

## Valox\* Resin VX3608C

## Europe-Africa-Middle East: COMMERCIAL

VALOX VX3608C is an impact modified, flame retardant PBT+PC injection moulding resin. Application: electrical enclosures. This grade is 3607U with reduced oxygen index.

### Property

TYPICAL PROPERTIES <sup>(1)</sup>			
MECHANICAL	Value	Unit	Standard
Taber Abrasion, CS-17, 1 kg	33	mg/1000cy	SABIC Method
Tensile Stress, yield, 50 mm/min	45	MPa	ISO 527
Tensile Stress, break, 50 mm/min	40	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	5	%	ISO 527
Tensile Strain, break, 50 mm/min	35	%	ISO 527
Tensile Modulus, 1 mm/min	1850	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	65	MPa	ISO 178
Flexural Modulus, 2 mm/min	1800	MPa	ISO 178
Hardness, H358/30	87	MPa	ISO 2039-1
IMPACT	Value	Unit	Standard
Izod Impact, unnotched 80*10*4 +23°C	NB	kJ/m <sup>2</sup>	ISO 180/1U
Izod Impact, unnotched 80*10*4 -30°C	NB	kJ/m <sup>2</sup>	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	50	kJ/m <sup>2</sup>	ISO 180/1A
Izod Impact, notched 80*10*4 -10°C	40	kJ/m <sup>2</sup>	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	20	kJ/m <sup>2</sup>	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	50	kJ/m <sup>2</sup>	ISO 179/1eA
Charpy -30°C, V-notch Edgew 80*10*4 sp=62mm	18	kJ/m <sup>2</sup>	ISO 179/1eA
Charpy 23°C, Unnotch Edgew 80*10*4 sp=62mm	NB	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy -30°C, Unnotch Edgew 80*10*4 sp=62mm	NB	kJ/m <sup>2</sup>	ISO 179/1eU
THERMAL	Value	Unit	Standard
CTE, 23°C to 60°C, flow	1.05E-04	1/°C	ISO 11359-2
CTE, 23°C to 60°C, xflow	1.1E-04	1/°C	ISO 11359-2
Ball Pressure Test, 125°C +/- 2°C	PASSES	-	IEC 60695-10-2
Vicat Softening Temp, Rate A/50	165	°C	ISO 306
Vicat Softening Temp, Rate B/50	130	°C	ISO 306
Vicat Softening Temp, Rate B/120	135	°C	ISO 306
HDT/Be, 0.45MPa Edgew 120*10*4 sp=100mm	120	°C	ISO 75/Be
HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm	80	°C	ISO 75/Ae
PHYSICAL	Value	Unit	Standard
Mold Shrinkage on Tensile Bar, flow (2)	1 - 1.8	%	SABIC Method
Mold Shrinkage on Tensile Bar, xflow (2)	0.9 - 1.8	%	SABIC Method
Density	1.3	g/cm <sup>3</sup>	ISO 1183
Water Absorption, (23°C/sat)	0.45	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.15	%	ISO 62
Melt Volume Rate, MVR at 250°C/5.0 kg	9	cm <sup>3</sup> /10 min	ISO 1133
ELECTRICAL	Value	Unit	Standard
Volume Resistivity	>1.E+15	Ohm-cm	IEC 60093
Surface Resistivity, ROA	>1.E+15	Ohm	IEC 60093

Dielectric Strength, in oil, 3.2 mm	16	kV/mm	IEC 60243-1
Relative Permittivity, 50/60 Hz	2.8	-	IEC 60250
Relative Permittivity, 1 MHz	2.7	-	IEC 60250
Dissipation Factor, 50/60 Hz	0.003	-	IEC 60250
Dissipation Factor, 1 MHz	0.013	-	IEC 60250
Comparative Tracking Index	225	V	IEC 60112
<b>FLAME CHARACTERISTICS</b>			
	Value	Unit	Standard
UL Compliant, 94V-2 Flame Class Rating (3)(4)	1.6	mm	UL 94 by GE
UL Compliant, 94V-1 Flame Class Rating (3)(4)	2	mm	UL 94 by GE
UL Compliant, 94V-0 Flame Class Rating (3)(4)	4	mm	UL 94 by GE
Glow Wire Flammability Index 850°C, passes at	2.5	mm	IEC 60695-2-12
Glow Wire Flammability Index 960°C, passes at	3.2	mm	IEC 60695-2-12
Oxygen Index (LOI)	25	%	ISO 4589

Source GMD, last updated:04/26/2000

### Processing

Parameter	Value	Unit
<b>Injection Molding</b>		
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

Source GMD, last updated:04/26/2000

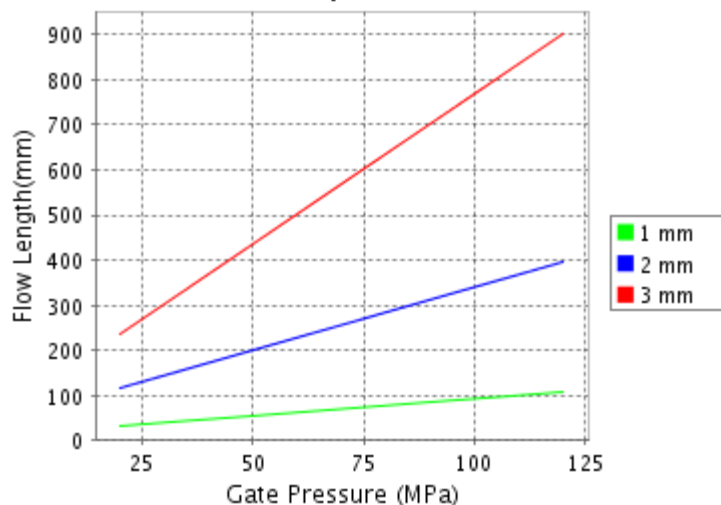
### CALCULATED FLOW LENGTH INDICATION

Moldflow® Radial Flow Analysis

Valox® V3001MC

Melt Temperature : 260°C

Mold Temperature : 70°C



**Note: Technical support is recommended if Gate Pressure is greater than 80 MPa. Contact your local representative.**

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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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