

Xenoy* Resin 5770

Americas: COMMERCIAL

20% GR/MR, PC/polyester alloy. Impact modified, chemical resistance, good surface and low warpage. Lawn and garden applications.

Property

TYPICAL PROPERTIES ⁽¹⁾			
MECHANICAL	Value	Unit	Standard
Tensile Stress, yld, Type I, 5 mm/min	82	MPa	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	84	MPa	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	4.5	%	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	131	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	4960	MPa	ASTM D 790
Hardness, Rockwell R	95	-	ASTM D 785
IMPACT	Value	Unit	Standard
Izod Impact, unnotched, 23°C	640	J/m	ASTM D 4812
Izod Impact, notched, 23°C	106	J/m	ASTM D 256
Izod Impact, notched, -30°C	69	J/m	ASTM D 256
Gardner, 23°C	67	J	ASTM D 3029
Gardner, -30°C	33	J	ASTM D 3029
Instrumented Impact Energy @ peak, 23°C	13	J	ASTM D 3763
THERMAL	Value	Unit	Standard
Vicat Softening Temp, Rate B/50	146	°C	ASTM D 1525
HDT, 0.45 MPa, 6.4 mm, unannealed	143	°C	ASTM D 648
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	1.39	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	0.4 - 0.6	%	SABIC Method
Mold Shrinkage, xflow, 3.2 mm	0.7 - 0.9	%	SABIC Method
FLAME CHARACTERISTICS	Value	Unit	Standard
UL Recognized, 94HB Flame Class Rating (3)	1.52	mm	UL 94

Source GMD, last updated:12/29/1999

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 - 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.

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