12	hr	
Suggested Max Moisture	0.020	%	
Suggested Shot Size	40 to 80	%	
Rear Temperature	238 to 254	°C	
Middle Temperature	243 to 260	°C	
Front Temperature	249 to 266	°C	
Nozzle Temperature	243 to 260	°C	
Processing (Melt) Temp	249 to 266	°C	
Mold Temperature	65.6 to 87.8	°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.	1.5 to 3.2 mm		
2.	3.2 to 4.6 mm		
3.	1.5 to 3.2 mm		
4.	3.2-4.6 mm		
5.	Type I, 5.0 mm/min		
6.	1.3 mm/min		
7.	1.3 mm/min		

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