

Valox* Resin 195

Americas: COMMERCIAL

PELLET FORM. For compounding only (not for injection molding). Unreinforced PBT. FDA 21CFR177.1660 compliant. Melt viscosity between 740 and 900 poise. Natural Color (1001) Only.

Property

TYPICAL PROPERTIES ⁽¹⁾			
MECHANICAL	Value	Unit	Standard
Tensile Stress, yld, Type I, 50 mm/min	56	MPa	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	17.9	%	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	84	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	2390	MPa	ASTM D 790
IMPACT	Value	Unit	Standard
Izod Impact, unnotched, 23°C	1850	J/m	ASTM D 4812
Izod Impact, notched, 23°C	53	J/m	ASTM D 256
THERMAL	Value	Unit	Standard
HDT, 0.45 MPa, 6.4 mm, unannealed	128	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	49	°C	ASTM D 648
CTE, -40°C to 40°C, flow	8.1E-05	1/°C	ASTM E 831
CTE, 60°C to 138°C, flow	1.39E-04	1/°C	ASTM E 831
PHYSICAL	Value	Unit	Standard
Specific Gravity	1.31	-	ASTM D 792
Specific Volume	0.76	cm ³ /g	ASTM D 792
Water Absorption, 24 hours	0.08	%	ASTM D 570
Mold Shrinkage, flow, 0.75-2.3 mm	0.9 - 1.6	%	SABIC Method
Mold Shrinkage, flow, 2.3-4.6 mm	1.5 - 2.3	%	SABIC Method
Mold Shrinkage, xflow, 0.75-2.3 mm	1 - 1.7	%	SABIC Method
Mold Shrinkage, xflow, 2.3-4.6 mm	1.6 - 2.4	%	SABIC Method
Melt Viscosity	0	Pa-s	SABIC Method

Source GMD, last updated:11/21/2003

Processing

Parameter	Value	Unit
Compounding Extrusion		
Drying Temperature	110 - 120	°C
Drying Time	4 - 6	hrs
Drying Time (Cumulative)	8	hrs
Maximum Moisture Content	0	%
Melt Temperature	245 - 260	°C
Barrel - Zone 1 Temperature	200 - 230	°C
Barrel - Zone 2 Temperature	240 - 255	°C
Barrel - Zone 3 Temperature	240 - 275	°C
Barrel - Zone 4 Temperature	240 - 275	°C
Adapter Temperature	240 - 275	°C
Die Temperature	240 - 275	°C
Waterbath Temperature	25 - 35	°C

THESE PROPERTY VALUES ARE NOT INTENDED FOR SPECIFICATION PURPOSES.

PLEASE CHECK WITH YOUR [\(LOCAL SALES OFFICE\)](#) FOR AVAILABILITY IN YOUR REGION

(1) Typical values only. Variations within normal tolerances are possible for various colors. All values are measured after at least 48 hours storage at 23°C/50% relative humidity. All properties, except the melt volume and melt flow rates, are measured on injection molded samples. All samples tested under ISO test standards are prepared according to ISO 294.

(2) Only typical data for selection purposes. Not to be used for part or tool design.

(3) This rating is not intended to reflect hazards presented by this or any other material under actual fire conditions.

(4) Internal measurements according to UL standards.

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