

Xenoy* Resin X6800BM

Americas: COMMERCIAL

Blow moldable, impact modified XENYOY

Property

TYPICAL PROPERTIES ⁽¹⁾			
MECHANICAL	Value	Unit	Standard
Tensile Stress, yld, Type I, 50 mm/min	35	MPa	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	48	MPa	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	11	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	238	%	ASTM D 638
Tensile Modulus, 5 mm/min	1690	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	51	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	1650	MPa	ASTM D 790
Tensile Stress, yield, 50 mm/min	31	MPa	ISO 527
Tensile Stress, break, 50 mm/min	38	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	14.4	%	ISO 527
Tensile Strain, break, 50 mm/min	167	%	ISO 527
Tensile Modulus, 1 mm/min	1700	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	48	MPa	ISO 178
Flexural Modulus, 2 mm/min	1420	MPa	ISO 178
IMPACT	Value	Unit	Standard
Izod Impact, notched, 23°C	802	J/m	ASTM D 256
Izod Impact, notched, -30°C	186	J/m	ASTM D 256
Instrumented Impact Total Energy, 23°C	54	J	ASTM D 3763
Izod Impact, notched 80*10*4 +23°C	95	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	22	kJ/m ²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	129	kJ/m ²	ISO 179/1eA
THERMAL	Value	Unit	Standard
Vicat Softening Temp, Rate B/50	115	°C	ASTM D 1525
HDT, 1.82 MPa, 3.2mm, unannealed	47	°C	ASTM D 648
CTE, -40°C to 40°C, flow	8.3E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	1.7E-04	1/°C	ASTM E 831
CTE, -40°C to 40°C, flow	8.3E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	1.7E-04	1/°C	ISO 11359-2
Vicat Softening Temp, Rate B/50	118	°C	ISO 306
Vicat Softening Temp, Rate B/120	115	°C	ISO 306
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	46	°C	ISO 75/Af
PHYSICAL	Value	Unit	Standard
Specific Gravity	1.22	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	2.85 - 3.35	%	SABIC Method
Melt Flow Rate, 265°C/2.16kg	4	g/10 min	ASTM D 1238
Density	1.22	g/cm ³	ISO 1183
Water Absorption, (23°C/sat)	0.1	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.01	%	ISO 62
Melt Volume Rate, MVR at 265°C/5.0 kg	9	cm ³ /10 min	ISO 1133

Processing

Parameter	Value	Unit
Extrusion Blow Molding		
Drying Temperature	100 - 105	°C
Drying Time	3 - 4	hrs
Drying Time (Cumulative)	12	hrs
Maximum Moisture Content	0.01 - 0.03	%
Melt Temperature (Parison)	255 - 265	°C
Barrel - Zone 1 Temperature	250 - 260	°C
Barrel - Zone 2 Temperature	250 - 260	°C
Barrel - Zone 3 Temperature	255 - 260	°C
Barrel - Zone 4 Temperature	255 - 265	°C
Adapter - Zone 5 Temperature	255 - 265	°C
Head - Zone 6 - Top Temperature	255 - 265	°C
Head - Zone 7 - Middle Temperature	255 - 265	°C
Head - Zone 7 - Bottom Temperature	255 - 265	°C
Screw Speed	15 - 50	rpm
Extruder Feed Zone Temperature	255 - 265	°C
Accumulator Temperature	255 - 265	°C
Mold Temperature	50 - 95	°C
Die Temperature	255 - 265	°C

Source GMD, last updated:04/27/2007

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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