



XENOY™ Resin 1105

Asia Pacific: COMMERCIAL

PBT/PC blend, injection molding grade, non-reinforced, impact modified, excellent toughness at low temperatures, very good paintability

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	490	kgf/cm ²	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	480	kgf/cm ²	ASTM D 638
Tensile Stress, yld, Type I, 5 mm/min	460	kgf/cm ²	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	460	kgf/cm ²	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	4.2	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	120	%	ASTM D 638
Tensile Strain, yld, Type I, 5 mm/min	4.1	%	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	110	%	ASTM D 638
Tensile Modulus, 50 mm/min	20500	kgf/cm ²	ASTM D 638
Tensile Modulus, 5 mm/min	20200	kgf/cm ²	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	770	kgf/cm ²	ASTM D 790
Flexural Stress, brk, 1.3 mm/min, 50 mm span	760	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	19300	kgf/cm ²	ASTM D 790
Tensile Stress, yield, 50 mm/min	52	MPa	ISO 527
Tensile Stress, break, 50 mm/min	50	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	4.5	%	ISO 527
Tensile Strain, break, 50 mm/min	116	%	ISO 527
Tensile Modulus, 1 mm/min	2070	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	78	MPa	ISO 178
Flexural Strain, break, 2 mm/min	7.3	%	ISO 178
Flexural Modulus, 2 mm/min	2010	MPa	ISO 178

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(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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MECHANICAL			
Hardness, Shore D	79	-	ISO 868
IMPACT			
Izod Impact, notched, 23°C	76	cm-kgf/cm	ASTM D 256
Izod Impact, notched, 0°C	72	cm-kgf/cm	ASTM D 256
Izod Impact, notched, -10°C	70	cm-kgf/cm	ASTM D 256
Izod Impact, notched, -20°C	70	cm-kgf/cm	ASTM D 256
Izod Impact, notched, -30°C	49	cm-kgf/cm	ASTM D 256
Izod Impact, notched, -40°C	37	cm-kgf/cm	ASTM D 256
Izod Impact, notched 80*10*4 +23°C	63	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	51	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*4 -40°C	34	kJ/m ²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	62	kJ/m ²	ISO 179/1eA
Charpy -30°C, V-notch Edgew 80*10*4 sp=62mm	47	kJ/m ²	ISO 179/1eA
THERMAL			
Vicat Softening Temp, Rate B/50	122	°C	ASTM D 1525
HDT, 0.45 MPa, 6.4 mm, unannealed	115	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	97	°C	ASTM D 648
Vicat Softening Temp, Rate B/50	122	°C	ISO 306
Vicat Softening Temp, Rate B/120	123	°C	ISO 306
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	109	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	90	°C	ISO 75/Af
PHYSICAL			
Specific Gravity	1.2	-	ASTM D 792
Specific Volume	1.2	cm ³ /g	ASTM D 792
Mold Shrinkage, flow, 3.2 mm (5)	0.8 - 1	%	SABIC Method
Mold Shrinkage, xflow, 3.2 mm (5)	0.8 - 1	%	SABIC Method

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TYPICAL PROPERTIES¹	TYPICAL VALUE	Unit	Standard
PHYSICAL			
Melt Flow Rate, 250°C/5.0 kgf	16	g/10 min	ASTM D 1238
Density	1.2	g/cm³	ISO 1183
Melt Flow Rate, 250°C/5.0 kg	16	g/10 min	ISO 1133

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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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