

Xenoy* Resin 6390

Americas: COMMERCIAL

30% glass filament reinforced PET+PC alloy for gas assist injection with high stiffness.

Property

TYPICAL PROPERTIES ⁽¹⁾			
MECHANICAL	Value	Unit	Standard
Tensile Stress, brk, Type I, 5 mm/min	110	MPa	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	4.2	%	ASTM D 638
Flexural Stress, brk, 1.3 mm/min, 50 mm span	165	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	6340	MPa	ASTM D 790
IMPACT	Value	Unit	Standard
Izod Impact, unnotched, 23°C	758	J/m	ASTM D 4812
Izod Impact, unnotched, -30°C	833	J/m	ASTM D 4812
Izod Impact, notched, 23°C	106	J/m	ASTM D 256
Izod Impact, notched, -30°C	85	J/m	ASTM D 256
Instrumented Impact Energy @ peak, 23°C	5	J	ASTM D 3763
Instrumented Impact Energy @ peak, -30	7	J	ASTM D 3763
Instrumented Impact Total Energy, 23°C	16	J	ASTM D 3763
Instrumented Impact Total Energy, -30°C	14	J	ASTM D 3763
THERMAL	Value	Unit	Standard
HDT, 0.45 MPa, 3.2 mm, unannealed	215	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	135	°C	ASTM D 648
HDT, 0.45 MPa, 6.4 mm, unannealed	196	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	126	°C	ASTM D 648
PHYSICAL	Value	Unit	Standard
Specific Gravity	1.49	-	ASTM D 792
Water Absorption, 24 hours	0.08	%	ASTM D 570
Mold Shrinkage, flow, 3.2 mm	0.1 - 0.3	%	SABIC Method
Mold Shrinkage, xflow, 3.2 mm	0.3 - 0.5	%	SABIC Method
Melt Flow Rate, 266°C/5.0 kgf	25	g/10 min	ASTM D 1238

Source GMD, last updated:12/29/1999

Processing

Parameter	Value	Unit
Injection Molding		
Drying Temperature	120	°C
Drying Time	4 - 6	hrs
Drying Time (Cumulative)	12	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	270 - 295	°C
Nozzle Temperature	270 - 290	°C
Front - Zone 3 Temperature	270 - 295	°C
Middle - Zone 2 Temperature	265 - 290	°C
Rear - Zone 1 Temperature	260 - 280	°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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