



**VALOX™ Resin V3900WX**  
**Americas: COMMERCIAL**

PBT/PC blend - Unreinforced - Flame Retardant. This is a UV-stabilized grade designed for outdoor enclosure applications requiring UL 746C F1 weatherability performance.

TYPICAL PROPERTIES <sup>1</sup>	TYPICAL VALUE	Unit	Standard
<b>MECHANICAL</b>			
Tensile Stress, yield	480	kgf/cm <sup>2</sup>	SABIC - Japan Method
Tensile Stress, yld, Type I, 50 mm/min	540	kgf/cm <sup>2</sup>	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	430	kgf/cm <sup>2</sup>	ASTM D 638
Tensile Strain, break	250	%	SABIC - Japan Method
Tensile Strain, yld, Type I, 50 mm/min	5	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	50	%	ASTM D 638
Tensile Modulus, 5 mm/min	22400	kgf/cm <sup>2</sup>	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	810	kgf/cm <sup>2</sup>	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	22400	kgf/cm <sup>2</sup>	ASTM D 790
Tensile Stress, yield, 50 mm/min	51	MPa	ISO 527
Tensile Stress, break, 50 mm/min	40	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	4	%	ISO 527
Tensile Strain, break, 50 mm/min	42	%	ISO 527
Tensile Modulus, 1 mm/min	2090	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	73	MPa	ISO 178
Flexural Modulus, 2 mm/min	2130	MPa	ISO 178
<b>IMPACT</b>			
Izod Impact, notched, 23°C	81	cm-kgf/cm	ASTM D 256
Izod Impact, notched, -30°C	11	cm-kgf/cm	ASTM D 256
Instrumented Impact Total Energy, 23°C	509	cm-kgf	ASTM D 3763
Instrumented Impact Total Energy, -40°C	509	cm-kgf	ASTM D 3763
Izod Impact, notched 80*10*4 +23°C	41	kJ/m <sup>2</sup>	ISO 180/1A

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(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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<b>IMPACT</b>			
Izod Impact, notched 80*10*4 -30°C	8	kJ/m <sup>2</sup>	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	52	kJ/m <sup>2</sup>	ISO 179/1eA
<b>THERMAL</b>			
Vicat Softening Temp, Rate B/50	105	°C	ASTM D 1525
HDT, 1.82 MPa, 3.2mm, unannealed	75	°C	ASTM D 648
HDT, 0.45 MPa, 6.4 mm, unannealed	119	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	96	°C	ASTM D 648
CTE, -40°C to 40°C, flow	8.84E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	8.97E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, flow	8.84E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	8.97E-05	1/°C	ISO 11359-2
Ball Pressure Test, 125°C +/- 2°C	PASSES	-	IEC 60695-10-2
Vicat Softening Temp, Rate B/50	121	°C	ISO 306
Vicat Softening Temp, Rate B/120	123	°C	ISO 306
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	77	°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	120	°C	UL 746B
<b>PHYSICAL</b>			
Specific Gravity	1.3	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm (5)	0.7 - 1	%	SABIC Method
Melt Flow Rate, 265°C/2.16kgf	11	g/10 min	ASTM D 1238
Density	1.3	g/cm <sup>3</sup>	ISO 1183
Water Absorption, (23°C/sat)	0.1	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.03	%	ISO 62

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<b>PHYSICAL</b>			
Melt Volume Rate, MVR at 265°C/2.16 kg	9	cm <sup>3</sup> /10 min	ISO 1133
<b>ELECTRICAL</b>			
Surface Resistivity	6.02E+16	Ohm	ASTM D 257
Dissipation Factor, 1 MHz	0.0199	-	ASTM D 150
<b>FLAME CHARACTERISTICS</b>			
UL Recognized, 94V-0 Flame Class Rating (3)	1.5	mm	UL 94
UL Recognized, 94-5VA Rating (3)	3	mm	UL 94
Glow Wire Flammability Index 960°C, passes at	1	mm	IEC 60695-2-12
Glow Wire Flammability Index 960°C, passes at, by VDE	3	mm	IEC 60695-2-12
Glow Wire Ignitability Temperature, 1.0 mm	825	°C	IEC 60695-2-13
Glow Wire Ignitability Temperature, 3.0 mm	725	°C	IEC 60695-2-13
UV-light, water exposure/immersion	F1	-	UL 746C

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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
<b>Injection Molding</b>		
Drying Temperature	120	°C
Drying Time	3 - 4	hrs
Drying Time (Cumulative)	12	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	250 - 265	°C
Nozzle Temperature	245 - 260	°C
Front - Zone 3 Temperature	250 - 265	°C
Middle - Zone 2 Temperature	245 - 260	°C
Rear - Zone 1 Temperature	240 - 255	°C
Mold Temperature	65 - 90	°C
Back Pressure	0.3 - 0.7	MPa
Screw Speed	50 - 80	rpm
Shot to Cylinder Size	40 - 80	%
Vent Depth	0.025 - 0.038	mm

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