

# XYLEX™ RESIN X7519HP

REGION ASIA

## DESCRIPTION

Good Chemical Resistance, XYLEX grade with good dishwasher performance, USA/Europe Food Contact

Comment: While molding of thicker parts, cooling speed has an influence of transparency. Thicker parts may form opaque areas in the centre due to slow cooling.

## TYPICAL PROPERTY VALUES

Revision 20220721

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
<b>MECHANICAL</b>			
Tensile Stress, yld, Type I, 50 mm/min	58	MPa	ASTM D638
Tensile Stress, brk, Type I, 50 mm/min	66	MPa	ASTM D638
Tensile Strain, yld, Type I, 50 mm/min	2	%	ASTM D638
Tensile Strain, brk, Type I, 50 mm/min	120	%	ASTM D638
Tensile Modulus, 5 mm/min	2470	MPa	ASTM D638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	98	MPa	ASTM D790
Flexural Modulus, 1.3 mm/min, 50 mm span	2240	MPa	ASTM D790
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
<b>IMPACT</b>			
Izod Impact, notched, 23°C	700	J/m	ASTM D256
Izod Impact, notched, -30°C	100	J/m	ASTM D256
Instrumented Dart Impact Total Energy, 23°C	74	J	ASTM D3763
Izod Impact, notched 80*10*4 +23°C	10	kJ/m <sup>2</sup>	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	8	kJ/m <sup>2</sup>	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	13	kJ/m <sup>2</sup>	ISO 179/1eA
<b>THERMAL</b>			
Vicat Softening Temp, Rate B/50	130	°C	ASTM D1525
HDT, 1.82 MPa, 3.2mm, unannealed	113	°C	ASTM D648
CTE, -40°C to 40°C, flow	6.5E-05	1/°C	ASTM E831
CTE, -40°C to 40°C, xflow	6.7E-05	1/°C	ASTM E831
CTE, -40°C to 40°C, flow	7.5E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	7.5E-05	1/°C	ISO 11359-2
Vicat Softening Temp, Rate B/50	130	°C	ISO 306
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
<b>PHYSICAL</b>			
Specific Gravity	1.19	-	ASTM D792
Mold Shrinkage, flow, 3.2 mm	0.7 – 0.8	%	SABIC method

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Melt Flow Rate, 300°C/1.2 kgf	12.5	g/10 min	ASTM D1238
Density	1.19	g/cm <sup>3</sup>	ISO 1183
Water Absorption, (23°C/saturated)	0.16	%	ISO 62-1
Moisture Absorption (23°C / 50% RH)	0.14	%	ISO 62
Melt Volume Rate, MVR at 300°C/1.2 kg	10	cm <sup>3</sup> /10 min	ISO 1133
<b>INJECTION MOLDING</b>			
Drying Temperature	85 – 100	°C	
Drying Time	2 – 3	Hrs	
Drying Time (Cumulative)	8	Hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	280 – 300	°C	
Nozzle Temperature	280 – 290	°C	
Front - Zone 3 Temperature	290 – 300	°C	
Middle - Zone 2 Temperature	280 – 290	°C	
Rear - Zone 1 Temperature	275 – 285	°C	
Hopper Temperature	50	°C	
Mold Temperature	65 – 75	°C	
Back Pressure	0.1 – 0.5	MPa	
Screw Speed	20 – 100	rpm	
Shot to Cylinder Size	40 – 80	%	

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