

VALOX™ FR RESINS 457

REGION EUROPE

DESCRIPTION

VALOX 457 Polybutylene Terephthalate (PBT) resin is a 6.5% glass fiber reinforced, injection moldable grade. This brominated flame retardant PBT has a UL V0 and 5VA rating . VALOX 457 resin is a general purpose resin that is an excellent candidate for a wide variety of electrical component applications.

TYPICAL PROPERTY VALUES

Revision 20191022

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	79	MPa	ASTM D638
Tensile Stress, brk, Type I, 5 mm/min	79	MPa	ASTM D638
Tensile Strain, yld, Type I, 5 mm/min	3	%	ASTM D638
Tensile Strain, brk, Type I, 5 mm/min	3	%	ASTM D638
Tensile Modulus, 5 mm/min	4100	MPa	ASTM D638
Tensile Stress, yield, 5 mm/min	75	MPa	ISO 527
Tensile Stress, break, 5 mm/min	75	MPa	ISO 527
Tensile Strain, yield, 5 mm/min	3	%	ISO 527
Tensile Strain, break, 5 mm/min	3	%	ISO 527
Tensile Modulus, 1 mm/min	4200	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	120	MPa	ISO 178
Flexural Stress, break, 2 mm/min	120	MPa	ISO 178
Flexural Strain, break, 2 mm/min	4	%	ISO 178
Flexural Modulus, 2 mm/min	3700	MPa	ISO 178
Ball Indentation Hardness, H358/30	180	MPa	ISO 2039-1
Hardness, Rockwell R	120	-	ISO 2039-2
IMPACT			
Charpy Impact, unnotched, 23°C	30	kJ/m ²	ISO 179/2C
Charpy Impact, unnotched, -30°C	30	kJ/m ²	ISO 179/2C
Izod Impact, unnotched, 23°C	275	J/m	ASTM D4812
Izod Impact, unnotched, -30°C	320	J/m	ASTM D4812
Izod Impact, notched, 23°C	32	J/m	ASTM D256
Izod Impact, notched, 0°C	32	J/m	ASTM D256
Izod Impact, notched, -30°C	32	J/m	ASTM D256
Izod Impact, unnotched 80*10*4 +23°C	25	kJ/m ²	ISO 180/1U
Izod Impact, unnotched 80*10*4 -30°C	25	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	3	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*4 0°C	3	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	3	kJ/m ²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	7	kJ/m ²	ISO 179/1eA
Charpy Impact, notched, 23°C	4	kJ/m ²	ISO 179/2C
Charpy -30°C, V-notch Edgew 80*10*4 sp=62mm	6	kJ/m ²	ISO 179/1eA
Charpy Impact, notched, -30°C	3	kJ/m ²	ISO 179/2C
Charpy 23°C, Unnotch Edgew 80*10*4 sp=62mm	30	kJ/m ²	ISO 179/1eU

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Charpy -30°C, Unnotch Edgew 80*10*4 sp=62mm	30	kJ/m²	ISO 179/1eU
THERMAL			
Vicat Softening Temp, Rate A/50	220	°C	ASTM D1525
Vicat Softening Temp, Rate B/50	188	°C	ASTM D1525
HDT, 0.45 MPa, 3.2 mm, unannealed	200	°C	ASTM D648
HDT, 1.82 MPa, 3.2mm, unannealed	145	°C	ASTM D648
CTE, -40°C to 40°C, flow	5.72E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	8.82E-05	1/°C	ISO 11359-2
CTE, 23°C to 80°C, flow	8.E-05	1/°C	ISO 11359-2
CTE, 23°C to 80°C, xflow	1.E-04	1/°C	ISO 11359-2
CTE, 23°C to 150°C, flow	6.61E-05	1/°C	ISO 11359-2
CTE, 23°C to 150°C, xflow	1.34E-04	1/°C	ISO 11359-2
Ball Pressure Test, 125°C +/- 2°C	PASSES	-	IEC 60695-10-2
Vicat Softening Temp, Rate A/50	220	°C	ISO 306
Vicat Softening Temp, Rate B/50	190	°C	ISO 306
Vicat Softening Temp, Rate B/120	210	°C	ISO 306
HDT/Be, 0.45MPa Edgew 120*10*4 sp=100mm	200	°C	ISO 75/Be
HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm	140	°C	ISO 75/Ae
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	200	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	145	°C	ISO 75/Af
Relative Temp Index, Elec	120	°C	UL 746B
Relative Temp Index, Mech w/impact	120	°C	UL 746B
Relative Temp Index, Mech w/o impact	140	°C	UL 746B
PHYSICAL			
Specific Gravity	1.44	-	ASTM D792
Filler Content	7	%	ASTM D229
Mold Shrinkage on Tensile Bar, flow	0.8 – 1	%	SABIC method
Mold Shrinkage on Tensile Bar, xflow	0.9 – 1.2	%	SABIC method
Melt Flow Rate, 266°C/5.0 kgf	65	g/10 min	ASTM D1238
Density	1.45	g/cm³	ISO 1183
Water Absorption, (23°C/saturated)	0.28	%	ISO 62-1
Moisture Absorption (23°C / 50% RH)	0.06	%	ISO 62
Melt Volume Rate, MVR at 250°C/2.16 kg	11	cm³/10 min	ISO 1133
Melt Volume Rate, MVR at 250°C/5.0 kg	30	cm³/10 min	ISO 1133
Melt Volume Rate, MVR at 265°C/5.0 kg	55	cm³/10 min	ISO 1133
Melt Viscosity, 260°C, 1500 sec-1	190	Pa-s	ISO 11443
ELECTRICAL			
Volume Resistivity	>5.5E+16	Ω.cm	ASTM D257
Dielectric Strength, in oil, 1.6 mm	23	kV/mm	ASTM D149
Dielectric Strength, in oil, 3.2 mm	15	kV/mm	ASTM D149
Relative Permittivity, 1 MHz	3.4	-	ASTM D150
Dissipation Factor, 1 MHz	0.02	-	ASTM D150
Hot Wire Ignition {PLC}	3	PLC Code	UL 746A
High Voltage Arc Track Rate {PLC}	4	PLC Code	UL 746A
High Voltage Arc Resistance {PLC}	7	PLC Code	UL 746A

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
High Ampere Arc Ign, surface {PLC}	3	PLC Code	UL 746A
Comparative Tracking Index (UL) {PLC}	3	PLC Code	UL 746A
Volume Resistivity	>1.E+15	Ω .cm	IEC 60093
Surface Resistivity, ROA	>1.E+15	Ω	IEC 60093
Dielectric Strength, in oil, 0.8 mm	29	kV/mm	IEC 60243-1
Dielectric Strength, in oil, 1.6 mm	23	kV/mm	IEC 60243-1
Dielectric Strength, in oil, 3.2 mm	15	kV/mm	IEC 60243-1
Relative Permittivity, 100 Hz	3.5	-	IEC 60250
Relative Permittivity, 1 MHz	3.4	-	IEC 60250
Dissipation Factor, 50/60 Hz	0.002	-	IEC 60250
Dissipation Factor, 100 Hz	0.002	-	IEC 60250
Dissipation Factor, 1 MHz	0.02	-	IEC 60250
Comparative Tracking Index	175	V	IEC 60112
Relative Permittivity, 50/60 Hz	3	-	IEC 60250
FLAME CHARACTERISTICS			
UL Yellow Card Link	E45329-236603	-	-
UL Recognized, 94V-0 Flame Class Rating	0.71	mm	UL 94
UL Recognized, 94-5VA Flame Class Rating	3	mm	UL 94
Glow Wire Flammability Index 960°C, passes at	1	mm	IEC 60695-2-12
Oxygen Index (LOI)	30	%	ISO 4589
INJECTION MOLDING			
Drying Temperature	110 – 120	°C	
Drying Time	2 – 4	Hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	250 – 270	°C	
Nozzle Temperature	240 – 260	°C	
Front - Zone 3 Temperature	245 – 265	°C	
Middle - Zone 2 Temperature	240 – 255	°C	
Rear - Zone 1 Temperature	230 – 245	°C	
Hopper Temperature	40 – 60	°C	
Mold Temperature	40 – 100	°C	

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