

XENOY™ RESIN X5630Q

REGION AMERICAS

DESCRIPTION

XENOY X5630Q is a 19% mineral filled PC/PET blend with low CTE, high heat, dimensional stability, low shrinkage, especially for painted applications. XENOY X5630Q could be positioned for body panels, spoilers, housings, door handles, spring-loaded applications, fuel filler doors, medical device enclosures, EV electric vehicle components.

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	41	MPa	ISO 527
Tensile Strain, yield, 5 mm/min	3.3	%	ISO 527
Tensile Strain, break, 5 mm/min	14	%	ISO 527
Tensile Modulus, 1 mm/min	4200	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	92	MPa	ISO 178
Flexural Modulus, 2 mm/min	4100	MPa	ISO 178
IMPACT			
Izod Impact, unnotched 80*10*4 +23°C	121	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	7	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	16	kJ/m ²	ISO 179/1eA
THERMAL			
CTE, -30°C to 80°C, flow	3.8E-05	1/°C	ISO 11359-2
CTE, -30°C to 80°C, xflow	1.E-04	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			
Mold Shrinkage on Tensile Bar, flow	0.5 – 0.7	%	SABIC method
Melt Flow Rate, 265°C/5.0 kgf	20	g/10 min	ASTM D1238
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	16	cm ³ /10 min	ISO 1133
INJECTION MOLDING			
Drying Temperature	110	°C	
Drying Time	4 – 6	Hrs	
Drying Time (Cumulative)	8	Hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	260 – 275	°C	
Nozzle Temperature	255 – 270	°C	



PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Front - Zone 3 Temperature	255 – 275	°C	
Middle - Zone 2 Temperature	250 – 270	°C	
Rear - Zone 1 Temperature	245 – 265	°C	
Mold Temperature	65 – 90	°C	
Back Pressure	0.3 – 0.7	MPa	
Screw Speed	50 – 80	rpm	
Shot to Cylinder Size	50 – 80	%	
Vent Depth	0.013 – 0.02	mm	