

Valox* Resin 327

Americas: COMMERCIAL

Unreinforced, impact modified polyester, high ductility and good processability.

Property

TYPICAL PROPERTIES ⁽¹⁾			
MECHANICAL	Value	Unit	Standard
Tensile Stress, yld, Type I, 50 mm/min	48	MPa	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	200	%	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	82	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	2200	MPa	ASTM D 790
IMPACT	Value	Unit	Standard
Izod Impact, notched, 23°C	80	J/m	ASTM D 256
THERMAL	Value	Unit	Standard
HDT, 0.45 MPa, 6.4 mm, unannealed	151	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	54	°C	ASTM D 648
PHYSICAL	Value	Unit	Standard
Specific Gravity	1.29	-	ASTM D 792
Specific Volume	0.77	cm ³ /g	ASTM D 792
Water Absorption, 24 hours	0.08	%	ASTM D 570
Mold Shrinkage, flow, 0.75-2.3 mm	1.4 - 1.8	%	SABIC Method
Mold Shrinkage, flow, 2.3-4.6 mm	1.7 - 2.3	%	SABIC Method
Mold Shrinkage, xflow, 0.75-2.3 mm	1.4 - 1.8	%	SABIC Method
Mold Shrinkage, xflow, 2.3-4.6 mm	1.7 - 2.2	%	SABIC Method
ELECTRICAL	Value	Unit	Standard
Volume Resistivity	1.E+17	Ohm-cm	ASTM D 257
Dielectric Strength, in air, 0.8 mm	15.9	kV/mm	ASTM D 149
Relative Permittivity, 1 MHz	2.9	-	ASTM D 150
Dissipation Factor, 1 MHz	0.02	-	ASTM D 150

Source GMD, last updated:01/05/2000

Processing

Parameter	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

Source GMD, last updated:01/05/2000

THESE PROPERTY VALUES ARE NOT INTENDED FOR SPECIFICATION PURPOSES.

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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