



Xylex* Resin X7519

Asia Pacific: COMMERCIAL

Good Chemical Resistance, XYLEX grade with good dishwasher performance.

Comment: While molding of thicker parts, cooling speed has an influence of transparency. Thicker parts may form opaque areas in the centre due to slow cooling.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	590	kgf/cm ²	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	670	kgf/cm ²	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	2	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	120	%	ASTM D 638
Tensile Modulus, 5 mm/min	25100	kgf/cm ²	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	990	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	22800	kgf/cm ²	ASTM D 790
Tensile Stress, yield, 50 mm/min	61	MPa	ISO 527
Tensile Stress, break, 50 mm/min	66	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	6	%	ISO 527
Tensile Strain, break, 50 mm/min	134	%	ISO 527
Tensile Modulus, 1 mm/min	2370	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	90	MPa	ISO 178
Flexural Modulus, 2 mm/min	2030	MPa	ISO 178
IMPACT			
Izod Impact, notched, 23°C	71	cm-kgf/cm	ASTM D 256
Izod Impact, notched, -30°C	10	cm-kgf/cm	ASTM D 256
Instrumented Impact Total Energy, 23°C	754	cm-kgf	ASTM D 3763
Izod Impact, notched 80*10*4 +23°C	10	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	<5	kJ/m ²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	13	kJ/m ²	ISO 179/1eA
THERMAL			
Vicat Softening Temp, Rate B/50	130	°C	ASTM D 1525

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.





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TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
THERMAL			
HDT, 1.82 MPa, 3.2mm, unannealed	113	°C	ASTM D 648
CTE, -40°C to 40°C, flow	6.5E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	6.7E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, flow	7.5E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	7.5E-05	1/°C	ISO 11359-2
Vicat Softening Temp, Rate B/50	130	°C	ISO 306
Vicat Softening Temp, Rate B/120	132	°C	ISO 306
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	112	°C	ISO 75/Af
PHYSICAL			
Specific Gravity	1.19	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	0.7 - 0.8	%	SABIC Method
Melt Flow Rate, 300°C/1.2 kgf	12.5	g/10 min	ASTM D 1238
Density	1.19	g/cm ³	ISO 1183
Water Absorption, (23°C/sat)	0.16	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.14	%	ISO 62
Melt Volume Rate, MVR at 300°C/1.2 kg	10	cm ³ /10 min	ISO 1133

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PROCESSING PARAMETERS	TYPICAL VALUE	UNIT
Injection Molding		
Drying Temperature	85 - 100	°C
Drying Time	2 - 3	hrs
Drying Time (Cumulative)	8	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	280 - 300	°C
Nozzle Temperature	280 - 290	°C
Front - Zone 3 Temperature	290 - 300	°C
Middle - Zone 2 Temperature	280 - 290	°C
Rear - Zone 1 Temperature	275 - 285	°C
Hopper Temperature	50	°C
Mold Temperature	65 - 75	°C
Back Pressure	0.1 - 0.5	MPa
Screw Speed	20 - 100	rpm
Shot to Cylinder Size	40 - 80	%

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