

**VALOX® CS860***Americas: COMMERCIAL*

30% glass reinforced PBT+PET blend. Color stable, FR. Housewares, appliances; iron skirt, oven trim/panels.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	108	MPa	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	110	MPa	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	3.1	%	ASTM D 638
Tensile Modulus, 5 mm/min	6210	MPa	ASTM D 638
Flexural Stress, brk, 1.3 mm/min, 50 mm span	155	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	8270	MPa	ASTM D 790
IMPACT			
Izod Impact, unnotched, 23°C	534	J/m	ASTM D 4812
Izod Impact, notched, 23°C	80	J/m	ASTM D 256
THERMAL			
HDT, 0.45 MPa, 6.4 mm, unannealed	213	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	188	°C	ASTM D 648
Relative Temp Index, Elec	130	°C	UL 746B
Relative Temp Index, Mech w/impact	130	°C	UL 746B
Relative Temp Index, Mech w/o impact	140	°C	UL 746B
PHYSICAL			
Specific Gravity	1.73	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	0.2 - 0.3	%	GE Method
Mold Shrinkage, xflow, 3.2 mm	0.5 - 0.6	%	GE Method
Melt Flow Rate, 266°C/5.0 kgf	45	g/10 min	ASTM D 1238
ELECTRICAL			
Arc Resistance, Tungsten {PLC}	5	PLC Code	ASTM D 495
Hot Wire Ignition {PLC}	0	PLC Code	UL 746A
High Voltage Arc Track Rate {PLC}	4	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
FLAME CHARACTERISTICS			
UL Recognized, 94V-0 Flame Class Rating (3)	0.8	mm	UL 94
UL Recognized, 94-5VA Rating (3)	3	mm	UL 94



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PROCESSING PARAMETERS	TYPICAL VALUE	UNIT
Injection Molding		
Drying Temperature	60 - 75	°C
Drying Time	4 - 5	hrs
Drying Time (Cumulative)	8	hrs
Maximum Moisture Content	0.05	%
Minimum Moisture Content	0.02	%
Melt Temperature	255 - 275	°C
Nozzle Temperature	255 - 270	°C
Front - Zone 3 Temperature	255 - 265	°C
Middle - Zone 2 Temperature	250 - 260	°C
Rear - Zone 1 Temperature	245 - 255	°C
Mold Temperature	65 - 95	°C
Back Pressure	0.3 - 0.7	MPa
Screw Speed	50 - 80	rpm
Shot to Cylinder Size	40 - 80	%
Vent Depth	0.025 - 0.038	mm