

XENOY™ 6620 resin

Polycarbonate + PBT

SABIC Innovative Plastics

Message:

PBT+PC, Unreinforced, impact modified thermoplastic alloy. Outstanding impact at low temperature

General Information	
UL YellowCard	E121562-221088
Additive	Impact Modifier
Features	Impact Modified
	Low Temperature Impact Resistance
Processing Method	Injection Molding
Multi-Point Data	Elastic Modulus vs Temperature (ASTM D4065)
	Flexural DMA (ASTM D4065)
	Instrumented Impact (Energy) (ASTM D3763)
	Instrumented Impact (Load) (ASTM D3763)
	Tensile Creep (ASTM D2990)
	Tensile Fatigue
	Tensile Stress vs. Strain (ASTM D638)

Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.20	g/cm ³	ASTM D792
Specific Volume	0.838	cm ³ /g	ASTM D792
Molding Shrinkage			Internal Method
Flow : 3.20 mm	1.6 to 1.8	%	
Across Flow : 3.20 mm	1.6 to 1.8	%	
Water Absorption (24 hr)	0.080	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	108		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield)	43.4	MPa	ASTM D638
Tensile Elongation ² (Break)	180	%	ASTM D638
Flexural Modulus ³ (50.0 mm Span)	1720	MPa	ASTM D790
Flexural Strength ⁴ (Yield, 50.0 mm Span)	64.1	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-30°C	670	J/m	
23°C	900	J/m	
Unnotched Izod Impact (23°C)	1600	J/m	ASTM D4812

Gardner Impact			ASTM D3029
23°C ⁵	54.2	J	
23°C	54.2	J	
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed, 3.20 mm	93.0	°C	
0.45 MPa, Unannealed, 6.40 mm	98.9	°C	
1.8 MPa, Unannealed, 3.20 mm	53.0	°C	
1.8 MPa, Unannealed, 6.40 mm	60.0	°C	
CLTE			ASTM E831
Flow : -40 to 40°C	9.4E-5	cm/cm/°C	
Flow : 60 to 138°C	1.0E-4	cm/cm/°C	
Transverse : -40 to 40°C	9.8E-5	cm/cm/°C	
RTI Elec	75.0	°C	UL 746
RTI Imp	75.0	°C	UL 746
RTI Str	75.0	°C	UL 746
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	5.5E+16	ohms · cm	ASTM D257
Dielectric Strength			ASTM D149
1.60 mm, in Oil	28	kV/mm	
3.20 mm, in Air	19	kV/mm	
3.20 mm, in Oil	19	kV/mm	
Dielectric Constant			ASTM D150
100 Hz	3.10		
100 kHz	3.00		
1 MHz	3.00		
Dissipation Factor			ASTM D150
100 Hz	2.0E-3		
100 kHz	0.020		
1 MHz	0.020		
Arc Resistance ⁶	PLC 5		ASTM D495
Comparative Tracking Index (CTI)	PLC 0		UL 746
High Amp Arc Ignition (HAI)	PLC 0		UL 746
High Voltage Arc Tracking Rate (HVTR)	PLC 1		UL 746
Hot-wire Ignition (HWI)	PLC 3		UL 746
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.47 mm)	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	104 to 116	°C	
Drying Time	2.0 to 4.0	hr	
Drying Time, Maximum	6.0	hr	
Suggested Max Moisture	0.020	%	

Suggested Shot Size	50 to 80	%
Rear Temperature	227 to 243	°C
Middle Temperature	232 to 249	°C
Front Temperature	238 to 260	°C
Nozzle Temperature	238 to 260	°C
Processing (Melt) Temp	238 to 260	°C
Mold Temperature	48.9 to 82.2	°C
Back Pressure	0.172 to 0.345	MPa
Vent Depth	0.013 to 0.020	mm

NOTE

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|----|--------------------|
| 1. | Type I, 50 mm/min |
| 2. | Type I, 50 mm/min |
| 3. | 1.3 mm/min |
| 4. | 1.3 mm/min |
| 5. | Modified |
| 6. | Tungsten Electrode |

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