



Xenoy* Resin 1760E

Americas: COMMERCIAL

11% GR alloy. Impact/chemical resistant. Excellent physical property retention in automotive exteriors. High flow version of 1760.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
MECHANICAL			
Tensile Stress, brk, Type I, 5 mm/min	89	MPa	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	4.5	%	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	131	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	3910	MPa	ASTM D 790
IMPACT			
Izod Impact, notched, 23°C	48	J/m	ASTM D 256
Instrumented Impact, Energy @ peak, -20°C	4	J	ASTM D 3763
Instrumented Impact Energy @ peak, -30	2	J	ASTM D 3763
Instrumented Impact Total Energy, 23°C	7	J	ASTM D 3763
Instrumented Impact Total Energy, -30°C	2	J	ASTM D 3763
THERMAL			
HDT, 1.82 MPa, 6.4 mm, unannealed	115	°C	ASTM D 648
PHYSICAL			
Specific Gravity	1.3	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	0.4 - 0.6	%	SABIC Method
Mold Shrinkage, xflow, 3.2 mm	0.4 - 0.6	%	SABIC Method
Melt Flow Rate, 250°C/5.0 kgf	15	g/10 min	ASTM D 1238

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.





Xenoy* Resin 1760E
Americas: COMMERCIAL

PROCESSING PARAMETERS	TYPICAL VALUE	UNIT
Injection Molding		
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

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 this or any other material under actual fire conditions.
4) Own measurement according to UL.

Source, GMD, Last Update: 09/27/2000

