



## XENOY™ Resin X2203

### Americas: COMMERCIAL

Xenoy product that provides improved chemical resistance and impact performance versus previous generation X2202 product which is used in the market spaces such as soap dispenser, cleaning equipment, filter housing

TYPICAL PROPERTIES <sup>1</sup>	TYPICAL VALUE	Unit	Standard
<b>MECHANICAL</b>			
Flexural Stress, yld, 1.3 mm/min, 50 mm span	1010	kgf/cm <sup>2</sup>	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	26900	kgf/cm <sup>2</sup>	ASTM D 790
<b>IMPACT</b>			
Izod Impact, notched, 23°C	21	cm-kgf/cm	ASTM D 256
Izod Impact, notched, 0°C	12	cm-kgf/cm	ASTM D 256
Izod Impact, notched, -20°C	12	cm-kgf/cm	ASTM D 256
Instrumented Impact Total Energy, 23°C	693	cm-kgf	ASTM D 3763
Instrumented Impact Total Energy, 0°C	683	cm-kgf	ASTM D 3763
Instrumented Impact Total Energy, -20°C	734	cm-kgf	ASTM D 3763
<b>THERMAL</b>			
HDT, 0.45 MPa, 3.2 mm, unannealed	103	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	90	°C	ASTM D 648
<b>PHYSICAL</b>			
Melt Volume Rate, MVR at 265°C/5.0 kg	35	cm <sup>3</sup> /10 min	ISO 1133

(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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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
<b>Injection Molding</b>		
Drying Temperature	110	°C
Drying Time	4 - 6	hrs
Drying Time (Cumulative)	8	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	260 - 280	°C
Nozzle Temperature	255 - 275	°C
Front - Zone 3 Temperature	260 - 280	°C
Middle - Zone 2 Temperature	255 - 275	°C
Rear - Zone 1 Temperature	250 - 270	°C
Mold Temperature	65 - 95	°C
Back Pressure	0.3 - 0.6	MPa
Screw Speed	50 - 80	rpm
Shot to Cylinder Size	50 - 80	%
Vent Depth	0.013 - 0.02	mm

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