



## Xenoy\* Resin 6620U

### Americas: COMMERCIAL

UR, PBT+PC alloy. Improved mechanical properties retention under UV vs 6620. Outstanding low temperature impact/chemical resistance.

TYPICAL PROPERTIES <sup>1</sup>	TYPICAL VALUE	UNIT	STANDARD
<b>MECHANICAL</b>			
Tensile Stress, yld, Type I, 50 mm/min	43	MPa	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	150	%	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	64	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	1720	MPa	ASTM D 790
<b>IMPACT</b>			
Izod Impact, unnotched, 23°C	1602	J/m	ASTM D 4812
Izod Impact, notched, 23°C	801	J/m	ASTM D 256
Izod Impact, notched, -40°C	640	J/m	ASTM D 256
<b>THERMAL</b>			
HDT, 0.45 MPa, 6.4 mm, unannealed	98	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	60	°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	1.2	-	ASTM D 792
Specific Volume	0.83	cm <sup>3</sup> /g	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	1.6 - 1.8	%	SABIC Method
Mold Shrinkage, xflow, 3.2 mm	1.6 - 1.8	%	SABIC Method
<b>ELECTRICAL</b>			
Arc Resistance, Tungsten {PLC}	5	PLC Code	ASTM D 495
Hot Wire Ignition {PLC}	3	PLC Code	UL 746A
High Voltage Arc Track Rate {PLC}	1	PLC Code	UL 746A
High Ampere Arc Ign, surface {PLC}	0	PLC Code	UL 746A
Comparative Tracking Index (UL) {PLC}	0	PLC Code	UL 746A

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.





**Xenoy\* Resin 6620U**  
**Americas: COMMERCIAL**

TYPICAL PROPERTIES <sup>1</sup>	TYPICAL VALUE	UNIT	STANDARD
<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.

Source, GMD, Last Update: 01/05/2000





**Xenoy\* Resin 6620U**  
**Americas: COMMERCIAL**

PROCESSING PARAMETERS	TYPICAL VALUE	UNIT
<b>Injection Molding</b>		
Drying Temperature	105 - 115	°C
Drying Time	2 - 4	hrs
Drying Time (Cumulative)	6	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	250 - 270	°C
Nozzle Temperature	250 - 270	°C
Front - Zone 3 Temperature	250 - 265	°C
Middle - Zone 2 Temperature	240 - 255	°C
Rear - Zone 1 Temperature	230 - 245	°C
Mold Temperature	40 - 80	°C
Back Pressure	0.2 - 0.3	MPa
Shot to Cylinder Size	50 - 80	%
Vent Depth	0.013 - 0.02	mm

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, 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:01/05/2000

