VALOX™ FR RESIN ENH4565

REGION AMERICAS

DESCRIPTION

VALOX ENH4565 is a 33% glass reinforced, non-chlorinated/brominated flame retardant Polybutylene Terephthalate (PBT) injection moldable grade with excellent chemical resistance. It has a UL94V0@0.75mm flame rating. This is a good candidate for a variety of applications needing a sustainable FRPBT solution.

TYPICAL PROPERTY VALUES

Revision 20231109

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL [1]			
Tensile Stress, yld, Type I, 5 mm/min	137	MPa	ASTM D638
Tensile Stress, brk, Type I, 5 mm/min	137	MPa	ASTM D638
Tensile Strain, yld, Type I, 5 mm/min	2.4	%	ASTM D638
Tensile Strain, brk, Type I, 5 mm/min	2.4	%	ASTM D638
Tensile Modulus, 5 mm/min	11600	MPa	ASTM D638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	180	MPa	ASTM D790
Flexural Modulus, 1.3 mm/min, 50 mm span	9400	MPa	ASTM D790
Tensile Stress, yield, 5 mm/min	140	MPa	ISO 527
Tensile Stress, break, 5 mm/min	140	MPa	ISO 527
Tensile Strain, yield, 5 mm/min	2.4	%	ISO 527
Tensile Strain, break, 5 mm/min	2.4	%	ISO 527
Tensile Modulus, 1 mm/min	11500	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	185	MPa	ISO 178
Flexural Modulus, 2 mm/min	9400	MPa	ISO 178
IMPACT [1]			
Charpy Impact, unnotched, 23°C	60	kJ/m²	ISO 179/2C
Charpy Impact, unnotched, -30°C	60	kJ/m²	ISO 179/2C
Izod Impact, unnotched, 23°C	800	J/m	ASTM D4812
Izod Impact, unnotched, -30°C	600	J/m	ASTM D4812
Izod Impact, notched, 23°C	80	J/m	ASTM D256
Izod Impact, notched, -30°C	60	J/m	ASTM D256
Instrumented Dart Impact Total Energy, 23°C	9	J	ASTM D3763
Izod Impact, notched 80*10*4 +23°C	14	kJ/m²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	14	kJ/m²	ISO 180/1A
Charpy Impact, notched, 23°C	12	kJ/m²	ISO 179/2C
Charpy Impact, notched, -30°C	12	kJ/m²	ISO 179/2C
THERMAL [1]			
Vicat Softening Temp, Rate B/50	205	°C	ASTM D1525
HDT, 0.45 MPa, 3.2 mm, unannealed	218	°C	ASTM D648
HDT, 1.82 MPa, 3.2mm, unannealed	206	°C	ASTM D648
CTE, -40°C to 40°C, flow	1.9E-05	1/°C	ASTM E831
CTE, -40°C to 40°C, xflow	7.E-05	1/°C	ASTM E831
CTE, -40°C to 150°C, flow	2.E-05	1/°C	ASTM E831
CTE, -40°C to 150°C, xflow	9.8E-05	1/°C	ASTM E831

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
CTE, -40°C to 40°C, flow	1.9E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	7.E-05	1/°C	ISO 11359-2
CTE, 23°C to 80°C, flow	1.9E-05	1/°C	ISO 11359-2
CTE, 23°C to 80°C, xflow	8.E-05	1/°C	ISO 11359-2
Ball Pressure Test, 125°C +/- 2°C	Pass	-	IEC 60695-10-2
PHYSICAL (1)			
Specific Gravity	1.6	-	ASTM D792
Mold Shrinkage on Tensile Bar, flow (2)	0.1 – 0.4	%	SABIC method
Mold Shrinkage, flow, 3.2 mm (2)	0.1 – 0.4	%	SABIC method
Mold Shrinkage on Tensile Bar, xflow (2)	0.4 – 0.8	%	SABIC method
Mold Shrinkage, xflow, 3.2 mm (2)	0.4 – 0.8	%	SABIC method
Melt Flow Rate, 250°C/5.0 kgf	24	g/10 min	ASTM D1238
Density	1.61	g/cm³	ISO 1183
Water Absorption, (23°C/saturated)	0.23	%	ISO 62-1
Moisture Absorption (23°C / 50% RH)	0.06	%	ISO 62
Melt Volume Rate, MVR at 250°C/5.0 kg	18	cm³/10 min	ISO 1133
Melt Volume Rate, MVR at 265°C/5.0 kg	20	cm³/10 min	ISO 1133
INJECTION MOLDING (3)			
Drying Temperature	110 – 120	°C	
Drying Time	2 – 4	Hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	245 – 260	°C	
Nozzle Temperature	230 – 255	°C	
Front - Zone 3 Temperature	240 – 260	°C	
Middle - Zone 2 Temperature	235 – 250	°C	
Rear - Zone 1 Temperature	230 – 240	°C	
Hopper Temperature	40 – 60	°C	
Mold Temperature	40 – 100	°C	

(1) The information stated on Technical Datasheets should be used as indicative only for material selection purposes and not be utilized as specification or used for part or tool design.

(2) 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.,The information stated on Technical Datasheets should be used as indicative only for material selection purposes and not be utilized as specification or used for part or tool design.

(3) Injection Molding parameters are only mentioned as general guidelines. These may not apply or may need adjustment in specific situations such as low shot sizes, large part molding, thin wall molding and gas-assist molding.

DISCLAIMER