

VALOX™ PDR7904 resin

Polybutylene Terephthalate

SABIC Innovative Plastics Asia Pacific

Message:

GF filled PBT grade

General Information			
UL YellowCard	E45587-236836		
Filler / Reinforcement	Glass fiber reinforced material		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Melt Mass-Flow Rate (MFR) (250°C/5.0 kg)	36	g/10 min	ASTM D1238
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield)	141	MPa	Internal method
Tensile Elongation ² (Break)	9.7	%	Internal method
Flexural Modulus (6.40 mm)	11000	MPa	ASTM D790
Flexural Strength (Yield, 6.40 mm)	206	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	93	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 6.40 mm)	200	°C	ASTM D648
Flammability	Nominal Value		Test Method
Flame Rating (1.5 mm)	V-0		UL 94
Additional Information	Nominal Value	Unit	Test Method
Filler Content	23	%	ASTM D229
Injection	Nominal Value	Unit	
Drying Temperature	121	°C	
Drying Time	3.0 - 4.0	hr	
Drying Time, Maximum	12	hr	
Suggested Max Moisture	0.020	%	
Suggested Shot Size	40 - 80	%	
Rear Temperature	238 - 254	°C	
Middle Temperature	243 - 260	°C	
Front Temperature	249 - 266	°C	
Nozzle Temperature	243 - 260	°C	
Processing (Melt) Temp	249 - 266	°C	
Mold Temperature	49 - 77	°C	
Back Pressure	0.345 - 0.689	MPa	
Screw Speed	50 - 100	rpm	

Vent Depth	0.025 - 0.038	mm
NOTE		
1.	Type 1, 10mm/min	
2.	Type 1, 10mm/min	

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Recommended distributors for this material

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