

## Valox\* Resin V2000DM

Americas: COMMERCIAL

Unreinforced, directly metallizable PBT injection molding resin with high flow better release characteristics.

### Property

TYPICAL PROPERTIES <sup>(1)</sup>			
MECHANICAL	Value	Unit	Standard
Tensile Stress, yld, Type I, 50 mm/min	59	MPa	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	40	MPa	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	20	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	100	%	ASTM D 638
Tensile Modulus, 5 mm/min	2800	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	90	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	2570	MPa	ASTM D 790
Tensile Stress, yield, 50 mm/min	59	MPa	ISO 527
Tensile Stress, break, 50 mm/min	55	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	7	%	ISO 527
Tensile Strain, break, 50 mm/min	15	%	ISO 527
Tensile Modulus, 1 mm/min	3000	MPa	ISO 527
Flexural Modulus, 2 mm/min	2500	MPa	ISO 178
IMPACT	Value	Unit	Standard
Izod Impact, unnotched, -30°C	NB	J/m	ASTM D 4812
Izod Impact, notched, 23°C	46	J/m	ASTM D 256
Instrumented Impact Total Energy, 23°C	54	J	ASTM D 3763
Izod Impact, notched 80*10*4 +23°C	5	kJ/m <sup>2</sup>	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	2	kJ/m <sup>2</sup>	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	5	kJ/m <sup>2</sup>	ISO 179/1eA
THERMAL	Value	Unit	Standard
Vicat Softening Temp, Rate B/50	185	°C	ASTM D 1525
HDT, 1.82 MPa, 3.2mm, unannealed	54	°C	ASTM D 648
CTE, -40°C to 40°C, flow	8.4E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	8.E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, flow	8.4E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	8.E-05	1/°C	ISO 11359-2
Vicat Softening Temp, Rate B/50	186	°C	ISO 306
Vicat Softening Temp, Rate B/120	185	°C	ISO 306
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	53	°C	ISO 75/Af
PHYSICAL	Value	Unit	Standard
Specific Gravity	1.32	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	2.1 - 2.4	%	SABIC Method
Melt Flow Rate, 250°C/2.16 kgf	35.4	g/10 min	ASTM D 1238
Density	1.32	g/cm <sup>3</sup>	ISO 1183
Water Absorption, (23°C/sat)	0.08	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.34	%	ISO 62
Melt Volume Rate, MVR at 250°C/2.16 kg	34	cm <sup>3</sup> /10 min	ISO 1133

Source GMD, last updated:03/22/2008

Parameter	Value	Unit
Injection Molding		
Drying Temperature	120	°C
Drying Time	3 - 4	hrs
Drying Time (Cumulative)	12	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	245 - 260	°C
Nozzle Temperature	240 - 255	°C
Front - Zone 3 Temperature	245 - 260	°C
Middle - Zone 2 Temperature	240 - 255	°C
Rear - Zone 1 Temperature	230 - 250	°C
Mold Temperature	50 - 75	°C
Back Pressure	0.3 - 0.7	MPa
Screw Speed	50 - 100	rpm
Shot to Cylinder Size	40 - 80	%
Vent Depth	0.013 - 0.025	mm

Source GMD, last updated:03/22/2008

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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