

Valox* Resin 307

Americas: LIMITED USE

For Compounding only (not intended for injection molding) Unreinforced, general purpose PBT. Typical viscosity 1700-2100 Poise.

Property

TYPICAL PROPERTIES ⁽¹⁾			
MECHANICAL	Value	Unit	Standard
Tensile Stress, yld, Type I, 50 mm/min	51	MPa	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	300	%	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	82	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	2340	MPa	ASTM D 790
IMPACT	Value	Unit	Standard
Izod Impact, unnotched, 23°C	1602	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	154	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	54	°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	100	Pa-s	SABIC Method

Source GMD, last updated:01/05/2000

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

Source GMD, last updated:01/05/2000

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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