+135-3858-6433 (GuangDong)
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XENOY™ Resin X2420

Asia Pacific: COMMERCIAL

XENOYX2420 is a 10% glass filled, high flow, impact modified, injection moldable grade designed for high flow and impact strength. X2420 has enhanced melt flowability, impact ductility and broad color space.

TYPICAL PROPERTIES[1]	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	500	kgf/cm²	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	350	kgf/cm²	ASTM D 638
Tensile Strain, yld, Type I, 5 mm/min	3	%	ASTM D 638
Tensile Modulus, 5 mm/min	38700	kgf/cm²	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	910	kgf/cm²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	35600	kgf/cm²	ASTM D 790
Tensile Stress, yield, 5 mm/min	51	MPa	ISO 527
Tensile Stress, break, 5 mm/min	37	MPa	ISO 527
Tensile Strain, yield, 5 mm/min	3	%	ISO 527
Tensile Strain, break, 5 mm/min	7	%	ISO 527
IMPACT			
Izod Impact, unnotched, 23°C	163	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	20	cm-kgf/cm	ASTM D 256
Instrumented Impact Total Energy, 23°C	367	cm-kgf	ASTM D 3763
Izod Impact, unnotched 80*10*4 +23°C	110	kJ/m²	ISO 180/1U
Izod Impact, unnotched 80*10*4 -30°C	74	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	14	kJ/m²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	8	kJ/m²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	15	kJ/m²	ISO 179/1eA
Charpy -30°C, V-notch Edgew 80*10*4 sp=62mm	7	kJ/m²	ISO 179/1eA
Charpy 23°C, Unnotch Edgew 80*10*4 sp=62mm	95	kJ/m²	ISO 179/1eU
Charpy -30°C, Unnotch Edgew 80*10*4 sp=62mm	95	kJ/m²	ISO 179/1eU

(1) Typical values only. Variations within normal tolerances are possible for various colors. All values are measured after at least 48 hours storage at 23°C/50% relative humidity. All properties, except the melt volume and melt flow rates, are measured on injection molded samples. All samples tested under ISO test standards are prepared according to ISO 294.

(2) Only typical data for selection purposes. 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) 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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THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	111	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	101	°C	ASTM D 648
CTE, -40°C to 40°C, flow	5.E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	8.E-05	1/°C	ASTM E 831
CTE, 23°C to 80°C, flow	4.E-05	1/°C	ISO 11359-2
CTE, 23°C to 80°C, xflow	9.E-05	1/°C	ISO 11359-2
Vicat Softening Temp, Rate B/120	118	°C	ISO 306
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
PHYSICAL			
Specific Gravity	1.28	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm (5)	0.15 - 0.25	%	SABIC Method
Mold Shrinkage, xflow, 3.2 mm (5)	0.3 - 0.4	%	SABIC Method
Density	1.28	g/cm³	ISO 1183
Water Absorption, (23°C/sat)	0.02	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.04	%	ISO 62
Melt Volume Rate, MVR at 265°C/2.16 kg	12	cm³/10 min	ISO 1133
Melt Volume Rate, MVR at 300°C/1.2 kg	26	cm³/10 min	ISO 1133
FLAME CHARACTERISTICS			
UL Recognized, 94HB Flame Class Rating (3)	0.4	mm	UL 94

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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	95 - 105	°C
Drying Time	3 - 4	hrs
Drying Time (Cumulative)	8	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	260 - 290	°C
Nozzle Temperature	260 - 290	°C
Front - Zone 3 Temperature	255 - 290	°C
Middle - Zone 2 Temperature	255 - 290	°C
Rear - Zone 1 Temperature	250 - 280	°C
Hopper Temperature	60 - 80	°C
Mold Temperature	60 - 90	°C
Back Pressure	0.3 - 0.7	MPa
Screw Speed	40 - 70	rpm
Shot to Cylinder Size	30 - 80	%
Vent Depth	0.038 - 0.076	mm

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