



**XENOY™ Resin 6370**  
**Americas: COMMERCIAL**

30% glass-reinforced, impact modified thermoplastic alloy. Improved toughness and ductility.

| TYPICAL PROPERTIES <sup>1</sup>              | TYPICAL VALUE | Unit                | Standard    |
|--|---------------|---------------------|-------------|
| <b>MECHANICAL</b>                            |               |                     |             |
| Tensile Stress, yld, Type I, 5 mm/min        | 980           | kgf/cm <sup>2</sup> | ASTM D 638  |
| Tensile Stress, brk, Type I, 5 mm/min        | 920           | kgf/cm <sup>2</sup> | ASTM D 638  |
| Tensile Strain, yld, Type I, 5 mm/min        | 3             | %                   | ASTM D 638  |
| Tensile Strain, brk, Type I, 5 mm/min        | 4             | %                   | ASTM D 638  |
| Tensile Modulus, 5 mm/min                    | 99400         | kgf/cm <sup>2</sup> | ASTM D 638  |
| Flexural Stress, yld, 1.3 mm/min, 50 mm span | 1520          | kgf/cm <sup>2</sup> | ASTM D 790  |
| Flexural Stress, brk, 1.3 mm/min, 50 mm span | 1400          | kgf/cm <sup>2</sup> | ASTM D 790  |
| Flexural Modulus, 1.3 mm/min, 50 mm span     | 54800         | kgf/cm <sup>2</sup> | ASTM D 790  |
| Hardness, Rockwell R                         | 109           | -                   | ASTM D 785  |
| Tensile Stress, yield, 5 mm/min              | 105           | MPa                 | ISO 527     |
| Tensile Stress, break, 5 mm/min              | 3             | MPa                 | ISO 527     |
| Tensile Strain, yield, 5 mm/min              | 3             | %                   | ISO 527     |
| Tensile Strain, break, 5 mm/min              | 105           | %                   | ISO 527     |
| Tensile Modulus, 1 mm/min                    | 8500          | MPa                 | ISO 527     |
| Flexural Stress, yield, 2 mm/min             | 154           | MPa                 | ISO 178     |
| Flexural Modulus, 2 mm/min                   | 7750          | MPa                 | ISO 178     |
| <b>IMPACT</b>                                |               |                     |             |
| Izod Impact, unnotched, 23°C                 | 65            | cm-kgf/cm           | ASTM D 4812 |
| Izod Impact, notched, 23°C                   | 17            | cm-kgf/cm           | ASTM D 256  |
| Izod Impact, notched, -30°C                  | 11            | cm-kgf/cm           | ASTM D 256  |
| Instrumented Impact Energy @ peak, 23°C      | 50            | cm-kgf              | ASTM D 3763 |
| Instrumented Impact Total Energy, 23°C       | 173           | cm-kgf              | ASTM D 3763 |

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 (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>IMPACT</b>                              |               |                    |              |
| 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         | 6             | kJ/m <sup>2</sup>  | ISO 180/1A   |
| Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm | 9             | kJ/m <sup>2</sup>  | ISO 179/1eA  |
| <b>THERMAL</b>                             |               |                    |              |
| Vicat Softening Temp, Rate B/50            | 153           | °C                 | ASTM D 1525  |
| HDT, 1.82 MPa, 3.2mm, unannealed           | 163           | °C                 | ASTM D 648   |
| HDT, 0.45 MPa, 6.4 mm, unannealed          | 204           | °C                 | ASTM D 648   |
| HDT, 1.82 MPa, 6.4 mm, unannealed          | 149           | °C                 | ASTM D 648   |
| CTE, -40°C to 40°C, flow                   | 2.7E-05       | 1/°C               | ASTM E 831   |
| CTE, -40°C to 40°C, xflow                  | 1.1E-04       | 1/°C               | ASTM E 831   |
| CTE, 60°C to 138°C, flow                   | 1.98E-05      | 1/°C               | ASTM E 831   |
| CTE, -40°C to 40°C, flow                   | 2.7E-05       | 1/°C               | ISO 11359-2  |
| CTE, -40°C to 40°C, xflow                  | 1.1E-04       | 1/°C               | ISO 11359-2  |
| Vicat Softening Temp, Rate B/50            | 148           | °C                 | ISO 306      |
| Vicat Softening Temp, Rate B/120           | 150           | °C                 | ISO 306      |
| HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm      | 155           | °C                 | ISO 75/Af    |
| Relative Temp Index, Elec                  | 140           | °C                 | UL 746B      |
| Relative Temp Index, Mech w/impact         | 130           | °C                 | UL 746B      |
| Relative Temp Index, Mech w/o impact       | 140           | °C                 | UL 746B      |
| <b>PHYSICAL</b>                            |               |                    |              |
| Specific Gravity                           | 1.44          | -                  | ASTM D 792   |
| Specific Volume                            | 0.7           | cm <sup>3</sup> /g | ASTM D 792   |
| Water Absorption, 24 hours                 | 0.09          | %                  | ASTM D 570   |
| Mold Shrinkage, flow, 0.75-2.3 mm (5)      | 0.3 - 0.4     | %                  | SABIC Method |
| Mold Shrinkage, flow, 2.3-4.6 mm (5)       | 0.4 - 0.5     | %                  | SABIC Method |

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| <b>PHYSICAL</b>                            |               |                         |              |
| Mold Shrinkage, xflow, 0.75-2.3 mm (5)     | 0.4 - 0.7     | %                       | SABIC Method |
| Mold Shrinkage, xflow, 2.3-4.6 mm (5)      | 0.7 - 0.9     | %                       | SABIC Method |
| Melt Flow Rate, 250°C/5.0 kgf              | 24            | g/10 min                | ASTM D 1238  |
| Density                                    | 1.44          | g/cm <sup>3</sup>       | ISO 1183     |
| Water Absorption, (23°C/sat)               | 0.5           | %                       | ISO 62       |
| Moisture Absorption (23°C / 50% RH)        | 0.15          | %                       | ISO 62       |
| Melt Volume Rate, MVR at 250°C/5.0 kg      | 12            | cm <sup>3</sup> /10 min | ISO 1133     |
| Melt Volume Rate, MVR at 265°C/5.0 kg      | 19            | cm <sup>3</sup> /10 min | ISO 1133     |
| <b>ELECTRICAL</b>                          |               |                         |              |
| Volume Resistivity                         | 4.8E+15       | Ohm-cm                  | ASTM D 257   |
| Dielectric Strength, in air, 3.2 mm        | 20            | kV/mm                   | ASTM D 149   |
| Dielectric Strength, in oil, 1.6 mm        | 27            | kV/mm                   | ASTM D 149   |
| Relative Permittivity, 100 Hz              | 4             | -                       | ASTM D 150   |
| Relative Permittivity, 1 MHz               | 4             | -                       | ASTM D 150   |
| Dissipation Factor, 100 Hz                 | 0.003         | -                       | 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}                    | 1             | PLC Code                | UL 746A      |
| High Voltage Arc Track Rate {PLC}          | 1             | PLC Code                | UL 746A      |
| High Ampere Arc Ign, surface {PLC}         | 3             | PLC Code                | UL 746A      |
| Comparative Tracking Index (UL) {PLC}      | 2             | PLC Code                | UL 746A      |
| <b>FLAME CHARACTERISTICS</b>               |               |                         |              |
| UL Recognized, 94HB Flame Class Rating (3) | 1.5           | mm                      | UL 94        |

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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 - 280     | °C   |
| Nozzle Temperature          | 255 - 275     | °C   |
| Front - Zone 3 Temperature  | 260 - 280     | °C   |
| Middle - Zone 2 Temperature | 255 - 275     | °C   |
| Rear - Zone 1 Temperature   | 250 - 270     | °C   |
| Mold Temperature            | 65 - 95       | °C   |
| Back Pressure               | 0.3 - 0.6     | MPa  |
| Screw Speed                 | 50 - 80       | rpm  |
| Shot to Cylinder Size       | 50 - 80       | %    |
| Vent Depth                  | 0.013 - 0.02  | mm   |

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