

## Xenoy\* Resin 1732

Americas: COMMERCIAL

Unreinforced PBT+PC alloy. Impact/chemical resistance. UV-Stabilized. Easy flow version of 1731.

### Property

TYPICAL PROPERTIES <sup>(1)</sup>			
MECHANICAL	Value	Unit	Standard
Tensile Stress, yld, Type I, 50 mm/min	62	MPa	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	57	MPa	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	5	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	100	%	ASTM D 638
Tensile Modulus, 50 mm/min	1790	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	89	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	2340	MPa	ASTM D 790
IMPACT	Value	Unit	Standard
Izod Impact, notched, 23°C	747	J/m	ASTM D 256
Izod Impact, notched, -30°C	133	J/m	ASTM D 256
Instrumented Impact Total Energy, 23°C	56	J	ASTM D 3763
Instrumented Impact Total Energy, -30°C	73	J	ASTM D 3763
THERMAL	Value	Unit	Standard
Vicat Softening Temp, Rate B/50	129	°C	ASTM D 1525
HDT, 0.45 MPa, 3.2 mm, unannealed	118	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	101	°C	ASTM D 648
CTE, -40°C to 40°C, flow	7.38E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	7.56E-05	1/°C	ASTM E 831
PHYSICAL	Value	Unit	Standard
Specific Gravity	1.23	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	0.5 - 0.7	%	SABIC Method
Mold Shrinkage, xflow, 3.2 mm	0.6 - 0.8	%	SABIC Method
Melt Flow Rate, 266°C/5.0 kgf	30	g/10 min	ASTM D 1238

Source GMD, last updated:06/04/1998

### Processing

Parameter	Value	Unit
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

Source GMD, last updated:06/04/1998

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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