

Xylex * Resin EXXX0274 Europe-Africa-Middle East: DEVELOPMENTAL

F-1 weathering certified in natural color, specially designed for Pool & Spa applications

Property

TYPICAL PROPERTIES ⁽¹⁾			
MECHANICAL	Value	Unit	Standard
Tensile Stress, yld, Type I, 50 mm/min	61	MPa	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	65	MPa	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	6	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	130	%	ASTM D 638
Tensile Modulus, 5 mm/min	2300	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	96	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	2320	MPa	ASTM D 790
IMPACT	Value	Unit	Standard
Izod Impact, notched, 23°C	990	J/m	ASTM D 256
THERMAL	Value	Unit	Standard
HDT, 1.82 MPa, 3.2mm, unannealed	104	°C	ASTM D 648
PHYSICAL	Value	Unit	Standard
Specific Gravity	1.2	-	ASTM D 792
Melt Flow Rate, 200°C/3.8 kgf	3	g/10 min	ASTM D 1238
Melt Volume Rate, MVR at 265°C/2.16 kg	5	cm ³ /10 min	ISO 1133
OPTICAL	Value	Unit	Standard
Light Transmission	85	%	ASTM D 1003
Haze	1.6	%	ASTM D 1003

Source GMD, last updated:04/14/2006

Processing

Parameter	Value	Unit
Injection Molding		
Drying Temperature	65 - 75	°C
Drying Time	3 - 5	hrs
Drying Time (Cumulative)	8	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	245 - 265	°C
Nozzle Temperature	245 - 265	°C
Front - Zone 3 Temperature	245 - 265	°C
Middle - Zone 2 Temperature	240 - 260	°C
Rear - Zone 1 Temperature	240 - 250	°C
Mold Temperature	45 - 60	°C
Back Pressure	0.2 - 0.5	MPa
Screw Speed	20 - 100	rpm
Shot to Cylinder Size	40 - 80	%
Vent Depth	0.013 - 0.02	mm

Source GMD, last updated:04/14/2006

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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