



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/cm ²	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	350	kgf/cm ²	ASTM D 638
Tensile Strain, yld, Type I, 5 mm/min	3	%	ASTM D 638
Tensile Modulus, 5 mm/min	38700	kgf/cm ²	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	910	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	35600	kgf/cm ²	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/m ²	ISO 180/1U
Izod Impact, unnotched 80*10*4 -30°C	74	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	14	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	8	kJ/m ²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	15	kJ/m ²	ISO 179/1eA
Charpy -30°C, V-notch Edgew 80*10*4 sp=62mm	7	kJ/m ²	ISO 179/1eA
Charpy 23°C, Unnotch Edgew 80*10*4 sp=62mm	95	kJ/m ²	ISO 179/1eU
Charpy -30°C, Unnotch Edgew 80*10*4 sp=62mm	95	kJ/m ²	ISO 179/1eU



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TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
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/cm ³	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	cm ³ /10 min	ISO 1133
Melt Volume Rate, MVR at 300°C/1.2 kg	26	cm ³ /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