



Xenoy* Resin 6123M

Americas: COMMERCIAL

Property

NECHANICAL Value Unit Standard	TYPICAL PROPERTIES (1)			
Tensile Strain, brk, Type I, 50 mm/min 130	MECHANICAL	Value	Unit	Standard
Flexural Stress, yld, 1.3 mm/min, 50 mm span 1990 MPa ASTM D 790 Flexural Modulus, 1.3 mm/min, 50 mm span 1990 MPa ASTM D 790 MPa ASTM D 795 MPACT Value Unit Standard Uzod Impact, unnotched, 23°C 1602 J/m ASTM D 4812 Izod Impact, notothed, 23°C 801 J/m ASTM D 4812 Izod Impact, notothed, 23°C 801 J/m ASTM D 256 Modified Gardner, 23°C 54 J ASTM D 256 Modified Gardner, 23°C 54 J ASTM D 3029 MPACT Value Unit Standard HDT, 4.82 MPa, 6.4 mm, unannealed 115 °C ASTM D 648 HDT, 4.82 MPa, 6.4 mm, unannealed 86 °C ASTM D 648 HDT, 4.82 MPa, 6.4 mm, unannealed 86 °C ASTM D 648 CTE, 40°C to 40°C, flow 9.E-05 1/°C ASTM E 831 CTE, 60°C to 138°C, flow 1.44E-04 1/°C ASTM E 831 CTE, 60°C to 138°C, flow 1.44E-04 1/°C ASTM E 831 Relative Temp Index, Mech w/impact 115 °C UL 746B Relative Temp Index, Mech w/impact 115 °C UL 746B PHYSICAL Value Unit Standard Specific Gravity 1.24 °ASTM D 792 Specific Volume 0.8 °C MPACT ASTM D 792 Model Shrinkage, flow, 3.2 mm 1.2 - 1.5 % SABIC Method Mold Shrinkage, flow, 3.2 mm 1.2 - 1.5 % SABIC Method Mold Shrinkage, flow, 3.2 mm 1.2 - 1.5 % SABIC Method Mold Shrinkage, flow, 3.2 mm 1.2 - 1.5 % SABIC Method Mold Shrinkage, flow, 3.2 mm 1.2 - 1.5 % SABIC Method Mold Shrinkage, flow, 3.2 mm 1.2 - 1.5 % SABIC Method Mold Shrinkage, flow, 3.2 mm 1.2 - 1.5 % SABIC Method Mold Shrinkage, flow, 3.2 mm 1.2 - 1.5 % SABIC Method Mold Shrinkage, flow, 3.2 mm 1.2 - 1.5 % SABIC Method Mold Shrinkage, flow, 3.2 mm 1.2 - 1.5 % SABIC Method Mold Shrinkage, flow, 3.2 mm 1.2 - 1.5 % SABIC Method Mold Shrinkage, flow, 3.2 mm 1.2 - 1.5 % SABIC Method Mold Shrinkage, flow, 3.2 mm 1.2 - 1.5 % SABIC Method Mold Shrinkage, flow, 3.2 mm 1.2 - 1.5 % SABIC Method Mold Shrinkage, flow, 3.2 mm 1.2 - 1.5 % SABIC Method Mold Shrinkage, flow, 3.2 mm 1.2 - 1.5 % SABIC Method Mold Shrinkage, flow, 3.2 mm 1.2 - 1.5 % SABIC Method Mold Shrin	Tensile Stress, yld, Type I, 50 mm/min	46	MPa	ASTM D 638
Flexural Modulus, 1.3 mm/min, 50 mm span 1990	Tensile Strain, brk, Type I, 50 mm/min	130	%	ASTM D 638
Hardness, Rockwell R	Flexural Stress, yld, 1.3 mm/min, 50 mm span	75	MPa	ASTM D 790
MPACT 20d Impact, unnotched, 23°C 1602 J/m ASTM D 4812 20d Impact, unnotched, 23°C 801 J/m ASTM D 4812 20d Impact, notched, 23°C 54 J ASTM D 3029 Modified Gardner, 23°C Unit Standard MDT, 0.45 MPa, 6.4 mm, unannealed 86 °C ASTM D 648 MDT, 0.45 MPa, 6.4 mm, unannealed 86 °C ASTM D 648 MDT, 0.45 MPa, 6.4 mm, unannealed 86 °C ASTM D 648 MDT, 0.45 MPa, 6.4 mm, unannealed 86 °C ASTM D 648 MDT, 0.45 MPa, 6.4 mm, unannealed 86 °C ASTM D 648 MDT, 0.45 MPa, 6.4 mm, unannealed 87 °C ASTM D 648 MDT, 0.45 MPa, 6.4 mm, unannealed 87 °C ASTM D 648 MDT, 0.45 MPa, 6.4 mm, unannealed 87 °C ASTM D 648 MDT, 0.45 MPa, 6.4 mm, unannealed 87 °C ASTM D 648 MDT, 0.44 MPa, 24 °C ASTM D 648 MDT, 0.45 MPa, 24 °C ASTM E 831 MDT, 0.46 MPA, 24 °C UL 746B MDT, 0.45 MPA, 24 °C UL 746A MDT, 0.45 MPA, 24	Flexural Modulus, 1.3 mm/min, 50 mm span	1990	MPa	ASTM D 790
Izod Impact, unnotched, 23°C 1602 J/m ASTM D 4812 Izod Impact, notched, 23°C 801 J/m ASTM D 256 Modified Gardner, 23°C 54 J ASTM D 256 Modified Gardner, 23°C 54 J ASTM D 3029 THERMAL Value Unit Standard HDT, 0.45 MPa, 6.4 mm, unannealed 115 °C ASTM D 648 HDT, 1.82 MPa, 6.4 mm, unannealed 86 °C ASTM D 648 HDT, 1.82 MPa, 6.4 mm, unannealed 86 °C ASTM D 648 ASTM D 648 ASTM D 649 Se-05 1/°C ASTM E 831 CTE, 60°C to 138°C, flow 1.44E-04 1/°C ASTM E 831 CTE, 60°C to 138°C, flow 1.44E-04 1/°C ASTM E 831 Relative Temp Index, Elec 120 °C UL 746B Relative Temp Index, Mech w/impact 115 °C UL 746B Relative Temp Index, Mech w/o impact 125 °C UL 746B PHYSICAL Value Unit Standard Specific Gravity 1.24 - ASTM D 792 Specific Gravity 1.24 - ASTM D 792 Specific Volume 0.8 cm³/g ASTM D 792 ASTM D 793 ASTM D 794 ASTM D 795	Hardness, Rockwell R	116	-	ASTM D 785
Izod Impact, notched, 23°C 801	IMPACT	Value	Unit	Standard
Modified Gardner, 23°C	Izod Impact, unnotched, 23°C	1602	J/m	ASTM D 4812
THERMAL Value Unit Standard HDT, 0.45 MPa, 6.4 mm, unannealed 115 °C ASTM D 648 HDT, 1.82 MPa, 6.4 mm, unannealed 86 °C ASTM D 648 CTE, -40°C to 40°C, flow 9.E-05 1/°C ASTM E 831 CTE, 60°C to 138°C, flow 1.44E-04 1/°C ASTM E 831 Relative Temp Index, Elec 120 °C UL 746B Relative Temp Index, Mech w/impact 115 °C UL 746B Relative Temp Index, Mech w/o impact 125 °C UL 746B PHYSICAL Value Unit Standard Specific Gravity 1.24 - ASTM D 792 Specific Volume 0.8 cm³/g ASTM D 792 Water Absorption, 24 hours 0.11 % ASTM D 792 Water Absorption, 24 hours 0.11 % ASTM D 792 Water Absorption, 24 hours 0.11 % ASTM D 792 Water Absorption, 24 hours 0.11 % ASTM D 792 Water Absorption, 25 hours 3.2 mm	Izod Impact, notched, 23°C	801	J/m	ASTM D 256
HDT, 0.45 MPa, 6.4 mm, unannealed	Modified Gardner, 23°C	54	J	ASTM D 3029
HDT, 1.82 MPa, 6.4 mm, unannealed	THERMAL	Value	Unit	Standard
CTT, -40°C to 40°C, flow 9.E-05 1/°C ASTM E 831 CTE, 60°C to 138°C, flow 1.44E-04 1/°C ASTM E 831 Relative Temp Index, Elec 120 °C UL 746B Relative Temp Index, Mech w/o impact 115 °C UL 746B Relative Temp Index, Mech w/o impact 125 °C UL 746B PHYSICAL Value Unit Standard Specific Gravity 1.24 - ASTM D 792 Specific Volume 0.8 cm³/g ASTM D 792 Water Absorption, 24 hours 0.11 % ASTM D 570 Mold Shrinkage, flow, 3.2 mm 1.2-1.5 % SABIC Method Mold Shrinkage, xflow, 3.2 mm 1.2-1.5 % SABIC Method Volume Resistivity 1.E+16 Ohm-cm ASTM D 257 Dielectric Strength, in air, 3.2 mm 17.5 kV/mm ASTM D 257 Dielectric Strength, in oil, 1.6 mm 22.6 kV/mm ASTM D 149 Relative Permittivity, 100 Hz 3.1 - ASTM D 150 Dissipation Facto	HDT, 0.45 MPa, 6.4 mm, unannealed	115	°C	ASTM D 648
CTE, 60°C to 138°C, flow 1.44E-04 1/°C ASTM E 831 Relative Temp Index, Elec 120 °C UL 746B Relative Temp Index, Mech w/impact 115 °C UL 746B Relative Temp Index, Mech w/o impact 125 °C UL 746B PHYSICAL Value Unit Standard Specific Gravity 1.24 - ASTM D 792 Specific Volume 0.8 cm³/g ASTM D 792 Water Absorption, 24 hours 0.11 % ASTM D 570 Mold Shrinkage, flow, 3.2 mm 1.2 - 1.5 % SABIC Method Mold Shrinkage, xflow, 3.2 mm 1.2 - 1.5 % SABIC Method ELECTRICAL Value Unit Standard Volume Resistivity 1.E+16 Ohm-cm ASTM D 257 Dielectric Strength, in air, 3.2 mm 17.5 kV/mm ASTM D 149 Dielectric Strength, in oil, 1.6 mm 22.6 kV/mm ASTM D 150 Relative Permittivity, 100 Hz 3.1 - ASTM D 150 Dissipation Factor, 100 Hz	HDT, 1.82 MPa, 6.4 mm, unannealed	86	°C	ASTM D 648
Relative Temp Index, Elec 120 °C UL 746B Relative Temp Index, Mech w/impact 115 °C UL 746B Relative Temp Index, Mech w/o impact 125 °C UL 746B PHYSICAL Value Unit Standard Specific Gravity 1.24 - ASTM D 792 Specific Volume 0.8 cm³/g ASTM D 792 Water Absorption, 24 hours 0.11 % ASTM D 570 Mold Shrinkage, flow, 3.2 mm 1.2 - 1.5 % SABIC Method Mold Shrinkage, xflow, 3.2 mm 1.2 - 1.5 % SABIC Method Mold Shrinkage, xflow, 3.2 mm 1.2 - 1.5 % SABIC Method Mold Shrinkage, xflow, 3.2 mm 1.2 - 1.5 % SABIC Method Mold Shrinkage, xflow, 3.2 mm 1.2 - 1.5 % SABIC Method Mold Shrinkage, xflow, 3.2 mm 1.2 - 1.5 % SABIC Method Mold Shrinkage, xflow, 3.2 mm 1.2 - 1.5 % SABIC Method Dielectric Strength, in air, 3.2 mm 1.2 - 1.5 KV/mm ASTM D 150	CTE, -40°C to 40°C, flow	9.E-05	1/°C	ASTM E 831
Relative Temp Index, Mech w/impact 115 °C UL 746B Relative Temp Index, Mech w/o impact 125 °C UL 746B PHYSICAL Value Unit Standard Specific Gravity 1.24 - ASTM D 792 Specific Volume 0.8 cm³/g ASTM D 792 Water Absorption, 24 hours 0.11 % ASTM D 570 Mold Shrinkage, flow, 3.2 mm 1.2 - 1.5 % SABIC Method Mold Shrinkage, xflow, 3.2 mm 1.2 - 1.5 % SABIC Method Wolume Resistivity 1.E+16 Ohm-cm ASTM D 257 Dielectric Strength, in air, 3.2 mm 17.5 kV/mm ASTM D 257 Dielectric Strength, in oil, 1.6 mm 22.6 kV/mm ASTM D 149 Relative Permittivity, 100 Hz 3.1 - ASTM D 150 Relative Permittivity, 1 MHz 3.1 - ASTM D 150 Dissipation Factor, 100 Hz 0.002 - ASTM D 150 Dissipation Factor, 1 MHz 0.02 - ASTM D 150	CTE, 60°C to 138°C, flow	1.44E-04	1/°C	ASTM E 831
Relative Temp Index, Mech w/o impact 125 °C UL 746B PHYSICAL Value Unit Standard Specific Gravity 1.24 - ASTM D 792 Specific Volume 0.8 cm³/g ASTM D 792 Water Absorption, 24 hours 0.11 % ASTM D 570 Mold Shrinkage, flow, 3.2 mm 1.2 - 1.5 % SABIC Method Mold Shrinkage, xflow, 3.2 mm 1.2 - 1.5 % SABIC Method Value Unit Standard Volume Resistivity 1.E+16 Ohm-cm ASTM D 257 Dielectric Strength, in air, 3.2 mm 17.5 kV/mm ASTM D 149 Dielectric Strength, in oil, 1.6 mm 22.6 kV/mm ASTM D 149 Relative Permittivity, 100 Hz 3.1 - ASTM D 150 Relative Permittivity, 1 MHz 3.1 - ASTM D 150 Dissipation Factor, 100 Hz 0.002 - ASTM D 150 Dissipation Factor, 1 MHz 0.02 - ASTM D 150 Arc Resistance, Tungsten {PLC} 5 <t< td=""><td>Relative Temp Index, Elec</td><td>120</td><td>°C</td><td>UL 746B</td></t<>	Relative Temp Index, Elec	120	°C	UL 746B
PHYSICAL Value Unit Standard Specific Gravity 1.24 - ASTM D 792 Specific Volume 0.8 cm³/g ASTM D 792 Water Absorption, 24 hours 0.11 % ASTM D 570 Mold Shrinkage, flow, 3.2 mm 1.2 - 1.5 % SABIC Method Mold Shrinkage, xflow, 3.2 mm 1.2 - 1.5 % SABIC Method ELECTRICAL Value Unit Standard Volume Resistivity 1.E+16 Ohm-cm ASTM D 257 Dielectric Strength, in air, 3.2 mm 17.5 kV/mm ASTM D 149 Dielectric Strength, in oil, 1.6 mm 22.6 kV/mm ASTM D 149 Dielectric Strength, in oil, 1.6 mm 22.6 kV/mm ASTM D 150 Relative Permittivity, 100 Hz 3.1 - ASTM D 150 Dissipation Factor, 100 Hz 0.002 - ASTM D 150 Dissipation Factor, 1 MHz 0.02 - ASTM D 150 Dissipation Factor, 1 MHz 0.02 - ASTM D 150 Arc Resistance, Tungsten {PLC} <td>Relative Temp Index, Mech w/impact</td> <td>115</td> <td>°C</td> <td>UL 746B</td>	Relative Temp Index, Mech w/impact	115	°C	UL 746B
Specific Gravity 1.24 - ASTM D 792 Specific Volume 0.8 cm³/g ASTM D 792 Water Absorption, 24 hours 0.11 % ASTM D 570 Mold Shrinkage, flow, 3.2 mm 1.2 - 1.5 % SABIC Method Mold Shrinkage, xflow, 3.2 mm 1.2 - 1.5 % SABIC Method ELECTRICAL Value Unit Standard Volume Resistivity 1.E+16 Ohm-cm ASTM D 257 Dielectric Strength, in air, 3.2 mm 17.5 kV/mm ASTM D 149 Dielectric Strength, in oil, 1.6 mm 22.6 kV/mm ASTM D 149 Relative Permittivity, 100 Hz 3.1 - ASTM D 150 Relative Permittivity, 1 MHz 3.1 - ASTM D 150 Dissipation Factor, 100 Hz 0.002 - ASTM D 150 Dissipation Factor, 1 MHz 0.002 - ASTM D 150 Arc Resistance, Tungsten (PLC) 5 PLC Code ASTM D 150 High Voltage Arc Track Rate {PLC} 2 PLC Code UL 746A High Ampere	Relative Temp Index, Mech w/o impact	125	°C	UL 746B
Specific Volume 0.8 cm³/g ASTM D 792 Water Absorption, 24 hours 0.11 % ASTM D 570 Mold Shrinkage, flow, 3.2 mm 1.2 - 1.5 % SABIC Method Mold Shrinkage, xflow, 3.2 mm 1.2 - 1.5 % SABIC Method ELECTRICAL Value Unit Standard Volume Resistivity 1.E+16 Ohm-cm ASTM D 257 Dielectric Strength, in air, 3.2 mm 17.5 kV/mm ASTM D 149 Dielectric Strength, in oil, 1.6 mm 22.6 kV/mm ASTM D 149 Relative Permittivity, 100 Hz 3.1 - ASTM D 150 Relative Permittivity, 1 MHz 3.1 - ASTM D 150 Dissipation Factor, 100 Hz 0.002 - ASTM D 150 Dissipation Factor, 1 MHz 0.02 - ASTM D 150 Arc Resistance, Tungsten {PLC} 5 PLC Code ASTM D 495 Hot Wire Ignition {PLC} 2 PLC Code UL 746A High Ampere Arc Ign, surface {PLC} 1 PLC Code UL 746A Hig	PHYSICAL	Value	Unit	Standard
Water Absorption, 24 hours 0.11 % ASTM D 570 Mold Shrinkage, flow, 3.2 mm 1.2 - 1.5 % SABIC Method Mold Shrinkage, xflow, 3.2 mm 1.2 - 1.5 % SABIC Method ELECTRICAL Value Unit Standard Volume Resistivity 1.E+16 Ohm-cm ASTM D 257 Dielectric Strength, in air, 3.2 mm 17.5 kV/mm ASTM D 149 Dielectric Strength, in oil, 1.6 mm 22.6 kV/mm ASTM D 149 Relative Permittivity, 100 Hz 3.1 - ASTM D 150 Relative Permittivity, 1 MHz 3.1 - ASTM D 150 Dissipation Factor, 100 Hz 0.002 - ASTM D 150 Dissipation Factor, 1 MHz 0.002 - ASTM D 150 Arc Resistance, Tungsten (PLC) 5 PLC Code ASTM D 495 Hot Wire Ignition (PLC) 2 PLC Code UL 746A High Ampere Arc Ign, surface {PLC} 1 PLC Code UL 746A High Ampere Arc Ign, surface {PLC} 2 PLC Code UL 746A <t< td=""><td>Specific Gravity</td><td>1.24</td><td>-</td><td>ASTM D 792</td></t<>	Specific Gravity	1.24	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm 1.2 - 1.5 % SABIC Method Mold Shrinkage, xflow, 3.2 mm 1.2 - 1.5 % SABIC Method ELECTRICAL Value Unit Standard Volume Resistivity 1.E+16 Ohm-cm ASTM D 257 Dielectric Strength, in air, 3.2 mm 17.5 kV/mm ASTM D 149 Dielectric Strength, in oil, 1.6 mm 22.6 kV/mm ASTM D 149 Relative Permittivity, 100 Hz 3.1 - ASTM D 150 Relative Permittivity, 1 MHz 3.1 - ASTM D 150 Dissipation Factor, 100 Hz 0.002 - ASTM D 150 Dissipation Factor, 1 MHz 0.02 - ASTM D 150 Arc Resistance, Tungsten {PLC} 5 PLC Code ASTM D 495 Hot Wire Ignition {PLC} 2 PLC Code UL 746A High Ampere Arc Ign, surface {PLC} 1 PLC Code UL 746A High Ampere Arc Ign, surface {PLC} 2 PLC Code UL 746A FLAME CHARACTERISTICS Value Unit Standard	Specific Volume	0.8	cm³/g	ASTM D 792
Mold Shrinkage, xflow, 3.2 mm 1.2 - 1.5 % SABIC Method ELECTRICAL Value Unit Standard Volume Resistivity 1.E+16 Ohm-cm ASTM D 257 Dielectric Strength, in air, 3.2 mm 17.5 kV/mm ASTM D 149 Dielectric Strength, in oil, 1.6 mm 22.6 kV/mm ASTM D 149 Relative Permittivity, 100 Hz 3.1 - ASTM D 150 Relative Permittivity, 1 MHz 3.1 - ASTM D 150 Dissipation Factor, 100 Hz 0.002 - ASTM D 150 Dissipation Factor, 1 MHz 0.02 - ASTM D 150 Arc Resistance, Tungsten {PLC} 5 PLC Code ASTM D 495 Hot Wire Ignition {PLC} 2 PLC Code UL 746A High Voltage Arc Track Rate {PLC} 2 PLC Code UL 746A High Ampere Arc Ign, surface {PLC} 1 PLC Code UL 746A Comparative Tracking Index (UL) {PLC} 2 PLC Code UL 746A FLAME CHARACTERISTICS Value Unit Standard	Water Absorption, 24 hours	0.11	%	ASTM D 570
ELECTRICAL Value Unit Standard Volume Resistivity 1.E+16 Ohm-cm ASTM D 257 Dielectric Strength, in air, 3.2 mm 17.5 kV/mm ASTM D 149 Dielectric Strength, in oil, 1.6 mm 22.6 kV/mm ASTM D 149 Relative Permittivity, 100 Hz 3.1 - ASTM D 150 Relative Permittivity, 1 MHz 3.1 - ASTM D 150 Dissipation Factor, 100 Hz 0.002 - ASTM D 150 Dissipation Factor, 1 MHz 0.02 - ASTM D 150 Arc Resistance, Tungsten {PLC} 5 PLC Code ASTM D 495 Hot Wire Ignition {PLC} 2 PLC Code UL 746A High Voltage Arc Track Rate {PLC} 2 PLC Code UL 746A High Ampere Arc Ign, surface {PLC} 1 PLC Code UL 746A Comparative Tracking Index (UL) {PLC} 2 PLC Code UL 746A FLAME CHARACTERISTICS Value Unit Standard	Mold Shrinkage, flow, 3.2 mm	1.2 - 1.5	%	SABIC Method
Volume Resistivity 1.E+16 Ohm-cm ASTM D 257 Dielectric Strength, in air, 3.2 mm 17.5 kV/mm ASTM D 149 Dielectric Strength, in oil, 1.6 mm 22.6 kV/mm ASTM D 149 Relative Permittivity, 100 Hz 3.1 - ASTM D 150 Relative Permittivity, 1 MHz 3.1 - ASTM D 150 Dissipation Factor, 100 Hz 0.002 - ASTM D 150 Dissipation Factor, 1 MHz 0.02 - ASTM D 150 Arc Resistance, Tungsten {PLC} 5 PLC Code ASTM D 495 Hot Wire Ignition {PLC} 2 PLC Code UL 746A High Voltage Arc Track Rate {PLC} 2 PLC Code UL 746A High Ampere Arc Ign, surface {PLC} 1 PLC Code UL 746A Comparative Tracking Index (UL) {PLC} 2 PLC Code UL 746A FLAME CHARACTERISTICS Value Unit Standard	Mold Shrinkage, xflow, 3.2 mm	1.2 - 1.5	%	SABIC Method
Dielectric Strength, in air, 3.2 mm Dielectric Strength, in oil, 1.6 mm 22.6 kV/mm ASTM D 149 Relative Permittivity, 100 Hz Relative Permittivity, 1 MHz 3.1 - ASTM D 150 Dissipation Factor, 100 Hz Dissipation Factor, 1 MHz Dissi	ELECTRICAL	Value	Unit	Standard
Dielectric Strength, in oil, 1.6 mm Relative Permittivity, 100 Hz Relative Permittivity, 1 MHz Relative Permittivity, 1 MHz Relative Permittivity, 1 MHz 3.1 ASTM D 150 Dissipation Factor, 100 Hz Dissipation Factor, 1 MHz 0.002 ASTM D 150 Dissipation Factor, 1 MHz 0.02 ASTM D 150 Arc Resistance, Tungsten {PLC} Function {PLC} PLC Code UL 746A High Voltage Arc Track Rate {PLC} High Ampere Arc Ign, surface {PLC} Comparative Tracking Index (UL) {PLC} PLC Code UL 746A Value Unit Standard	Volume Resistivity	1.E+16	Ohm-cm	ASTM D 257
Relative Permittivity, 100 Hz Relative Permittivity, 1 MHz 3.1 - ASTM D 150 Dissipation Factor, 100 Hz Dissipation Factor, 1 MHz Dissipation Factor, 100 Hz ASTM D 150 ASTM D 150 ASTM D 150 ASTM D 495 PLC Code DIC Code DIC 746A Dissipation Factor, 1 MHz Dissipation Factor, 100 Hz	Dielectric Strength, in air, 3.2 mm	17.5	kV/mm	ASTM D 149
Relative Permittivity, 1 MHz Dissipation Factor, 100 Hz Dissipation Factor, 1 MHz Dissipation Factor, 1 MHz Dissipation Factor, 1 MHz O.002 ASTM D 150 ASTM D 495 Hot Wire Ignition {PLC} PLC Code UL 746A High Voltage Arc Track Rate {PLC} High Ampere Arc Ign, surface {PLC} This is a comparative Tracking Index (UL) {PLC} ASTM D 150 ASTM D 1	Dielectric Strength, in oil, 1.6 mm	22.6	kV/mm	ASTM D 149
Dissipation Factor, 100 Hz Dissipation Factor, 1 MHz O.002 ASTM D 150 Arc Resistance, Tungsten {PLC} Hot Wire Ignition {PLC} High Voltage Arc Track Rate {PLC} High Ampere Arc Ign, surface {PLC} Comparative Tracking Index (UL) {PLC} PLC Code UL 746A	Relative Permittivity, 100 Hz	3.1	-	ASTM D 150
Dissipation Factor, 1 MHz 0.02 - ASTM D 150 Arc Resistance, Tungsten {PLC} 5 PLC Code ASTM D 495 Hot Wire Ignition {PLC} 2 PLC Code UL 746A High Voltage Arc Track Rate {PLC} 2 PLC Code UL 746A High Ampere Arc Ign, surface {PLC} 1 PLC Code UL 746A Comparative Tracking Index (UL) {PLC} 2 PLC Code UL 746A FLAME CHARACTERISTICS Value Unit Standard	Relative Permittivity, 1 MHz	3.1	-	ASTM D 150
Arc Resistance, Tungsten {PLC} Hot Wire Ignition {PLC} High Voltage Arc Track Rate {PLC} High Ampere Arc Ign, surface {PLC} Comparative Tracking Index (UL) {PLC} FLAME CHARACTERISTICS 5 PLC Code UL 746A UL 746A PLC Code UL 746A PLC Code UL 746A Value Unit Standard	Dissipation Factor, 100 Hz	0.002	-	ASTM D 150
Hot Wire Ignition {PLC} 2 PLC Code UL 746A High Voltage Arc Track Rate {PLC} 2 PLC Code UL 746A High Ampere Arc Ign, surface {PLC} 1 PLC Code UL 746A Comparative Tracking Index (UL) {PLC} 2 PLC Code UL 746A FLAME CHARACTERISTICS Value Unit Standard	Dissipation Factor, 1 MHz	0.02	-	ASTM D 150
High Voltage Arc Track Rate {PLC} High Ampere Arc Ign, surface {PLC} Comparative Tracking Index (UL) {PLC} FLAME CHARACTERISTICS 2 PLC Code UL 746A 2 PLC Code UL 746A Value Unit Standard	Arc Resistance, Tungsten {PLC}	5	PLC Code	ASTM D 495
High Ampere Arc Ign, surface {PLC} Comparative Tracking Index (UL) {PLC} FLAME CHARACTERISTICS 1 PLC Code UL 746A Value Unit Standard	Hot Wire Ignition (PLC)	2	PLC Code	UL 746A
Comparative Tracking Index (UL) {PLC} PLC Code UL 746A FLAME CHARACTERISTICS Value Unit Standard	High Voltage Arc Track Rate {PLC}	2	PLC Code	UL 746A
FLAME CHARACTERISTICS Value Unit Standard	High Ampere Arc Ign, surface {PLC}	1	PLC Code	UL 746A
	Comparative Tracking Index (UL) {PLC}	2	PLC Code	UL 746A
UL Recognized, 94HB Flame Class Rating (3) 1.47 mm UL 94	FLAME CHARACTERISTICS	Value	Unit	Standard
	UL Recognized, 94HB Flame Class Rating (3)	1.47	mm	UL 94

Parameter		
Injection Molding	Value	Unit
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

Source GMD, last updated:01/05/2000

THESE PROPERTY VALUES ARE NOT INTENDED FOR SPECIFICATION PURPOSES.

PLEASE CHECK WITH YOUR (LOCAL SALES OFFICE) FOR AVAILABILITY IN YOUR REGION

(1) Typical values only. Variations within normal tolerances are possible for various colors. All values are measured after at least 48 hours storage at 23°C/50% relative humidity. All properties, except the melt volume and melt flow rates, are measured on injection molded samples. All samples tested under ISO test standards are prepared according to ISO 294.

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- (2) Only typical data for selection purposes. 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) Internal measurements according to UL standards.

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