

XENOYTM RESIN XL1339

REGION AMERICAS

DESCRIPTION

Data generated in BOZ labs. High heat grade for nonchemical resistance required applications.

TYPICAL PROPERTY VALUES

Revision 20190925

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	49	MPa	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	49	MPa	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	5	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	110	%	ASTM D 638
Tensile Modulus, 50 mm/min	2090	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	94	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	2090	MPa	ASTM D 790
Taber Abrasion, CS-17, 1 kg	16	mg/1000cy	ASTM D 1044
Tensile Stress, yield, 50 mm/min	55	MPa	ISO 527
Tensile Stress, break, 50 mm/min	40	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	5	%	ISO 527
Tensile Strain, break, 50 mm/min	70	%	ISO 527
Flexural Stress, yield, 2 mm/min	80	MPa	ISO 178
Flexural Modulus, 2 mm/min	2200	MPa	ISO 178
IMPACT			
Izod Impact, notched, 23°C	699	J/m	ASTM D 256
Izod Impact, notched, 0°C	672	J/m	ASTM D 256
Izod Impact, notched, -20°C	598	J/m	ASTM D 256
Izod Impact, notched, -30°C	245	J/m	ASTM D 256
Izod Impact, notched, -40°C	224	J/m	ASTM D 256
Izod Impact, unnotched 80*10*4 +23°C	NB	kJ/m ²	ISO 180/1U
Izod Impact, unnotched 80*10*4 -30°C	NB	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	40	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*4 -10°C	38	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*4 -20°C	35	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	25	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*4 -40°C	15	kJ/m ²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	45	kJ/m ²	ISO 179/1eA
Charpy -30°C, V-notch Edgew 80*10*4 sp=62mm	35	kJ/m ²	ISO 179/1eA
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
THERMAL			
CTE, -30°C to 30°C, flow	7.56E-05	1/°C	ASTM D 696
CTE, -30°C to 30°C, xflow	7.92E-05	1/°C	ASTM D 696
Thermal Conductivity	0.18	W/m-°C	ASTM C177

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CHEMISTRY THAT MATTERSTM



PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Vicat Softening Temp, Rate A/50	140	°C	ISO 306
Vicat Softening Temp, Rate B/50	130	°C	ISO 306
Vicat Softening Temp, Rate B/120	135	°C	ISO 306
HDT/Be, 0.45MPa Edgew 120*10*4 sp=100mm	125	°C	ISO 75/Be
HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm	105	°C	ISO 75/Ae
PHYSICAL			
Specific Gravity	1.22	-	ASTM D 792
Water Absorption, 24 hours	0.1	%	ASTM D 570
Water Absorption, equilibrium, 23C	0.7	%	ASTM D 570
Water Absorption, 50% RH, equilib	0.2	%	ASTM D 570
Mold Shrinkage on Tensile Bar, flow	0.5 – 0.8	%	SABIC method
Mold Shrinkage on Tensile Bar, xflow	0.5 – 0.8	%	SABIC method
Poisson's Ratio	0.4	-	ASTM E 132
Melt Volume Rate, MVR at 265°C/1.2 kg	4	cm³/10 min	ISO 1133
ELECTRICAL			
Volume Resistivity	>1.E+14	Ohm-cm	ASTM D 257
Surface Resistivity	>1.E+15	Ohm	ASTM D 257
Dielectric Strength, in oil, 3.2 mm	16.9	kV/mm	ASTM D 149
Relative Permittivity, 50/60 Hz	3.3	-	ASTM D 150
Relative Permittivity, 1 MHz	3.1	-	ASTM D 150
Dissipation Factor, 50/60 Hz	0.002	-	ASTM D 150
Dissipation Factor, 1 MHz	0.02	-	ASTM D 150
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	
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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