

# EXTEM<sup>TM</sup> RESIN XH2315

REGION ASIA

## DESCRIPTION

Extem XH2315 Resin. Also UL rating V094 at 0.75 and V0,5VA at 1.0 and 1.5-1.65

## TYPICAL PROPERTY VALUES

Revision 20181122

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
<b>MECHANICAL</b>			
Tensile Stress, yld, Type I, 5 mm/min	156	MPa	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	156	MPa	ASTM D 638
Tensile Strain, yld, Type I, 5 mm/min	3	%	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	3	%	ASTM D 638
Tensile Modulus, 5 mm/min	10230	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	206	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	8960	MPa	ASTM D 790
Tensile Stress, yield, 5 mm/min	147	MPa	ISO 527
Tensile Stress, break, 5 mm/min	147	MPa	ISO 527
Tensile Strain, yield, 5 mm/min	2	%	ISO 527
Tensile Strain, break, 5 mm/min	2	%	ISO 527
Tensile Modulus, 1 mm/min	10530	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	200	MPa	ISO 178
Flexural Modulus, 2 mm/min	9000	MPa	ISO 178
<b>IMPACT</b>			
Izod Impact, notched, 23°C	86	J/m	ASTM D 256
Izod Impact, Reverse Notched, 3.2 mm	320	J/m	ASTM D 256
Instrumented Impact Total Energy, 23°C	8	J	ASTM D 3763
Izod Impact, notched 80°10'4 +23°C	5	kJ/m <sup>2</sup>	ISO 180/1A
Charpy 23°C, V-notch Edgew 80°10'4 sp=62mm	24	kJ/m <sup>2</sup>	ISO 179/1eA
<b>THERMAL</b>			
Vicat Softening Temp, Rate B/50	267	°C	ASTM D 1525
HDT, 0.45 MPa, 3.2 mm, unannealed	257	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	254	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	255	°C	ASTM D 648
CTE, 23°C to 150°C, flow	1.6E-05	1/°C	ASTM E 831
CTE, 23°C to 150°C, xflow	5.3E-05	1/°C	ASTM E 831
<b>PHYSICAL</b>			
Specific Gravity	1.52	-	ASTM D 792
Water Absorption, 23°C/48hrs	0.59	%	ASTM D 570
Melt Flow Rate, 367°C/6.6 kgf	4	g/10 min	ASTM D 1238
Density	1.52	g/cm <sup>3</sup>	ISO 1183
<b>INJECTION MOLDING</b>			
Drying Temperature	175	°C	

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Drying Time	4 – 6	hrs	
Drying Time (Cumulative)	24	hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	380 – 405	°C	
Nozzle Temperature	375 – 400	°C	
Front - Zone 3 Temperature	380 – 405	°C	
Middle - Zone 2 Temperature	370 – 395	°C	
Rear - Zone 1 Temperature	360 – 380	°C	
Mold Temperature	150 – 175	°C	
Back Pressure	0.3 – 0.7	MPa	
Screw Speed	70 – 100	rpm	
Shot to Cylinder Size	40 – 70	%	
Vent Depth	0.025 – 0.076	mm	

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