

## Xylex \* Resin EXXX0069 Europe-Africa-Middle East: DEVELOPMENTAL

General purpose GEN2 Xylex, color/haze optimized for cosmetic packaging applications

### Property

TYPICAL PROPERTIES <sup>(1)</sup>			
MECHANICAL	Value	Unit	Standard
Tensile Stress, yield, 50 mm/min	58	MPa	ISO 527
Tensile Stress, break, 50 mm/min	60	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	6	%	ISO 527
Tensile Strain, break, 50 mm/min	135	%	ISO 527
Tensile Modulus, 1 mm/min	2100	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	90	MPa	ISO 178
Flexural Modulus, 2 mm/min	2000	MPa	ISO 178
IMPACT	Value	Unit	Standard
Izod Impact, notched 80*10*4 +23°C	11	kJ/m <sup>2</sup>	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	5	kJ/m <sup>2</sup>	ISO 180/1A
THERMAL	Value	Unit	Standard
Vicat Softening Temp, Rate B/120	120	°C	ISO 306
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	95	°C	ISO 75/Af
PHYSICAL	Value	Unit	Standard
Density	1.2	g/cm <sup>3</sup>	ISO 1183
Melt Volume Rate, MVR at 220°C/5.0 kg	7	cm <sup>3</sup> /10 min	ISO 1133
Melt Volume Rate, MVR at 265°C/2.16 kg	7	cm <sup>3</sup> /10 min	ISO 1133

Source GMD, last updated:05/15/2006

### 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:05/15/2006

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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