

Xenoy* Resin 6620U

Americas: COMMERCIAL

UR, PBT+PC alloy. Improved mechanical properties retention under UV vs 6620. Outstanding low temperature impact/chemical resistance.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	43	MPa	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	150	%	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	64	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	1720	MPa	ASTM D 790
IMPACT			
Izod Impact, unnotched, 23°C	1602	J/m	ASTM D 4812
Izod Impact, notched, 23°C	801	J/m	ASTM D 256
Izod Impact, notched, -40°C	640	J/m	ASTM D 256
THERMAL			
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
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
Specific Volume	0.83	cm ³ /g	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	1.6 - 1.8	%	SABIC Method
Mold Shrinkage, xflow, 3.2 mm	1.6 - 1.8	%	SABIC Method
ELECTRICAL			
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



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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	250 - 270	°C
Nozzle Temperature	250 - 270	°C
Front - Zone 3 Temperature	250 - 265	°C
Middle - Zone 2 Temperature	240 - 255	°C
Rear - Zone 1 Temperature	230 - 245	°C
Mold Temperature	40 - 80	°C
Back Pressure	0.2 - 0.3	MPa
Shot to Cylinder Size	50 - 80	%
Vent Depth	0.013 - 0.02	mm

