

Xylex* Resin X7507

Americas: COMMERCIAL

F-1 weathering certified in natural color, specially designed for Pool & Spa applications. Currently available in natural color only.

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	660	kgf/cm ²	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	6	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	130	%	ASTM D 638
Tensile Modulus, 5 mm/min	23400	kgf/cm ²	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	970	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	23600	kgf/cm ²	ASTM D 790
Tensile Stress, yield, 50 mm/min	62	MPa	ISO 527
Tensile Stress, break, 50 mm/min	59	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	5.4	%	ISO 527
Tensile Strain, break, 50 mm/min	110	%	ISO 527
Tensile Modulus, 1 mm/min	2660	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	92	MPa	ISO 178
Flexural Modulus, 2 mm/min	2180	MPa	ISO 178
IMPACT			
Izod Impact, notched, 23°C	100	cm-kgf/cm	ASTM D 256
Izod Impact, notched, -30°C	20	cm-kgf/cm	ASTM D 256
Instrumented Impact Total Energy, 23°C	805	cm-kgf	ASTM D 3763
Izod Impact, notched 80*10*4 +23°C	9	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	6	kJ/m ²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	20	kJ/m ²	ISO 179/1eA
THERMAL			
Vicat Softening Temp, Rate B/50	104	°C	ASTM D 1525

1) Typical values only. Variations within normal tolerances are possible for various colours. All values are measured at least after 48 hours storage at 23°C/50% relative humidity. All properties, except the melt volume rate are measured on injection moulded samples. All samples are prepared according to ISO 294.

2) Only typical data for material selection purpose. 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) Own measurement according to UL.

Source, GMD, Last Update: 02/07/2007

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TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
THERMAL			
HDT, 1.82 MPa, 3.2mm, unannealed	104	°C	ASTM D 648
CTE, -40°C to 40°C, flow	6.E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	7.E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, flow	6.E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	6.3E-05	1/°C	ISO 11359-2
Vicat Softening Temp, Rate B/50	125	°C	ISO 306
Vicat Softening Temp, Rate B/120	127	°C	ISO 306
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	105	°C	ISO 75/Af
PHYSICAL			
Specific Gravity	1.2	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	0.5 - 0.8	%	SABIC Method
Melt Flow Rate, 265°C/2.16kg	8	g/10 min	ASTM D 1238
Density	1.2	g/cm ³	ISO 1183
Water Absorption, (23°C/sat)	0.32	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.12	%	ISO 62
Melt Volume Rate, MVR at 265°C/2.16 kg	5	cm ³ /10 min	ISO 1133
OPTICAL			
Light Transmission	>85	%	ASTM D 1003
Haze	1.6	%	ASTM D 1003

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PROCESSING PARAMETERS	TYPICAL VALUE	UNIT
Injection Molding		
Drying Temperature	80 - 95	°C
Drying Time	3 - 5	hrs
Drying Time (Cumulative)	8	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	250 - 270	°C
Nozzle Temperature	250 - 270	°C
Front - Zone 3 Temperature	250 - 270	°C
Middle - Zone 2 Temperature	245 - 265	°C
Rear - Zone 1 Temperature	240 - 250	°C
Mold Temperature	45 - 60	°C
Back Pressure	0.2 - 0.5	MPa
Screw Speed	20 - 100	rpm
Shot to Cylinder Size	40 - 80	%
Vent Depth	0.013 - 0.02	mm

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