



XENOV™ Resin 6370
Americas: COMMERCIAL

30% glass-reinforced, impact modified thermoplastic alloy. Improved toughness and ductility.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	980	kgf/cm ²	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	920	kgf/cm ²	ASTM D 638
Tensile Strain, yld, Type I, 5 mm/min	3	%	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	4	%	ASTM D 638
Tensile Modulus, 5 mm/min	99400	kgf/cm ²	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	1520	kgf/cm ²	ASTM D 790
Flexural Stress, brk, 1.3 mm/min, 50 mm span	1400	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	54800	kgf/cm ²	ASTM D 790
Hardness, Rockwell R	109	-	ASTM D 785
Tensile Stress, yield, 5 mm/min	105	MPa	ISO 527
Tensile Stress, break, 5 mm/min	3	MPa	ISO 527
Tensile Strain, yield, 5 mm/min	3	%	ISO 527
Tensile Strain, break, 5 mm/min	105	%	ISO 527
Tensile Modulus, 1 mm/min	8500	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	154	MPa	ISO 178
Flexural Modulus, 2 mm/min	7750	MPa	ISO 178
IMPACT			
Izod Impact, unnotched, 23°C	65	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	17	cm-kgf/cm	ASTM D 256
Izod Impact, notched, -30°C	11	cm-kgf/cm	ASTM D 256
Instrumented Impact Energy @ peak, 23°C	50	cm-kgf	ASTM D 3763
Instrumented Impact Total Energy, 23°C	173	cm-kgf	ASTM D 3763



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IMPACT			
Izod Impact, notched 80*10*4 +23°C	10	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	6	kJ/m ²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	9	kJ/m ²	ISO 179/1eA
THERMAL			
Vicat Softening Temp, Rate B/50	153	°C	ASTM D 1525
HDT, 1.82 MPa, 3.2mm, unannealed	163	°C	ASTM D 648
HDT, 0.45 MPa, 6.4 mm, unannealed	204	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	149	°C	ASTM D 648
CTE, -40°C to 40°C, flow	2.7E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	1.1E-04	1/°C	ASTM E 831
CTE, 60°C to 138°C, flow	1.98E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, flow	2.7E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	1.1E-04	1/°C	ISO 11359-2
Vicat Softening Temp, Rate B/50	148	°C	ISO 306
Vicat Softening Temp, Rate B/120	150	°C	ISO 306
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	155	°C	ISO 75/Af
Relative Temp Index, Elec	140	°C	UL 746B
Relative Temp Index, Mech w/impact	130	°C	UL 746B
Relative Temp Index, Mech w/o impact	140	°C	UL 746B
PHYSICAL			
Specific Gravity	1.44	-	ASTM D 792
Specific Volume	0.7	cm ³ /g	ASTM D 792
Water Absorption, 24 hours	0.09	%	ASTM D 570
Mold Shrinkage, flow, 0.75-2.3 mm (5)	0.3 - 0.4	%	SABIC Method
Mold Shrinkage, flow, 2.3-4.6 mm (5)	0.4 - 0.5	%	SABIC Method



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Mold Shrinkage, xflow, 0.75-2.3 mm (5)	0.4 - 0.7	%	SABIC Method
Mold Shrinkage, xflow, 2.3-4.6 mm (5)	0.7 - 0.9	%	SABIC Method
Melt Flow Rate, 250°C/5.0 kgf	24	g/10 min	ASTM D 1238
Density	1.44	g/cm ³	ISO 1183
Water Absorption, (23°C/sat)	0.5	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.15	%	ISO 62
Melt Volume Rate, MVR at 250°C/5.0 kg	12	cm ³ /10 min	ISO 1133
Melt Volume Rate, MVR at 265°C/5.0 kg	19	cm ³ /10 min	ISO 1133
ELECTRICAL			
Volume Resistivity	4.8E+15	Ohm-cm	ASTM D 257
Dielectric Strength, in air, 3.2 mm	20	kV/mm	ASTM D 149
Dielectric Strength, in oil, 1.6 mm	27	kV/mm	ASTM D 149
Relative Permittivity, 100 Hz	4	-	ASTM D 150
Relative Permittivity, 1 MHz	4	-	ASTM D 150
Dissipation Factor, 100 Hz	0.003	-	ASTM D 150
Dissipation Factor, 1 MHz	0.02	-	ASTM D 150
Arc Resistance, Tungsten {PLC}	5	PLC Code	ASTM D 495
Hot Wire Ignition {PLC}	1	PLC Code	UL 746A
High Voltage Arc Track Rate {PLC}	1	PLC Code	UL 746A
High Ampere Arc Ign, surface {PLC}	3	PLC Code	UL 746A
Comparative Tracking Index (UL) {PLC}	2	PLC Code	UL 746A
FLAME CHARACTERISTICS			
UL Recognized, 94HB Flame Class Rating (3)	1.5	mm	UL 94



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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 - 280	°C
Nozzle Temperature	255 - 275	°C
Front - Zone 3 Temperature	260 - 280	°C
Middle - Zone 2 Temperature	255 - 275	°C
Rear - Zone 1 Temperature	250 - 270	°C
Mold Temperature	65 - 95	°C
Back Pressure	0.3 - 0.6	MPa
Screw Speed	50 - 80	rpm
Shot to Cylinder Size	50 - 80	%
Vent Depth	0.013 - 0.02	mm