

VALOX™ 815 resin

Polybutylene Terephthalate + PET

SABIC Innovative Plastics

Message:

15% GR PBTP, excellent surface finish. Typical applications are hot air gun housing assemblies, industrial glue guns, appliance housings and handles.

General Information			
UL YellowCard	E45587-236857		
Filler / Reinforcement	Glass fiber reinforced material, 15% filler by weight		
Features	Excellent appearance		
Uses	Handle		
	Electrical appliances		
	Shell		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.43	g/cm ³	ASTM D792
Specific Volume	0.704	cm ³ /g	ASTM D792
Molding Shrinkage			Internal method
Flow ¹	0.40 - 0.60	%	Internal method
Flow ²	0.60 - 0.90	%	Internal method
Transverse flow ³	0.50 - 0.80	%	Internal method
Transverse flow ⁴	0.80 - 1.1	%	Internal method
Water Absorption (24 hr)	0.060	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	119		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ⁵ (Break)	89.6	MPa	ASTM D638
Flexural Modulus ⁶ (50.0 mm Span)	4480	MPa	ASTM D790
Flexural Strength ⁷ (Break, 50.0 mm Span)	138	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	37	J/m	ASTM D256
Unnotched Izod Impact (23°C)	270	J/m	ASTM D4812
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, unannealed, 6.40mm	210	°C	ASTM D648
1.8 MPa, unannealed, 6.40mm	160	°C	ASTM D648
CLTE - Flow			ASTM E831
-40 to 40°C	4.5E-5	cm/cm/°C	ASTM E831
60 to 138°C	5.4E-5	cm/cm/°C	ASTM E831

RTI Elec	125	°C	UL 746
RTI Imp	110	°C	UL 746
RTI	125	°C	UL 746
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	5.6E+16	ohms·cm	ASTM D257
Dielectric Strength			ASTM D149
1.60 mm, in Oil	24	kV/mm	ASTM D149
3.20 mm, in Air	22	kV/mm	ASTM D149
Dielectric Constant			ASTM D150
100 Hz	3.60		ASTM D150
1 MHz	3.50		ASTM D150
Dissipation Factor (100 Hz)	2.0E-3		ASTM D150
Arc Resistance ⁸	PLC 5		ASTM D495
Comparative Tracking Index (CTI)	PLC 2		UL 746
High Amp Arc Ignition (HAI)	PLC 2		UL 746
High Voltage Arc Tracking Rate (HVTR)	PLC 1		UL 746
Hot-wire Ignition (HWI)	PLC 2		UL 746
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.47 mm)	HB		UL 94
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.	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 1, 5.0 mm/min		
6.	1.3 mm/min		
7.	1.3 mm/min		

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