



XENOY™ Resin X6800BM
Americas: COMMERCIAL

Blow moldable, impact modified XENOY

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	350	kgf/cm ²	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	480	kgf/cm ²	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	11	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	238	%	ASTM D 638
Tensile Modulus, 5 mm/min	17200	kgf/cm ²	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	520	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	16800	kgf/cm ²	ASTM D 790
Tensile Stress, yield, 50 mm/min	31	MPa	ISO 527
Tensile Stress, break, 50 mm/min	38	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	14.4	%	ISO 527
Tensile Strain, break, 50 mm/min	167	%	ISO 527
Tensile Modulus, 1 mm/min	1700	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	48	MPa	ISO 178
Flexural Modulus, 2 mm/min	1420	MPa	ISO 178
IMPACT			
Izod Impact, notched, 23°C	81	cm-kgf/cm	ASTM D 256
Izod Impact, notched, -30°C	18	cm-kgf/cm	ASTM D 256
Instrumented Impact Total Energy, 23°C	558	cm-kgf	ASTM D 3763
Izod Impact, notched 80*10*4 +23°C	95	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	22	kJ/m ²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	129	kJ/m ²	ISO 179/1eA
THERMAL			
Vicat Softening Temp, Rate B/50	115	°C	ASTM D 1525



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THERMAL			
HDT, 1.82 MPa, 3.2mm, unannealed	47	°C	ASTM D 648
CTE, -40°C to 40°C, flow	8.3E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	1.7E-04	1/°C	ASTM E 831
CTE, -40°C to 40°C, flow	8.3E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	1.7E-04	1/°C	ISO 11359-2
Vicat Softening Temp, Rate B/50	118	°C	ISO 306
Vicat Softening Temp, Rate B/120	115	°C	ISO 306
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	46	°C	ISO 75/Af
PHYSICAL			
Specific Gravity	1.22	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm (5)	2.85 - 3.35	%	SABIC Method
Melt Flow Rate, 265°C/2.16kgf	4	g/10 min	ASTM D 1238
Density	1.22	g/cm ³	ISO 1183
Water Absorption, (23°C/sat)	0.1	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.01	%	ISO 62
Melt Volume Rate, MVR at 265°C/5.0 kg	9	cm ³ /10 min	ISO 1133



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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Extrusion Blow Molding		
Drying Temperature	100 - 105	°C
Drying Time	3 - 4	hrs
Drying Time (Cumulative)	12	hrs
Maximum Moisture Content	0.01 - 0.03	%
Melt Temperature (Parison)	255 - 265	°C
Barrel - Zone 1 Temperature	250 - 260	°C
Barrel - Zone 2 Temperature	250 - 260	°C
Barrel - Zone 3 Temperature	255 - 260	°C
Barrel - Zone 4 Temperature	255 - 265	°C
Adapter - Zone 5 Temperature	255 - 265	°C
Head - Zone 6 - Top Temperature	255 - 265	°C
Head - Zone 7 - Middle Temperature	255 - 265	°C
Head - Zone 7 - Bottom Temperature	255 - 265	°C
Screw Speed	15 - 50	rpm
Extruder Feed Zone Temperature	255 - 265	°C
Accumulator Temperature	255 - 265	°C
Mold Temperature	50 - 95	°C
Die Temperature	255 - 265	°C