SABIC Innovative Plastics™

سابك sabic

Xenoy* Resin 6127

Americas: COMMERCIAL

Improved processing over 6120.

TYPICAL PROPERTIES [1]	TYPICAL VALUE	UNIT	STANDARD
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	53	MPa	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	37	MPa	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	120	%	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	68	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	1890	MPa	ASTM D 790
IMPACT			
Izod Impact, notched, 23°C	961	J/m	ASTM D 256
Izod Impact, notched, 0°C	160	J/m	ASTM D 256
Instrumented Impact Energy @ peak, 23°C	61	J	ASTM D 3763
Instrumented Impact Energy @ peak, -30	61	J	ASTM D 3763
THERMAL			
HDT, 0.45 MPa, 6.4 mm, unannealed	104	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	60	°C	ASTM D 648
Relative Temp Index, Elec	120	°C	UL 746B
Relative Temp Index, Mech w/impact	120	°C	UL 746B
Relative Temp Index, Mech w/o impact	140	°C	UL 746B
PHYSICAL			
Specific Gravity	1.23	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	1.6 - 2.1	%	SABIC Method
Mold Shrinkage, xflow, 3.2 mm	1.6 - 2.1	%	SABIC Method
ELECTRICAL			
Arc Resistance, Tungsten {PLC}	5	PLC Code	ASTM D 495
Hot Wire Ignition {PLC)	2	PLC Code	UL 746A
High Voltage Arc Track Rate {PLC}	0	PLC Code	UL 746A
High Ampere Arc Ign, surface {PLC}	0	PLC Code	UL 746A

1) Typical values only. Variations within normal tolerances are possible for variose colours.All values are measured at least after 48 hours storage at 230C/50% relative humidity.
All properties, expect 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.

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TYPICAL PROPERTIES [1]	TYPICAL VALUE	UNIT	STANDARD
ELECTRICAL			
Comparative Tracking Index (UL) {PLC}	0	PLC Code	UL 746A
FLAME CHARACTERISTICS			
UL Recognized, 94HB Flame Class Rating (3)	1.47	mm	UL 94

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

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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 - 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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