

Xylex * Resin EXXY0008

Americas: DEVELOPMENTAL

PRELIMINARY DATA. Opaque PC+polyester alloy. High flow, chemical resistant/good mechanical properties. UV-stabilized. Exc weatherability.

Property

TYPICAL PROPERTIES ⁽¹⁾			
MECHANICAL	Value	Unit	Standard
Tensile Stress, yld, Type I, 50 mm/min	39	MPa	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	39	MPa	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	5	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	150	%	ASTM D 638
Tensile Modulus, 50 mm/min	1310	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	52	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	1440	MPa	ASTM D 790
IMPACT	Value	Unit	Standard
Izod Impact, notched, 23°C	854	J/m	ASTM D 256
Instrumented Impact Total Energy, 23°C	85	J	ASTM D 3763
THERMAL	Value	Unit	Standard
HDT, 0.45 MPa, 3.2 mm, unannealed	60	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	57	°C	ASTM D 648
PHYSICAL	Value	Unit	Standard
Specific Gravity	1.1	-	ASTM D 792
Melt Flow Rate, 266°C/5.0 kgf	32	g/10 min	ASTM D 1238

Source GMD, last updated:03/01/2002

Processing

Parameter	Value	Unit
Injection Molding		
Drying Temperature	30 - 50	°C
Drying Time	3 - 5	hrs
Drying Time (Cumulative)	7	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	230 - 265	°C
Nozzle Temperature	230 - 265	°C
Front - Zone 3 Temperature	230 - 265	°C
Middle - Zone 2 Temperature	240 - 260	°C
Rear - Zone 1 Temperature	240 - 250	°C
Mold Temperature	25 - 55	°C
Back Pressure	0.2 - 0.5	MPa
Screw Speed	20 - 100	rpm
Shot to Cylinder Size	40 - 80	%
Vent Depth	0.013 - 0.02	mm

Source GMD, last updated:03/01/2002

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.

(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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