

XENOY™ RESIN X5630P

REGION EUROPE

DESCRIPTION

Mineral filled PC/PET blend with high heat dimensional stability, low shrinkage and low CTE, especially for painted applications

TYPICAL PROPERTY VALUES

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yield, 5 mm/min	56	MPa	ISO 527
Tensile Stress, break, 5 mm/min	50	MPa	ISO 527
Tensile Strain, yield, 5 mm/min	3.2	%	ISO 527
Tensile Strain, break, 5 mm/min	8	%	ISO 527
Tensile Modulus, 1 mm/min	4150	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	90	MPa	ISO 178
Flexural Modulus, 2 mm/min	4050	MPa	ISO 178
IMPACT			
Izod Impact, unnotched 80*10*4 +23°C	100	kJ/m ²	ISO 180/1U
Izod Impact, unnotched 80*10*4 -30°C	80	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	8	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	8	kJ/m ²	ISO 179/1eA
THERMAL			
CTE, -30°C to 80°C, flow	5.2E-05	1/°C	ISO 11359-2
CTE, -30°C to 80°C, xflow	7.2E-05	1/°C	ISO 11359-2
Vicat Softening Temp, Rate B/50	137	°C	ISO 306
Vicat Softening Temp, Rate B/120	140	°C	ISO 306
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	110	°C	ISO 75/Af
PHYSICAL			
Density	1.35	g/cm ³	ISO 1183
Water Absorption, (23°C/saturated)	0.42	%	ISO 62-1
Moisture Absorption (23°C / 50% RH)	0.14	%	ISO 62
Melt Volume Rate, MVR at 265°C/5.0 kg	15	cm ³ /10 min	ISO 1133
INJECTION MOLDING			
Drying Temperature	110 – 120	°C	
Drying Time	4 – 6	Hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	265 – 275	°C	
Nozzle Temperature	260 – 275	°C	
Front - Zone 3 Temperature	260 – 280	°C	
Middle - Zone 2 Temperature	250 – 275	°C	
Rear - Zone 1 Temperature	240 – 270	°C	
Hopper Temperature	60 – 80	°C	
Mold Temperature	60 – 100	°C	