



XENOY™ Resin 6620

Americas: COMMERCIAL

PBT+PC, Unreinforced, impact modified thermoplastic alloy. Outstanding impact at low temperature

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	440	kgf/cm ²	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	175	%	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	650	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	17500	kgf/cm ²	ASTM D 790
Hardness, Rockwell R	108	-	ASTM D 785
IMPACT			
Izod Impact, unnotched, 23°C	163	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	91	cm-kgf/cm	ASTM D 256
Izod Impact, notched, -30°C	68	cm-kgf/cm	ASTM D 256
Gardner, 23°C	553	cm-kgf	ASTM D 3029
Modified Gardner, 23°C	553	cm-kgf	ASTM D 3029
THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	93	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	53	°C	ASTM D 648
HDT, 0.45 MPa, 6.4 mm, unannealed	98	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	60	°C	ASTM D 648
CTE, -40°C to 40°C, flow	9.4E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	9.8E-05	1/°C	ASTM E 831
CTE, 60°C to 138°C, flow	1.03E-04	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			
Specific Gravity	1.2	-	ASTM D 792

(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.

(5) Measurements made from laboratory test coupon. Actual shrinkage may vary outside of range due to differences in processing conditions, equipment, part geometry and tool design. It is recommended that mold shrinkage studies be performed with surrogate or legacy tooling prior to cutting tools for new molded article.

(6) Needs hard coat to consistently pass 60 sec Vertical Burn.

Source GMD, last updated:

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TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
PHYSICAL			
Specific Volume	0.83	cm ³ /g	ASTM D 792
Water Absorption, 24 hours	0.08	%	ASTM D 570
Mold Shrinkage, flow, 3.2 mm (5)	1.6 - 1.8	%	SABIC Method
Mold Shrinkage, xflow, 3.2 mm (5)	1.6 - 1.8	%	SABIC Method
ELECTRICAL			
Volume Resistivity	5.5E+16	Ohm-cm	ASTM D 257
Dielectric Strength, in air, 3.2 mm	19	kV/mm	ASTM D 149
Dielectric Strength, in oil, 1.6 mm	27.9	kV/mm	ASTM D 149
Dielectric Strength, in oil, 3.2 mm	19	kV/mm	ASTM D 149
Relative Permittivity, 100 Hz	3.1	-	ASTM D 150
Relative Permittivity, 100 kHz	3	-	ASTM D 150
Relative Permittivity, 1 MHz	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	0.02	-	ASTM D 150
Arc Resistance, Tungsten {PLC}	5	PLC Code	ASTM D 495
Hot Wire Ignition {PLC}	3	PLC Code	UL 746A
High Voltage Arc Track Rate {PLC}	1	PLC Code	UL 746A
High Ampere Arc Ign, surface {PLC}	0	PLC Code	UL 746A
Comparative Tracking Index (UL) {PLC}	0	PLC Code	UL 746A
FLAME CHARACTERISTICS			
UL Recognized, 94HB Flame Class Rating (3)	1.47	mm	UL 94

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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	105 - 115	°C
Drying Time	2 - 4	hrs
Drying Time (Cumulative)	6	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	240 - 260	°C
Nozzle Temperature	240 - 260	°C
Front - Zone 3 Temperature	240 - 260	°C
Middle - Zone 2 Temperature	230 - 250	°C
Rear - Zone 1 Temperature	225 - 245	°C
Mold Temperature	50 - 80	°C
Back Pressure	0.2 - 0.3	MPa
Shot to Cylinder Size	50 - 80	%
Vent Depth	0.013 - 0.02	mm

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