



VALOX™ Resin 357U
Americas: COMMERCIAL

PBT+PC, UL94V-0/5VA Rated, Impact Modified, Opaque, Unreinforced, UV Stabilized. Applications like bobbins, switches and enclosures.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	490	kgf/cm ²	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	490	kgf/cm ²	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	110	%	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	840	kgf/cm ²	ASTM D 790
Flexural Stress, brk, 1.3 mm/min, 50 mm span	840	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	21000	kgf/cm ²	ASTM D 790
Hardness, Rockwell R	117	-	ASTM D 785
IMPACT			
Izod Impact, unnotched, 23°C	326	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	54	cm-kgf/cm	ASTM D 256
Gardner, 23°C	442	cm-kgf	ASTM D 3029
Modified Gardner, 23°C	442	cm-kgf	ASTM D 3029
THERMAL			
HDT, 0.45 MPa, 6.4 mm, unannealed	137	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	98	°C	ASTM D 648
CTE, -40°C to 40°C, flow	9.18E-05	1/°C	ASTM E 831
CTE, 60°C to 138°C, flow	1.24E-04	1/°C	ASTM E 831
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
PHYSICAL			
Specific Gravity	1.34	-	ASTM D 792
Specific Volume	0.75	cm ³ /g	ASTM D 792
Water Absorption, 24 hours	0.08	%	ASTM D 570

(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.

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

Source GMD, last updated:

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PHYSICAL			
Mold Shrinkage, flow, 0.75-2.3 mm (5)	0.8 - 1.1	%	SABIC Method
Mold Shrinkage, flow, 2.3-4.6 mm (5)	1 - 1.4	%	SABIC Method
Mold Shrinkage, xflow, 0.75-2.3 mm (5)	0.9 - 1.3	%	SABIC Method
Mold Shrinkage, xflow, 2.3-4.6 mm (5)	1.2 - 1.6	%	SABIC Method
Melt Volume Rate, MVR at 250°C/5.0 kg	8	cm ³ /10 min	ISO 1133
ELECTRICAL			
Volume Resistivity	>1.2E+16	Ohm-cm	ASTM D 257
Dielectric Strength, in air, 3.2 mm	18.5	kV/mm	ASTM D 149
Dielectric Strength, in oil, 1.6 mm	25.2	kV/mm	ASTM D 149
Dielectric Strength, in oil, 3.2 mm	18.5	kV/mm	ASTM D 149
Relative Permittivity, 100 Hz	3.2	-	ASTM D 150
Relative Permittivity, 1 MHz	3.2	-	ASTM D 150
Dissipation Factor, 100 Hz	0.003	-	ASTM D 150
Dissipation Factor, 1 MHz	0.03	-	ASTM D 150
Arc Resistance, Tungsten {PLC}	6	PLC Code	ASTM D 495
Hot Wire Ignition {PLC}	2	PLC Code	UL 746A
High Voltage Arc Track Rate {PLC}	3	PLC Code	UL 746A
High Ampere Arc Ign, surface {PLC}	3	PLC Code	UL 746A
Comparative Tracking Index (UL) {PLC}	2	PLC Code	UL 746A
FLAME CHARACTERISTICS			
UL Recognized, 94HB Flame Class Rating (3)	0.46	mm	UL 94
UL Recognized, 94V-0 Flame Class Rating (3)	0.64	mm	UL 94
UL Recognized, 94-5VA Rating (3)	3	mm	UL 94
Oxygen Index (LOI)	30	%	ASTM D 2863
UV-light, water exposure/immersion	F1	-	UL 746C

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PROCESSING PARAMETERS	TYPICAL 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	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	50 - 75	°C
Back Pressure	0.3 - 0.7	MPa
Screw Speed	50 - 100	rpm
Shot to Cylinder Size	40 - 80	%
Vent Depth	0.025 - 0.038	mm

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