



VALOX™ Resin 309
Americas: COMMERCIAL

PBT, For compounding only. Not intended for Injection Molding. Melt viscosity: 250C at 21.6 kgf is 3500-4500. Available in Natural (1001) only.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	330	kgf/cm ²	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	550	kgf/cm ²	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	127	%	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	780	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	22000	kgf/cm ²	ASTM D 790
IMPACT			
Izod Impact, unnotched, 23°C	206	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	6	cm-kgf/cm	ASTM D 256
THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	115	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	45	°C	ASTM D 648
PHYSICAL			
Specific Gravity	1.31	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm (5)	1.9 - 2.1	%	SABIC Method
Mold Shrinkage, xflow, 3.2 mm (5)	2 - 2.2	%	SABIC Method
Melt Viscosity	4000	poise	SABIC Method

(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.

(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.

Source GMD, last updated:

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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Compounding Extrusion		
Drying Temperature	110 - 120	°C
Drying Time	4 - 6	hrs
Drying Time (Cumulative)	8	hrs
Maximum Moisture Content	0	%
Melt Temperature	245 - 260	°C
Barrel - Zone 1 Temperature	200 - 230	°C
Barrel - Zone 2 Temperature	240 - 255	°C
Barrel - Zone 3 Temperature	240 - 275	°C
Barrel - Zone 4 Temperature	240 - 275	°C
Adapter Temperature	240 - 275	°C
Die Temperature	240 - 275	°C
Waterbath Temperature	25 - 35	°C

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