



XENYO™ Resin X5630Q

Americas: COMMERCIAL

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

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yield, 5 mm/min	53	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	4340	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	92	MPa	ISO 178
Flexural Modulus, 2 mm/min	4110	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	6	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	4	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	108	°C	ISO 75/Af
PHYSICAL			
Mold Shrinkage on Tensile Bar, flow (2) (5)	0.5 - 0.7	%	SABIC Method
Melt Flow Rate, 265°C/5.0 kgf	20	g/10 min	ASTM D 1238
Density	1.35	g/cm ³	ISO 1183
Water Absorption, (23°C/sat)	0.42	%	ISO 62



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TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
PHYSICAL			
Moisture Absorption (23°C / 50% RH)	0.14	%	ISO 62
Melt Volume Rate, MVR at 265°C/5.0 kg	17	cm ³ /10 min	ISO 1133



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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 - 275	°C
Nozzle Temperature	255 - 270	°C
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