

Xylex * Resin EXXX0089

Americas: DEVELOPMENTAL

Low to medium flow, high polyester content, for applications that require robust chemical resistance

Property

TYPICAL PROPERTIES ⁽¹⁾			
	Value	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	58	MPa	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	60	MPa	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	120	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	120	%	ASTM D 638
Tensile Modulus, 5 mm/min	2000	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	80	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	1990	MPa	ASTM D 790
Tensile Stress, yield, 50 mm/min	60	MPa	ISO 527
Tensile Stress, break, 50 mm/min	60	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	120	%	ISO 527
Tensile Strain, break, 50 mm/min	120	%	ISO 527
Tensile Modulus, 1 mm/min	2000	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	80	MPa	ISO 178
Flexural Modulus, 2 mm/min	1990	MPa	ISO 178
IMPACT			
Izod Impact, notched, 23°C	-	J/m	ASTM D 256
Izod Impact, notched 80*10*4 +23°C	11	kJ/m ²	ISO 180/1A
THERMAL			
HDT, 1.82 MPa, 3.2mm, unannealed	98	°C	ASTM D 648
Vicat Softening Temp, Rate B/120	115	°C	ISO 306
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	98	°C	ISO 75/Af
PHYSICAL			
Specific Gravity	1.2	-	ASTM D 792
Melt Flow Rate, 200°C/3.8 kgf	0	g/10 min	ASTM D 1238
Density	1.2	g/cm ³	ISO 1183
Melt Volume Rate, MVR at 220°C/5.0 kg	0	cm ³ /10 min	ISO 1133
Melt Volume Rate, MVR at 265°C/2.16 kg	6	cm ³ /10 min	ISO 1133

Source GMD, last updated:04/10/2007

Processing

Parameter	Value	Unit
Injection Molding		
Drying Temperature	70 - 80	°C
Drying Time	3 - 5	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	240 - 270	°C
Nozzle Temperature	240 - 270	°C
Front - Zone 3 Temperature	240 - 270	°C
Middle - Zone 2 Temperature	235 - 265	°C

Rear - Zone 1 Temperature	235 - 255	°C
Mold Temperature	50 - 70	°C
Screw Speed	20 - 100	rpm

Source GMD, last updated:04/10/2007

THESE PROPERTY VALUES ARE NOT INTENDED FOR SPECIFICATION PURPOSES.

PLEASE CHECK WITH YOUR [\(LOCAL SALES OFFICE\)](#) FOR AVAILABILITY IN YOUR REGION

- (1) Typical values only. Variations within normal tolerances are possible for various colors. All values are measured after at least 48 hours storage at 23°C/50% relative humidity. All properties, except the melt volume and melt flow rates, are measured on injection molded samples. All samples tested under ISO test standards are prepared according to ISO 294.
- (2) Only typical data for selection purposes. Not to be used for part or tool design.
- (3) This rating is not intended to reflect hazards presented by this or any other material under actual fire conditions.
- (4) Internal measurements according to UL standards.

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