



**XENOY™ Resin 5720U**  
**Americas: COMMERCIAL**

Unfilled PBT+PC alloy. Outstanding low temperature impact/chemical resistance. UV stabilized version of XENOY

TYPICAL PROPERTIES <sup>1</sup>	TYPICAL VALUE	Unit	Standard
<b>MECHANICAL</b>			
Tensile Stress, yld, Type I, 50 mm/min	470	kgf/cm <sup>2</sup>	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	480	kgf/cm <sup>2</sup>	ASTM D 638
Tensile Stress, yld, Type I, 5 mm/min	440	kgf/cm <sup>2</sup>	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	500	kgf/cm <sup>2</sup>	ASTM D 638
Tensile Stress, yld, Type I, 10 mm/min	450	kgf/cm <sup>2</sup>	SABIC - Japan Method
Tensile Stress, brk, Type I, 10 mm/min	470	kgf/cm <sup>2</sup>	SABIC - Japan Method
Tensile Strain, yld, Type I, 50 mm/min	4	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	116.6	%	ASTM D 638
Tensile Strain, yld, Type I, 5 mm/min	4.6	%	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	122.4	%	ASTM D 638
Tensile Strain, yld, Type I, 10 mm/min	4.6	%	SABIC - Japan Method
Tensile Strain, brk, Type I, 10 mm/min	109.5	%	SABIC - Japan Method
Tensile Modulus, 50 mm/min	18500	kgf/cm <sup>2</sup>	ASTM D 638
Tensile Modulus, 5 mm/min	18600	kgf/cm <sup>2</sup>	ASTM D 638
Tensile Modulus, 10 mm/min	18700	kgf/cm <sup>2</sup>	SABIC - Japan Method
Flexural Stress, yld, 1.3 mm/min, 50 mm span	710	kgf/cm <sup>2</sup>	ASTM D 790
Flexural Stress, brk, 1.3 mm/min, 50 mm span	700	kgf/cm <sup>2</sup>	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	16900	kgf/cm <sup>2</sup>	ASTM D 790
Tensile Stress, yield, 5 mm/min	44	MPa	ISO 527
Tensile Stress, break, 5 mm/min	43	MPa	ISO 527
Tensile Stress, yield, 50 mm/min	47	MPa	ISO 527

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(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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<b>MECHANICAL</b>			
Tensile Stress, break, 50 mm/min	43	MPa	ISO 527
Tensile Strain, yield, 5 mm/min	4.1	%	ISO 527
Tensile Strain, break, 5 mm/min	106.8	%	ISO 527
Tensile Strain, yield, 50 mm/min	4.6	%	ISO 527
Tensile Strain, break, 50 mm/min	115.3	%	ISO 527
Tensile Modulus, 1 mm/min	1790	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	71	MPa	ISO 178
Flexural Modulus, 2 mm/min	1860	MPa	ISO 178
<b>IMPACT</b>			
Izod Impact, notched, 23°C	73	cm-kgf/cm	ASTM D 256
Izod Impact, notched, 0°C	70	cm-kgf/cm	ASTM D 256
Izod Impact, notched, -10°C	67	cm-kgf/cm	ASTM D 256
Izod Impact, notched, -20°C	70	cm-kgf/cm	ASTM D 256
Izod Impact, notched, -30°C	65	cm-kgf/cm	ASTM D 256
Izod Impact, notched, -40°C	60	cm-kgf/cm	ASTM D 256
Instrumented Impact Energy @ peak, 23°C	456	cm-kgf	ASTM D 3763
Instrumented Impact, Energy @ peak, -20°C	420	cm-kgf	ASTM D 3763
Instrumented Impact Energy @ peak, -30	504	cm-kgf	ASTM D 3763
Instrumented Impact Energy @ peak, -40°C	504	cm-kgf	ASTM D 3763
Instrumented Impact Total Energy, 23°C	550	cm-kgf	ASTM D 3763
Instrumented Impact Total Energy, -20°C	542	cm-kgf	ASTM D 3763
Instrumented Impact Total Energy, -30°C	631	cm-kgf	ASTM D 3763
Instrumented Impact Total Energy, -40°C	603	cm-kgf	ASTM D 3763
Izod Impact, notched 80*10*4 +23°C	55	kJ/m <sup>2</sup>	ISO 180/1A

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<b>IMPACT</b>			
Izod Impact, notched 80*10*4 0°C	55	kJ/m <sup>2</sup>	ISO 180/1A
Izod Impact, notched 80*10*4 -10°C	52	kJ/m <sup>2</sup>	ISO 180/1A
Izod Impact, notched 80*10*4 -20°C	50	kJ/m <sup>2</sup>	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	48	kJ/m <sup>2</sup>	ISO 180/1A
Izod Impact, notched 80*10*4 -40°C	46	kJ/m <sup>2</sup>	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	55	kJ/m <sup>2</sup>	ISO 179/1eA
Charpy -30°C, V-notch Edgew 80*10*4 sp=62mm	47	kJ/m <sup>2</sup>	ISO 179/1eA
<b>THERMAL</b>			
Vicat Softening Temp, Rate B/50	119	°C	ASTM D 1525
HDT, 0.45 MPa, 3.2 mm, unannealed	108	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	83	°C	ASTM D 648
HDT, 0.45 MPa, 6.4 mm, unannealed	117	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	95	°C	ASTM D 648
CTE, -40°C to 95°C, flow	9.75E-05	1/°C	ASTM E 831
CTE, -40°C to 95°C, xflow	1.E-04	1/°C	ASTM E 831
CTE, -30°C to 80°C, flow	9.75E-05	1/°C	ISO 11359-2
CTE, -30°C to 80°C, xflow	1.E-04	1/°C	ISO 11359-2
Vicat Softening Temp, Rate B/50	119	°C	ISO 306
Vicat Softening Temp, Rate B/120	122	°C	ISO 306
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	109	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	87	°C	ISO 75/Af
<b>PHYSICAL</b>			
Specific Gravity	1.17	-	ASTM D 792
Specific Volume	0.85	cm <sup>3</sup> /g	ASTM D 792
Density	1.17	g/cm <sup>3</sup>	ASTM D 792
Mold Shrinkage, flow, 3.2 mm (5)	1 - 1.2	%	SABIC Method
Melt Flow Rate, 250°C/2.16 kgf	3.8	g/10 min	ASTM D 1238
Melt Flow Rate, 250°C/5.0 kgf	11.4	g/10 min	ASTM D 1238

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TYPICAL PROPERTIES <sup>1</sup>	TYPICAL VALUE	Unit	Standard
<b>PHYSICAL</b>			
Melt Flow Rate, 265°C/2.16kgf	6	g/10 min	ASTM D 1238
Melt Flow Rate, 266°C/5.0 kgf	19.7	g/10 min	ASTM D 1238
Density	1.17	g/cm <sup>3</sup>	ISO 1183
Water Absorption, (23°C/sat)	0.28	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.08	%	ISO 62
Melt Flow Rate, 250°C/2.16 kg	3	g/10 min	ISO 1133
Melt Flow Rate, 250°C/5.0 kg	11	g/10 min	ISO 1133
Melt Volume Rate, MVR at 250°C/2.16 kg	3	cm <sup>3</sup> /10 min	ISO 1133
Melt Volume Rate, MVR at 250°C/5.0 kg	10	cm <sup>3</sup> /10 min	ISO 1133
Melt Volume Rate, MVR at 265°C/2.16 kg	6	cm <sup>3</sup> /10 min	ISO 1133
Melt Volume Rate, MVR at 265°C/5.0 kg	18	cm <sup>3</sup> /10 min	ISO 1133

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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
<b>Injection Molding</b>		
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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