

XR419

Description

XR419 has improved chemical resistance for painted exterior parts

Key Features

High Heat Resistance, Non Painting, Chemical Resistance

Properties	Condition	Method	Unit	XR419
Physical				
Specific Gravity	23°C	ASTM D792		1.06
Mold Shrinkage	23°C, 3.2mm	ASTM D955	%	0.4 ~ 0.7
Melt Flow Index	220°C, 10kg	ASTM D1238	g/10min	5
Mechanical				
Tensile Strength at Yield	23°C, 50mm/min, 3.2mm	ASTM D638	MPa	47
Tensile Elongation at Break	23°C, 50mm/min, 3.2mm	ASTM D638	%, (Min)	15
Tensile Modulus	23°C, 50mm/min, 3.2mm	ASTM D638	MPa	2100
Flexural Strength	23°C, 15mm/min, 3.2mm	ASTM D790	MPa	72
Flexural Modulus	23°C, 15mm/min, 3.2mm	ASTM D790	MPa	2250
Izod Impact Strength	Notched, 3.2mm, 23°C	ASTM D256	J/m	240
Izod Impact Strength	Notched, 3.2mm, -30°C	ASTM D256	J/m	100
Izod Impact Strength	Notched, 6.4mm, 23°C	ASTM D256	J/m	220
Izod Impact Strength	Notched, 6.4mm, -30°C	ASTM D256	J/m	90
Rockwell Hardness	R-Scale	ASTM D785		106
Thermal				
Heat Deflection Temperature	Edgewise, 1.82MPa, 6.4mm, Unannealed	ASTM D648	°C	102
Heat Deflection Temperature	Edgewise, 0.46MPa, 6.4mm, Unannealed	ASTM D648	°C	106
Heat Deflection Temperature	Edgewise, 1.82MPa, 6.4mm, Annealed	ASTM D648	°C	104
Heat Deflection Temperature	Edgewise, 0.46MPa, 6.4mm, Annealed	ASTM D648	°C	109
Vicat Softening Temperature	50N, 50°C/h	ASTM D1525	°C	106

Note

Typical values can be used only for the purpose of selecting material, and there can be variation within normal tolerances for various colors.

Values given should not be interpreted as specification and not be used for designing part or tool.

All properties, except melt flow index are measured by injection molded specimens after 48 hours storage at 23°C, 50% relative humidity.

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WeConnectScience



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High Heat Resistance, Non Painting, Chemical Resistance

Processing Guide (Injection Molding)

Processing Parameters	Unit	Value
Drying Temperature	°C	80 ~ 90
Drying Time	hrs	3 ~ 4
Injection Temperature	°C	230 ~ 270
Mold Temperature	°C	40 ~ 80
Screw Speed	rpm	30 ~ 60

Note

Injection Temperature & Screw Speed are only mentioned as general guidelines.

These may not apply or need adjustment in specific situations such as low shot sizes, thin wall molding and gas-assist molding.

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