



VALOX™ Resin 553
Europe-Africa-Middle East: COMMERCIAL

VALOX 553 is a 30% glass fibre reinforced, flame retardant PBT+PC blend with good warpage characteristics. Applications: appliance handles, spotlights, electric motors, pumphousings.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	140	MPa	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	140	MPa	ASTM D 638
Tensile Strain, yld, Type I, 5 mm/min	2	%	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	3	%	ASTM D 638
Tensile Modulus, 5 mm/min	10700	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	190	MPa	ASTM D 790
Flexural Stress, brk, 1.3 mm/min, 50 mm span	190	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	9400	MPa	ASTM D 790
Tensile Stress, yield, 5 mm/min	135	MPa	ISO 527
Tensile Stress, break, 5 mm/min	135	MPa	ISO 527
Tensile Strain, yield, 5 mm/min	2	%	ISO 527
Tensile Strain, break, 5 mm/min	2	%	ISO 527
Tensile Modulus, 1 mm/min	11000	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	205	MPa	ISO 178
Flexural Stress, break, 2 mm/min	200	MPa	ISO 178
Flexural Strain, break, 2 mm/min	3	%	ISO 178
Flexural Modulus, 2 mm/min	9500	MPa	ISO 178
Hardness, H358/30	132	MPa	ISO 2039-1
Hardness, Rockwell R	118	-	ISO 2039-2
IMPACT			
Charpy Impact, unnotched, 23°C	60	kJ/m ²	ISO 179/2C
Charpy Impact, unnotched, -30°C	55	kJ/m ²	ISO 179/2C

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(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.

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TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
IMPACT			
Izod Impact, unnotched, 23°C	770	J/m	ASTM D 4812
Izod Impact, unnotched, -30°C	770	J/m	ASTM D 4812
Izod Impact, notched, 23°C	100	J/m	ASTM D 256
Izod Impact, notched, 0°C	95	J/m	ASTM D 256
Izod Impact, notched, -30°C	90	J/m	ASTM D 256
Instrumented Impact Total Energy, 23°C	8	J	ASTM D 3763
Izod Impact, unnotched 80*10*4 +23°C	53	kJ/m ²	ISO 180/1U
Izod Impact, unnotched 80*10*4 -30°C	52	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	10	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*4 0°C	10	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	9	kJ/m ²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	8	kJ/m ²	ISO 179/1eA
Charpy Impact, notched, 23°C	11	kJ/m ²	ISO 179/2C
Charpy -30°C, V-notch Edgew 80*10*4 sp=62mm	8	kJ/m ²	ISO 179/1eA
Charpy Impact, notched, -30°C	11	kJ/m ²	ISO 179/2C
Charpy 23°C, Unnotch Edgew 80*10*4 sp=62mm	NB	kJ/m ²	ISO 179/1eU
Charpy -30°C, Unnotch Edgew 80*10*4 sp=62mm	NB	kJ/m ²	ISO 179/1eU
Izod Reverse Impact, notched 80*10*4,23°C	45	kJ/m ²	ISO 180/1C
THERMAL			
Vicat Softening Temp, Rate A/50	210	°C	ASTM D 1525
Vicat Softening Temp, Rate B/50	165	°C	ASTM D 1525
HDT, 0.45 MPa, 3.2 mm, unannealed	203	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	138	°C	ASTM D 648
CTE, -40°C to 40°C, flow	2.5E-05	1/°C	ASTM E 831

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TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
THERMAL			
CTE, -40°C to 40°C, xflow	5.77E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, flow	1.92E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	7.4E-05	1/°C	ISO 11359-2
CTE, 23°C to 80°C, flow	2.5E-05	1/°C	ISO 11359-2
CTE, 23°C to 80°C, xflow	8.5E-05	1/°C	ISO 11359-2
CTE, 23°C to 150°C, flow	1.54E-05	1/°C	ISO 11359-2
CTE, 23°C to 150°C, xflow	1.24E-04	1/°C	ISO 11359-2
Ball Pressure Test, 125°C +/- 2°C	PASSES	-	IEC 60695-10-2
Vicat Softening Temp, Rate A/50	210	°C	ISO 306
Vicat Softening Temp, Rate B/50	165	°C	ISO 306
Vicat Softening Temp, Rate B/120	161	°C	ISO 306
HDT/Be, 0.45MPa Edgew 120*10*4 sp=100mm	205	°C	ISO 75/Be
HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm	135	°C	ISO 75/Ae
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	202	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	140	°C	ISO 75/Af
Relative Temp Index, Elec	125	°C	UL 746B
Relative Temp Index, Mech w/impact	110	°C	UL 746B
Relative Temp Index, Mech w/o impact	125	°C	UL 746B
PHYSICAL			
Specific Gravity	1.58	-	ASTM D 792
Filler Content	30	%	ASTM D 229
Mold Shrinkage on Tensile Bar, flow (2) (5)	0.4 - 0.6	%	SABIC Method
Mold Shrinkage, flow, 3.2 mm (5)	0.5	%	SABIC Method
Mold Shrinkage on Tensile Bar, xflow (2) (5)	0.5 - 0.9	%	SABIC Method
Melt Flow Rate, 266°C/5.0 kgf	40	g/10 min	ASTM D 1238
Density	1.58	g/cm ³	ISO 1183
Water Absorption, (23°C/sat)	0.26	%	ISO 62

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TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
PHYSICAL			
Moisture Absorption (23°C / 50% RH)	0.07	%	ISO 62
Melt Volume Rate, MVR at 250°C/2.16 kg	7	cm ³ /10 min	ISO 1133
Melt Volume Rate, MVR at 250°C/5.0 kg	20	cm ³ /10 min	ISO 1133
Melt Volume Rate, MVR at 265°C/5.0 kg	30	cm ³ /10 min	ISO 1133
Melt Viscosity, 260°C, 1500 sec-1	200	Pa-s	ISO 11443
ELECTRICAL			
Volume Resistivity	>1.E+15	Ohm-cm	ASTM D 257
Dielectric Strength, in oil, 0.8 mm	28	kV/mm	ASTM D 149
Dielectric Strength, in oil, 1.6 mm	24	kV/mm	ASTM D 149
Dielectric Strength, in oil, 3.2 mm	15	kV/mm	ASTM D 149
Arc Resistance, Tungsten {PLC}	6	PLC Code	ASTM D 495
Hot Wire Ignition {PLC}	1	PLC Code	UL 746A
High Voltage Arc Track Rate {PLC}	4	PLC Code	UL 746A
High Ampere Arc Ign, surface {PLC}	3	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, in oil, 0.8 mm	28	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, 1 MHz	3.3	-	IEC 60250
Dissipation Factor, 50/60 Hz	0.001	-	IEC 60250
Dissipation Factor, 1 MHz	0.007	-	IEC 60250
Dissipation Factor, 2450 MHz	0.02	-	IEC 60250
Comparative Tracking Index	225	V	IEC 60112
Comparative Tracking Index, M	125	V	IEC 60112
Relative Permittivity, 50/60 Hz	3.4	-	IEC 60250
FLAME CHARACTERISTICS			
UL Recognized, 94V-0 Flame Class Rating (3)	0.86	mm	UL 94
UL Recognized, 94-5VA Rating (3)	2.3	mm	UL 94
Needle Flame Test, 10 s, passes at	1.5	mm	IEC 60695-2-2
Glow Wire Flammability Index 960°C, passes at	1	mm	IEC 60695-2-12
Oxygen Index (LOI)	34	%	ISO 4589

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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
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

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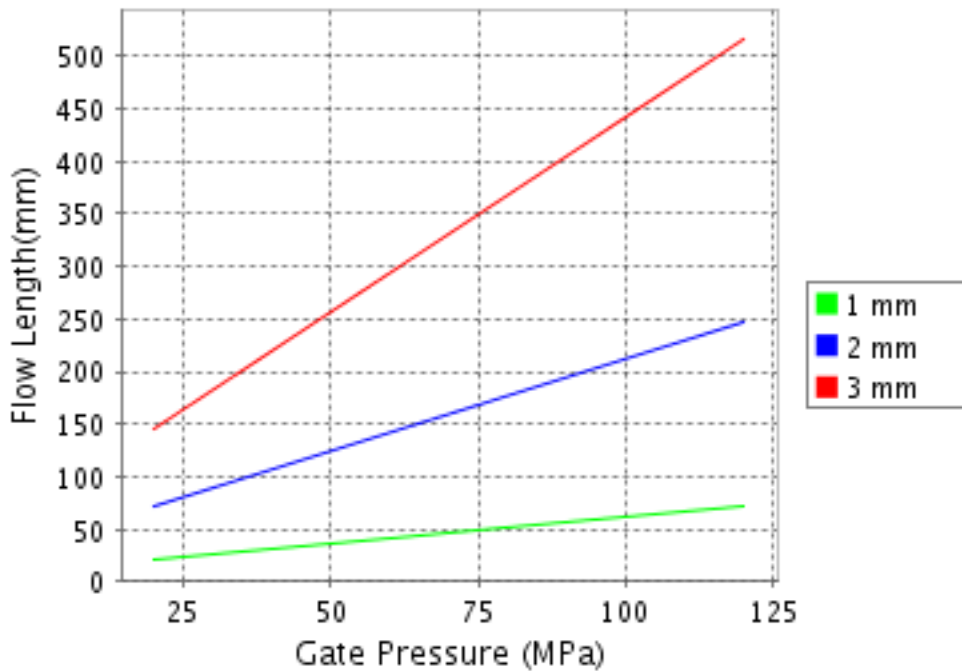
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CALCULATED FLOW LENGTH INDICATION
Moldflow® Radial Flow Analysis
VALOX® 553
Melt Temperature : 260°C
Mold Temperature : 70°C



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