XENOY™ RESIN X5230

REGION EUROPE

DESCRIPTION

Mineral filled PC/PET blend with high flow, high heat, dimensional stability, low shrinkage and low CTE, especially for painted applications

TYPICAL PROPERTY VALUES

Revision 20190925

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yield, 5 mm/min	58	MPa	ISO 527
Tensile Stress, break, 5 mm/min	42	MPa	ISO 527
Tensile Strain, yield, 5 mm/min	3.6	%	ISO 527
Tensile Strain, break, 5 mm/min	9	%	ISO 527
Tensile Modulus, 1 mm/min	3850	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	95	MPa	ISO 178
Flexural Modulus, 2 mm/min	3750	MPa	ISO 178
IMPACT			
Izod Impact, unnotched 80*10*4 +23°C	137	kJ/m²	ISO 180/1U
Izod Impact, unnotched 80*10*4 -30°C	120	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	10	kJ/m²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	7	kJ/m²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	10	kJ/m²	ISO 179/1eA
THERMAL			
CTE, -30°C to 80°C, flow	5.4E-05	1/°C	ISO 11359-2
CTE, -30°C to 80°C, xflow	7.4E-05	1/°C	ISO 11359-2
Vicat Softening Temp, Rate B/50	137	°C	ISO 306
Vicat Softening Temp, Rate B/120	140	°C	ISO 306
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	109	°C	ISO 75/Af
PHYSICAL			
Mold Shrinkage on Tensile Bar, flow	0.5 – 0.7	%	SABIC method
Melt Flow Rate, 265°C/5.0 kgf	28	g/10 min	ASTM D 1238
Density	1.33	g/cm³	ISO 1183
Water Absorption, (23°C/sat)	0.42	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.14	%	ISO 62
Melt Volume Rate, MVR at 265°C/5.0 kg	24	cm³/10 min	ISO 1133
INJECTION MOLDING			
Drying Temperature	110 – 120	°C	
Drying Time	4 – 6	hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	265 – 275	°C	
Nozzle Temperature	260 – 275	°C	
Front - Zone 3 Temperature	260 – 280	°C	
Middle - Zone 2 Temperature	250 – 275	°C	

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Rear - Zone 1 Temperature	240 – 270	°C	
Hopper Temperature	60 – 80	°C	
Mold Temperature	60 – 100	°C	

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