



VALOX™ Resin 215HPR
Americas: COMMERCIAL

Unreinforced PBT with mold release. FDA food contact compliant in limited colors. Effective March 2008 this grade will no longer be supported with biocompatibility data. Alternative grade VALOX HX215HP.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	520	kgf/cm ²	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	10	%	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	840	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	23900	kgf/cm ²	ASTM D 790
IMPACT			
Izod Impact, unnotched, 23°C	163	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	5	cm-kgf/cm	ASTM D 256
Modified Gardner, 23°C	414	cm-kgf	ASTM D 3029
THERMAL			
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			
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 (5)	0.9 - 1.6	%	SABIC Method
Mold Shrinkage, flow, 2.3-4.6 mm (5)	1.5 - 2.3	%	SABIC Method
Mold Shrinkage, xflow, 0.75-2.3 mm (5)	1 - 1.7	%	SABIC Method
Mold Shrinkage, xflow, 2.3-4.6 mm (5)	1.6 - 2.4	%	SABIC Method
Melt Viscosity	1100	poise	SABIC Method

(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.

(5) Measurements made from laboratory test coupon. Actual shrinkage may vary outside of range due to differences in processing conditions, equipment, part geometry and tool design. It is recommended that mold shrinkage studies be performed with surrogate or legacy tooling prior to cutting tools for new molded article.

(6) Needs hard coat to consistently pass 60 sec Vertical Burn.

Source GMD, last updated:

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PROCESSING PARAMETERS	TYPICAL 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

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