



XENOY™ 1102 resin

General Information		
Product Description		
Unreinforced PC/polyester alloy. Excellent low temperature impact/chemical resistance to automotive fluids.		
General		
Features	• Good Chemical Resistance • Low Temperature Impact Resistance	
Uses	• Automotive Applications	
Processing Method	• Injection Molding	
Multi-Point Data	• Coefficient of Thermal Expansion vs. Temperature (ASTM E831) • Compressive Stress vs. Strain (ASTM D695) • Elastic Modulus vs Temperature (ASTM D4065) • Flexural DMA (ASTM D4065) • Instrumented Impact (Energy) (ASTM D3763) • Instrumented Impact (Load) (ASTM D3763) • Pressure-Volume-Temperature (PVT - Zoller Method) • Shear DMA (ASTM D4065) • Specific Heat vs. Temperature (ASTM D3417) • Tensile Creep (ASTM D2990) • Tensile Fatigue • Tensile Stress vs. Strain (ASTM D638) • Thermal Conductivity vs. Temperature (ASTM E1530) • Viscosity vs. Shear Rate (ASTM D3835)	

ASTM and ISO Properties ¹			
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.20		ASTM D792
Specific Volume	23.1	in ³ /lb	ASTM D792
Molding Shrinkage - Flow (0.126 in)	8.0E-3 to 0.010	in/in	Internal Method
Molding Shrinkage - Across Flow (0.126 in)	8.0E-3 to 0.010	in/in	Internal Method
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ² (Yield)	7900	psi	ASTM D638
Tensile Elongation ² (Break)	150	%	ASTM D638
Flexural Modulus ³ (1.97 in Span)	285000	psi	ASTM D790
Flexural Strength ³ (Yield, 1.97 in Span)	11900	psi	ASTM D790



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SABIC Innovative Plastics - Polycarbonate + PBT

Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-22°F	12	ft-lb/in	
32°F	13	ft-lb/in	
73°F	15	ft-lb/in	
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
66 psi, Unannealed, 0.252 in	230	°F	
Deflection Temperature Under Load			ASTM D648
264 psi, Unannealed, 0.252 in	195	°F	
Processing Information			
Injection	Nominal Value	Unit	
Drying Temperature	230	°F	
Drying Time	4.0 to 6.0	hr	
Drying Time, Maximum	8.0	hr	
Suggested Max Moisture	0.020	%	
Suggested Shot Size	50 to 80	%	
Rear Temperature	470 to 510	°F	
Middle Temperature	480 to 520	°F	
Front Temperature	490 to 530	°F	
Nozzle Temperature	490 to 520	°F	
Processing (Melt) Temp	500 to 530	°F	
Mold Temperature	150 to 190	°F	
Back Pressure	50.0 to 100	psi	
Screw Speed	50 to 80	rpm	
Vent Depth	5.0E-4 to 8.0E-4	in	

