XYLEX™ RESIN X8409AC

REGION ASIA

DESCRIPTION

PC + Polyester, Injection (Blow) Molding, or Extrusion Blow molding grade, Chemical Resistance and Transparency

TYPICAL PROPERTY VALUES

Revision 20190925

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	57	MPa	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	55	MPa	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	6	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	92	%	ASTM D 638
Tensile Modulus, 50 mm/min	2370	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	94	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	2220	MPa	ASTM D 790
Tensile Stress, yield, 50 mm/min	60	MPa	ISO 527
Tensile Stress, break, 50 mm/min	60	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	5.8	%	ISO 527
Tensile Strain, break, 50 mm/min	117	%	ISO 527
Tensile Modulus, 1 mm/min	2180	MPa	ISO 527
Flexural Stress, break, 2 mm/min	89	MPa	ISO 178
Flexural Modulus, 2 mm/min	2000	MPa	ISO 178
IMPACT			
Izod Impact, notched, 23°C	854	J/m	ASTM D 256
Izod Impact, notched, -30°C	200	J/m	ASTM D 256
Instrumented Impact Total Energy, 23°C	70	J	ASTM D 3763
Izod Impact, notched 80*10*4 +23°C	10	kJ/m²	ISO 180/1A
Izod Impact, notched 80*10*4 -10°C	8	kJ/m²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	8	kJ/m²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	8	kJ/m²	ISO 179/1eA
THERMAL			
Vicat Softening Temp, Rate B/50	123	°C	ASTM D 1525
HDT, 0.45 MPa, 3.2 mm, unannealed	116	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	104	°C	ASTM D 648
CTE, -40°C to 40°C, flow	1.04E-04	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	1.04E-04	1/°C	ASTM E 831
Thermal Conductivity	0.23	W/m-°C	ISO 8302
CTE, -40°C to 40°C, flow	1.04E-04	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	1.04E-04	1/°C	ISO 11359-2
CTE, 23°C to 60°C, flow	6.E-05	1/°C	ISO 11359-2
CTE, 23°C to 60°C, xflow	7.E-05	1/°C	ISO 11359-2
Vicat Softening Temp, Rate B/50	121	°C	ISO 306
Vicat Softening Temp, Rate B/120	123	°C	ISO 306

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm	102	°C	ISO 75/Ae
PHYSICAL			
Specific Gravity	1.2	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	0.5 – 0.8	%	SABIC method
Mold Shrinkage, xflow, 3.2 mm	0.5 – 0.8	%	SABIC method
Melt Flow Rate, 265°C/2.16kgf	4	g/10 min	ASTM D 1238
Density	1.2	g/cm³	ISO 1183
Water Absorption, (23°C/sat)	0.37	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.13	%	ISO 62
Melt Volume Rate, MVR at 265°C/2.16 kg	3	cm³/10 min	ISO 1133
OPTICAL			
Light Transmission, 2.54 mm	88	%	ASTM D 1003
Haze, 2.54 mm	1.5	%	ASTM D 1003
Refractive Index	1.576	-	ASTM D542
FLAME CHARACTERISTICS			
UL Yellow Card Link	E207780-638046	-	-
EXTRUSION BLOW MOLDING			
Drying Temperature	75 – 90	°C	
Drying Time	4 – 6	hrs	
Drying Time (Cumulative)	24	hrs	
Maximum Moisture Content	0.01 – 0.02	%	
Melt Temperature (Parison)	250 – 270	°C	
Barrel - Zone 1 Temperature	235 – 260	°C	
Barrel - Zone 2 Temperature	235 – 260	°C	
Barrel - Zone 3 Temperature	235 – 260	°C	
Barrel - Zone 4 Temperature	235 – 260	°C	
Adapter - Zone 5 Temperature	235 – 260	°C	
Head - Zone 6 - Top Temperature	240 – 270	°C	
Head - Zone 7 - Middle Temperature	240 – 270	°C	
Head - Zone 7 - Bottom Temperature	240 – 270	°C	
Mold Temperature	30 – 75	°C	

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