



Xenoy* Resin 1102

Americas: COMMERCIAL

Unreinforced PC/polyester alloy. Excellent low temperatue impact/chemical resistance to automotive fluids.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	54	MPa	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	150	%	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	82	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	1960	MPa	ASTM D 790
IMPACT			
Izod Impact, notched, 23°C	801	J/m	ASTM D 256
Izod Impact, notched, 0°C	694	J/m	ASTM D 256
Izod Impact, notched, -30°C	640	J/m	ASTM D 256
THERMAL			
HDT, 0.45 MPa, 6.4 mm, unannealed	110	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	90	°C	ASTM D 648
PHYSICAL			
Specific Gravity	1.2	-	ASTM D 792
Specific Volume	0.83	cm ³ /g	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	0.8 - 1	%	SABIC Method
Mold Shrinkage, xflow, 3.2 mm	0.8 - 1	%	SABIC Method

1) Typical values only. Variations within normal tolerances are possible for variose colours. All values are measured at least after 48 hours storage at 230C/50% relative humidity.
All properties, except the melt volume rate are measured on injection moulded samples.
All samples are prepared according to ISO 294.

2) Only typical data for material selection purpose. Not to be used for part or tool design.
3) This rating is not intended to reflect hazards presented this or any other material under actual fire conditions.
4) Own measurement according to UL.





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PROCESSING PARAMETERS	TYPICAL VALUE	UNIT
Injection Molding		
Drying Temperature	110	°C
Drying Time	4 - 6	hrs
Drying Time (Cumulative)	8	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	260 - 275	°C
Nozzle Temperature	255 - 270	°C
Front - Zone 3 Temperature	255 - 275	°C
Middle - Zone 2 Temperature	250 - 270	°C
Rear - Zone 1 Temperature	245 - 265	°C
Mold Temperature	65 - 90	°C
Back Pressure	0.3 - 0.7	MPa
Screw Speed	50 - 80	rpm
Shot to Cylinder Size	50 - 80	%
Vent Depth	0.013 - 0.02	mm

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