SABIC Innovative Plastics™

Xenoy* Resin 6240

Americas: COMMERCIAL

10% GR, impact modified alloy, improved impact strength and ductility.

Property

TYPICAL PROPERTIES (1)			
MECHANICAL	Value	Unit	Standard
Tensile Stress, yld, Type I, 5 mm/min	62	MPa	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	62	MPa	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	4	%	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	96	MPa	ASTM D 790
Flexural Stress, brk, 1.3 mm/min, 50 mm span	96	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	2750	MPa	ASTM D 790
Hardness, Rockwell R	113	-	ASTM D 785
IMPACT	Value	Unit	Standard
Izod Impact, unnotched, 23°C	747	J/m	ASTM D 4812
Izod Impact, notched, 23°C	186	J/m	ASTM D 256
THERMAL	Value	Unit	Standard
HDT, 0.45 MPa, 6.4 mm, unannealed	176	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	121	°C	ASTM D 648
CTE, -40°C to 40°C, flow	5.22E-05	1/°C	ASTM E 831
CTE, 60°C to 138°C, flow	5.22E-05	1/°C	ASTM E 831
Relative Temp Index, Elec	75	°C	UL 746B
Relative Temp Index, Mech w/impact	75	°C	UL 746B
Relative Temp Index, Mech w/o impact	75	°C	UL 746B
PHYSICAL	Value	Unit	Standard
Specific Gravity	1.3	-	ASTM D 792
Specific Volume	0.76	cm³/g	ASTM D 792
Water Absorption, 24 hours	0.11	%	ASTM D 570
Mold Shrinkage, flow, 3.2 mm	0.7 - 0.9	%	SABIC Method
ELECTRICAL	Value	Unit	Standard
Volume Resistivity	7.E+15	Ohm-cm	ASTM D 257
Dielectric Strength, in air, 3.2 mm	18.8	kV/mm	ASTM D 149
Dielectric Strength, in oil, 1.6 mm	25.1	kV/mm	ASTM D 149
Dielectric Strength, in oil, 3.2 mm	18.8	kV/mm	ASTM D 149
Relative Permittivity, 100 Hz	3.4	-	ASTM D 150
Relative Permittivity, 100 kHz	3.3	-	ASTM D 150
Relative Permittivity, 1 MHz	3.3	-	ASTM D 150
Dissipation Factor, 100 Hz	0.002	-	ASTM D 150
Dissipation Factor, 100 kHz	0.02	-	ASTM D 150
Dissipation Factor, 1 MHz	0.01	-	ASTM D 150
FLAME CHARACTERISTICS	Value	Unit	Standard
UL Recognized, 94HB Flame Class Rating (3)	1.49	mm	UL 94

Source GMD, last updated:12/29/1999

Processing

Parameter Injection Molding	Value	Unit
Drying Temperature	110	°C
Drying Time	4 - 6	hrs
Drying Time (Cumulative)	8	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	260 - 280	°C
Nozzle Temperature	255 - 275	°C
Front - Zone 3 Temperature	260 - 280	°C
Middle - Zone 2 Temperature	255 - 275	°C
Rear - Zone 1 Temperature	250 - 270	°C
Mold Temperature	65 - 95	°C
Back Pressure	0.3 - 0.6	MPa
Screw Speed	50 - 80	rpm
Shot to Cylinder Size	50 - 80	%
Vent Depth	0.013 - 0.02	mm

Source GMD, last updated:12/29/1999

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.