XENOY™ RESIN X5630Q

REGION AMERICAS

DESCRIPTION

Mineral filled PC/PET blend with high heat dimensional stability, low shrinkage and low CTE, especially for painted applications

TYPICAL PROPERTY VALUES

Revision 20190925

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yield, 5 mm/min	56	MPa	ISO 527
Tensile Stress, break, 5 mm/min	41	MPa	ISO 527
Tensile Strain, yield, 5 mm/min	3.3	%	ISO 527
Tensile Strain, break, 5 mm/min	14	%	ISO 527
Tensile Modulus, 1 mm/min	4200	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	92	MPa	ISO 178
Flexural Modulus, 2 mm/min	4100	MPa	ISO 178
IMPACT			
Izod Impact, unnotched 80*10*4 +23°C	121	kJ/m²	ISO 180/1U
Izod Impact, unnotched 80*10*4 -30°C	80	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	7	kJ/m²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	5	kJ/m²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	16	kJ/m²	ISO 179/1eA
THERMAL			
CTE, -30°C to 80°C, flow	3.8E-05	1/°C	ISO 11359-2
CTE, -30°C to 80°C, xflow	1.E-04	1/°C	ISO 11359-2
Vicat Softening Temp, Rate B/50	137	°C	ISO 306
Vicat Softening Temp, Rate B/120	140	°C	ISO 306
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	110	°C	ISO 75/Af
PHYSICAL			
Mold Shrinkage on Tensile Bar, flow	0.5 – 0.7	%	SABIC method
Melt Flow Rate, 265°C/5.0 kgf	20	g/10 min	ASTM D 1238
Density	1.35	g/cm³	ISO 1183
Water Absorption, (23°C/sat)	0.42	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.14	%	ISO 62
Melt Volume Rate, MVR at 265°C/5.0 kg	16	cm³/10 min	ISO 1133
INJECTION MOLDING			
Drying Temperature	110	°C	
Drying Time	4 – 6	hrs	
Drying Time (Cumulative)	8	hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	260 – 275	°C	
Nozzle Temperature	255 – 270	°C	
Front - Zone 3 Temperature	255 – 275	°C	

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Middle - Zone 2 Temperature	250 – 270	°C	
Rear - Zone 1 Temperature	245 – 265	°C	
Mold Temperature	65 – 90	°C	
Back Pressure	0.3 – 0.7	MPa	
Screw Speed	50 – 80	rpm	
Shot to Cylinder Size	50 – 80	%	
Vent Depth	0.013 – 0.02	mm	

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