



## Xenoy\* Resin 1333

### Americas: COMMERCIAL

Unreinforced thermoplastic alloy with excellent chemical resistance and dimensional stability. Cosmetic applications.

TYPICAL PROPERTIES <sup>1</sup>	TYPICAL VALUE	UNIT	STANDARD
<b>MECHANICAL</b>			
Tensile Stress, yld, Type I, 50 mm/min	66	MPa	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	100	%	ASTM D 638
Flexural Modulus, 1.3 mm/min, 50 mm span	2340	MPa	ASTM D 790
Hardness, Rockwell R	125	-	ASTM D 785
<b>IMPACT</b>			
Izod Impact, notched, 23°C	85	J/m	ASTM D 256
<b>THERMAL</b>			
HDT, 1.82 MPa, 6.4 mm, unannealed	115	°C	ASTM D 648
Relative Temp Index, Elec	75	°C	UL 746B
Relative Temp Index, Mech w/impact	75	°C	UL 746B
Relative Temp Index, Mech w/o impact	75	°C	UL 746B
<b>PHYSICAL</b>			
Specific Gravity	1.23	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	0.7 - 0.9	%	SABIC Method
Mold Shrinkage, xflow, 3.2 mm	0.7 - 0.9	%	SABIC Method
<b>FLAME CHARACTERISTICS</b>			
UL Recognized, 94HB Flame Class Rating (3)	1.47	mm	UL 94

1) Typical values only. Variations within normal tolerances are possible for various colours. All values are measured at least after 48 hours storage at 23°C/50% relative humidity.  
All properties, except the melt volume rate are measured on injection moulded samples.  
All samples are prepared according to ISO 294.

2) Only typical data for material selection purpose. 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) Own measurement according to UL.





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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 - 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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