



XENOY™ Resin 1731

Americas: COMMERCIAL

Impact/chemical resistant. UV-Stabilized. Excellent physical property retention in automotive exteriors and OVAD.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	620	kgf/cm ²	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	570	kgf/cm ²	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, 5 mm/min	24100	kgf/cm ²	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	940	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	23900	kgf/cm ²	ASTM D 790
Tensile Stress, yield, 50 mm/min	60	MPa	ISO 527
Tensile Stress, break, 50 mm/min	58	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	5	%	ISO 527
Tensile Strain, break, 50 mm/min	90	%	ISO 527
Tensile Modulus, 1 mm/min	2330	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	93	MPa	ISO 178
Flexural Modulus, 2 mm/min	2210	MPa	ISO 178
IMPACT			
Izod Impact, notched, 23°C	68	cm-kgf/cm	ASTM D 256
Izod Impact, notched, -30°C	10	cm-kgf/cm	ASTM D 256
Izod Impact, notched, 23°C, 6.4mm	16	cm-kgf/cm	ASTM D 256
Instrumented Impact Total Energy, 23°C	623	cm-kgf	ASTM D 3763
Instrumented Impact Total Energy, -30°C	626	cm-kgf	ASTM D 3763
Izod Impact, notched 80*10*4 +23°C	59	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	16	kJ/m ²	ISO 180/1A

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(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
IMPACT			
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	65	kJ/m ²	ISO 179/1eA
THERMAL			
Vicat Softening Temp, Rate B/50	125	°C	ASTM D 1525
HDT, 1.82 MPa, 3.2mm, unannealed	93	°C	ASTM D 648
HDT, 0.45 MPa, 6.4 mm, unannealed	115	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	107	°C	ASTM D 648
CTE, -40°C to 40°C, flow	7.75E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	7.57E-05	1/°C	ASTM E 831
CTE, -40°C to 95°C, flow	8.28E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, flow	7.75E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	7.57E-05	1/°C	ISO 11359-2
Vicat Softening Temp, Rate B/50	127	°C	ISO 306
Vicat Softening Temp, Rate B/120	130	°C	ISO 306
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	99	°C	ISO 75/Af
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	1.22	-	ASTM D 792
Specific Volume	0.82	cm ³ /g	ASTM D 792
Mold Shrinkage, flow, 3.2 mm (5)	0.5 - 0.7	%	SABIC Method
Mold Shrinkage, xflow, 3.2 mm (5)	0.6 - 0.8	%	SABIC Method
Melt Flow Rate, 250°C/5.0 kgf	9.6	g/10 min	ASTM D 1238
Density	1.22	g/cm ³	ISO 1183
Water Absorption, (23°C/sat)	0.28	%	ISO 62

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TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
PHYSICAL			
Moisture Absorption (23°C / 50% RH)	0.08	%	ISO 62
Melt Flow Rate, 250°C/5.0 kg	8	g/10 min	ISO 1133
ELECTRICAL			
Arc Resistance, Tungsten {PLC}	5	PLC Code	ASTM D 495
Hot Wire Ignition {PLC}	2	PLC Code	UL 746A
High Voltage Arc Track Rate {PLC}	2	PLC Code	UL 746A
High Ampere Arc Ign, surface {PLC}	0	PLC Code	UL 746A
Comparative Tracking Index (UL) {PLC}	2	PLC Code	UL 746A
FLAME CHARACTERISTICS			
UL Recognized, 94HB Flame Class Rating (3)	1.49	mm	UL 94

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PROCESSING PARAMETERS	TYPICAL 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

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