

VALOX™ EH7020HF resin

Polybutylene Terephthalate + PET

SABIC Innovative Plastics Asia Pacific

Message:

VALOX EH7020HF is a mineral filled PBT/PET that offers good surface appearance, high flow and good heat performance. EH7020HF was developed for automotive bezel application that requires basecoat + top coat metalization. EH7020HF is higher flow version of EH7020.

General Information			
Filler / Reinforcement	Mineral filler		
Features	High liquidity		
	Heat resistance, high		
	Excellent appearance		
Uses	Application in Automobile Field		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.49	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR)			ASTM D1238
265°C/2.16 kg	64	g/10 min	ASTM D1238
266°C/1.2 kg	36	g/10 min	ASTM D1238
Melt Volume-Flow Rate (MVR) (265°C/2.16 kg)	52.0	cm ³ /10min	ISO 1133
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	5880	MPa	ASTM D638
--	4800	MPa	ISO 527-2/1
Tensile Strength			
Yield ²	56.0	MPa	ASTM D638
Yield	45.0	MPa	ISO 527-2/5
Fracture ³	55.0	MPa	ASTM D638
Fracture	57.0	MPa	ISO 527-2/5
Tensile Elongation			
Yield ⁴	2.0	%	ASTM D638
Yield	1.5	%	ISO 527-2/5
Fracture ⁵	2.0	%	ASTM D638
Fracture	1.9	%	ISO 527-2/5
Flexural Modulus			
50.0mm span ⁶	4680	MPa	ASTM D790
-- ⁷	4710	MPa	ISO 178
Flexural Stress			
--	96.0	MPa	ISO 178

Yield, 50.0mm span ⁸	93.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	27	J/m	ASTM D256
23°C ⁹	2.7	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
1.8 MPa, unannealed, 3.20mm	70.0	°C	ASTM D648
1.8 MPa, unannealed, 100 mm span ¹⁰	77.0	°C	ISO 75-2/Ae
Vicat Softening Temperature	179	°C	ISO 306/B120
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	65.6 - 87.8	°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.	Type 1, 5.0 mm/min		
5.	Type 1, 5.0 mm/min		
6.	1.3 mm/min		
7.	2.0 mm/min		
8.	1.3 mm/min		
9.	80*10*4		
10.	120*10*4 mm		

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