



**VALOX™ Resin 310SE0**  
**Americas: COMMERCIAL**

VALOX 310SE0 is an unreinforced, flame retardant PBT injection moulding resin. Applications: electrical industry, bobbins, keyboard, switches and switch components and appliance housings.

TYPICAL PROPERTIES <sup>1</sup>	TYPICAL VALUE	Unit	Standard
<b>MECHANICAL</b>			
Tensile Stress, yld, Type I, 50 mm/min	590	kgf/cm <sup>2</sup>	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	590	kgf/cm <sup>2</sup>	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	20	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	20	%	ASTM D 638
Tensile Modulus, 5 mm/min	28700	kgf/cm <sup>2</sup>	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	1020	kgf/cm <sup>2</sup>	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	26700	kgf/cm <sup>2</sup>	ASTM D 790
Taber Abrasion, CS-17, 1 kg	19	mg/1000cy	SABIC Method
Tensile Stress, yield, 50 mm/min	55	MPa	ISO 527
Tensile Stress, break, 50 mm/min	40	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	6	%	ISO 527
Tensile Strain, break, 50 mm/min	20	%	ISO 527
Tensile Modulus, 1 mm/min	2800	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	90	MPa	ISO 178
Flexural Modulus, 2 mm/min	2600	MPa	ISO 178
Hardness, H358/30	105	MPa	ISO 2039-1
Hardness, Rockwell R	120	-	ISO 2039-2
<b>IMPACT</b>			
Izod Impact, unnotched, 23°C	163	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	3	cm-kgf/cm	ASTM D 256
Izod Impact, notched, -30°C	2	cm-kgf/cm	ASTM D 256
Instrumented Impact Total Energy, 23°C	2039	cm-kgf	ASTM D 3763

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

Source GMD, last updated:

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<b>IMPACT</b>			
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	5	kJ/m <sup>2</sup>	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	3	kJ/m <sup>2</sup>	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	8	kJ/m <sup>2</sup>	ISO 179/1eA
Charpy Impact, notched, 23°C	4	kJ/m <sup>2</sup>	ISO 179/2C
Charpy -30°C, V-notch Edgew 80*10*4 sp=62mm	4	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
<b>THERMAL</b>			
Vicat Softening Temp, Rate B/50	165	°C	ASTM D 1525
HDT, 1.82 MPa, 3.2mm, unannealed	74	°C	ASTM D 648
HDT, 0.45 MPa, 6.4 mm, unannealed	162	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	71	°C	ASTM D 648
CTE, -40°C to 40°C, flow	7.92E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	7.92E-05	1/°C	ASTM E 831
CTE, 60°C to 138°C, flow	1.31E-04	1/°C	ASTM E 831
Thermal Conductivity	0.24	W/m-°C	ISO 8302
CTE, -40°C to 40°C, flow	7.6E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	7.3E-05	1/°C	ISO 11359-2
CTE, 23°C to 60°C, flow	1.E-04	1/°C	ISO 11359-2
CTE, 23°C to 60°C, xflow	1.E-04	1/°C	ISO 11359-2
Ball Pressure Test, 125°C +/- 2°C	PASSES	-	IEC 60695-10-2
Vicat Softening Temp, Rate A/50	212	°C	ISO 306

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<b>THERMAL</b>			
Vicat Softening Temp, Rate B/50	165	°C	ISO 306
Vicat Softening Temp, Rate B/120	165	°C	ISO 306
HDT/Be, 0.45MPa Edgew 120*10*4 sp=100mm	135	°C	ISO 75/Be
HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm	60	°C	ISO 75/Ae
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	71	°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
<b>PHYSICAL</b>			
Specific Gravity	1.4	-	ASTM D 792
Specific Volume	0.71	cm <sup>3</sup> /g	ASTM D 792
Mold Shrinkage on Tensile Bar, flow (2) (5)	1.1 - 1.8	%	SABIC Method
Mold Shrinkage, flow, 3.2 mm (5)	1.5 - 2.3	%	SABIC Method
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 on Tensile Bar, xflow (2) (5)	0.9 - 1.9	%	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 Flow Rate, 250°C/2.16 kgf	8.6	g/10 min	ASTM D 1238
Density	1.4	g/cm <sup>3</sup>	ISO 1183
Water Absorption, (23°C/sat)	0.36	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.08	%	ISO 62
Melt Volume Rate, MVR at 250°C/2.16 kg	8	cm <sup>3</sup> /10 min	ISO 1133
<b>ELECTRICAL</b>			
Dielectric Strength, in air, 3.2 mm	18.4	kV/mm	ASTM D 149
Dielectric Strength, in oil, 1.6 mm	22	kV/mm	ASTM D 149
Arc Resistance, Tungsten {PLC}	6	PLC Code	ASTM D 495
Hot Wire Ignition {PLC}	2	PLC Code	UL 746A

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<b>ELECTRICAL</b>			
High Voltage Arc Track Rate {PLC}	4	PLC Code	UL 746A
High Voltage Arc Resistance {PLC}	6	PLC Code	UL 746A
High Ampere Arc Ign, surface {PLC}	0	PLC Code	UL 746A
Comparative Tracking Index (UL) {PLC}	3	PLC Code	UL 746A
Volume Resistivity	>1.E+15	Ohm-cm	IEC 60093
Surface Resistivity, ROA	>1.E+15	Ohm	IEC 60093
Dielectric Strength, shorttime, 1.0mm	18	kV/mm	IEC 60243-1
Dielectric Strength, in oil, 0.8 mm	31	kV/mm	IEC 60243-1
Dielectric Strength, in oil, 1.6 mm	24	kV/mm	IEC 60243-1
Dielectric Strength, in oil, 3.2 mm	15	kV/mm	IEC 60243-1
Relative Permittivity, 100 Hz	3.1	-	IEC 60250
Relative Permittivity, 1 MHz	2.8	-	IEC 60250
Dissipation Factor, 50/60 Hz	0.001	-	IEC 60250
Dissipation Factor, 100 Hz	0.002	-	IEC 60250
Dissipation Factor, 1 MHz	0.01	-	IEC 60250
Comparative Tracking Index	175	V	IEC 60112
Comparative Tracking Index, M	100	V	IEC 60112
Relative Permittivity, 50/60 Hz	2.9	-	IEC 60250
<b>FLAME CHARACTERISTICS</b>			
UL Recognized, 94V-0 Flame Class Rating (3)	0.71	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
Oxygen Index (LOI)	30	%	ISO 4589

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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	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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