

Xylex * Resin EXXX0270

Americas: LIMITED USE

Good Chemical Resistance, diffuse visual effects XYLEX grade with good dishwasher performance; currently available only in natural

Property

TYPICAL PROPERTIES ⁽¹⁾			
MECHANICAL	Value	Unit	Standard
Tensile Stress, yld, Type I, 50 mm/min	58	MPa	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	66	MPa	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	2	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	120	%	ASTM D 638
Tensile Modulus, 5 mm/min	2510	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	99	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	2280	MPa	ASTM D 790
Tensile Stress, yield, 50 mm/min	61	MPa	ISO 527
Tensile Stress, break, 50 mm/min	66	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	6	%	ISO 527
Tensile Strain, break, 50 mm/min	134	%	ISO 527
Tensile Modulus, 1 mm/min	2370	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	90	MPa	ISO 178
Flexural Modulus, 2 mm/min	2030	MPa	ISO 178
IMPACT	Value	Unit	Standard
Izod Impact, notched, 23°C	700	J/m	ASTM D 256
Izod Impact, notched 80*10*4 +23°C	10	kJ/m ²	ISO 180/1A
THERMAL	Value	Unit	Standard
HDT, 1.82 MPa, 3.2mm, unannealed	113	°C	ASTM D 648
Ball Pressure Test, 75°C +/- 2°C	10	-	IEC 60695-10-2
Vicat Softening Temp, Rate B/120	132	°C	ISO 306
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	112	°C	ISO 75/Af
PHYSICAL	Value	Unit	Standard
Specific Gravity	1.19	-	ASTM D 792
Melt Flow Rate, 300°C/1.2 kgf	12.5	g/10 min	ASTM D 1238
Density	1.19	g/cm ³	ISO 1183
Melt Volume Rate, MVR at 300°C/1.2 kg	10	cm ³ /10 min	ISO 1133

Source GMD, last updated:09/27/2006

Processing

Parameter	Value	Unit
Injection Molding		
Drying Temperature	75 - 85	°C
Drying Time	3 - 5	hrs
Drying Time (Cumulative)	8	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	285 - 305	°C
Nozzle Temperature	285 - 305	°C
Front - Zone 3 Temperature	285 - 305	°C

Middle - Zone 2 Temperature	280 - 305	°C
Rear - Zone 1 Temperature	280 - 295	°C
Mold Temperature	50 - 65	°C
Back Pressure	0.1 - 0.5	MPa
Screw Speed	20 - 100	rpm
Shot to Cylinder Size	40 - 80	%
Vent Depth	0.013 - 0.02	mm

Source GMD, last updated:09/27/2006

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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