

XENOY™ RESIN X5600WX

REGION AMERICAS

DESCRIPTION

Unreinforced, opaque Polyester+PC alloy. Chemical resistance, dimensional stability and mechanical performance. UV Stabilized. Mold Release

TYPICAL PROPERTY VALUES

Revision 20190702

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	61	MPa	ASTM D638
Tensile Stress, brk, Type I, 50 mm/min	61	MPa	ASTM D638
Tensile Strain, yld, Type I, 50 mm/min	5.2	%	ASTM D638
Tensile Strain, brk, Type I, 50 mm/min	120	%	ASTM D638
Tensile Modulus, 50 mm/min	2480	MPa	ASTM D638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	99	MPa	ASTM D790
Flexural Modulus, 1.3 mm/min, 50 mm span	2480	MPa	ASTM D790
Tensile Stress, yield, 50 mm/min	55	MPa	ISO 527
Tensile Stress, break, 50 mm/min	56	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	4.5	%	ISO 527
Tensile Strain, break, 50 mm/min	120	%	ISO 527
Flexural Stress, yield, 2 mm/min	70	MPa	ISO 178
Flexural Modulus, 2 mm/min	2150	MPa	ISO 178
IMPACT			
Izod Impact, notched, 23°C	800	J/m	ASTM D256
Izod Impact, notched, -30°C	267	J/m	ASTM D256
Instrumented Dart Impact Total Energy, 23°C	54	J	ASTM D3763
Izod Impact, notched 80°10'4 +23°C	50	kJ/m²	ISO 180/1A
Izod Impact, notched 80°10'4 -30°C	20	kJ/m²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80°10'4 sp=62mm	60	kJ/m²	ISO 179/1eA
THERMAL			
Vicat Softening Temp, Rate B/50	130	°C	ASTM D1525
HDT, 0.45 MPa, 3.2 mm, unannealed	120	°C	ASTM D648
HDT, 1.82 MPa, 3.2mm, unannealed	98	°C	ASTM D648
CTE, -40°C to 40°C, flow	6.9E-05	1/°C	ASTM E831
CTE, -40°C to 40°C, xflow	7.4E-05	1/°C	ASTM E831
CTE, -40°C to 40°C, flow	6.9E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	7.4E-05	1/°C	ISO 11359-2
Vicat Softening Temp, Rate B/50	130	°C	ISO 306
Vicat Softening Temp, Rate B/120	132	°C	ISO 306
HDT/Af, 1.8 MPa Flatw 80°10'4 sp=64mm	95	°C	ISO 75/Af
PHYSICAL			
Specific Gravity	1.24	-	ASTM D792
Mold Shrinkage, flow, 3.2 mm	0.7 – 0.9	%	SABIC method
Mold Shrinkage, xflow, 3.2 mm	0.7 – 0.9	%	SABIC method

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CHEMISTRY THAT MATTERS™



PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Melt Flow Rate, 250°C/5.0 kgf	4.1	g/10 min	ASTM D1238
Density	1.2	g/cm³	ISO 1183
FLAME CHARACTERISTICS			
UL Yellow Card Link	E121562-506508	-	-
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	

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