SABIC Innovative Plastics™

sabic

Xenoy* Resin 1402B

Americas: COMMERCIAL

Blowmoldable, unreinforced PC/polyester alloy. Characterized by high melt viscosity/strength with excellent low temperature impact.

TYPICAL PROPERTIES [1]	TYPICAL VALUE	UNIT	STANDARD
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	48	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	68	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	1990	MPa	ASTM D 790
IMPACT			
Izod Impact, notched, 23°C	694	J/m	ASTM D 256
Izod Impact, notched, -30°C	534	J/m	ASTM D 256
Modified Gardner, 23°C	44	J	ASTM D 3029
THERMAL			
HDT, 1.82 MPa, 6.4 mm, unannealed	96	°C	ASTM D 648
PHYSICAL			
Specific Gravity	1.19	-	ASTM D 792
Specific Volume	0.84	cm^3/g	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	0.9 - 1.1	%	SABIC Method
Mold Shrinkage on Tensile Bar, xflow (2)	0.9 - 1.1	%	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, expect 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
Extrusion Blow Molding		
Drying Temperature	95 - 100	°C
Drying Time	4 - 6	hrs
Drying Time (Cumulative)	24	hrs
Maximum Moisture Content	0.01 - 0.02	%
Minimum Moisture Content	0.02	%
Melt Temperature (Parison)	240 - 250	°C
Barrel - Zone 1 Temperature	235 - 245	°C
Barrel - Zone 2 Temperature	235 - 245	°C
Barrel - Zone 3 Temperature	235 - 245	°C
Barrel - Zone 4 Temperature	235 - 245	°C
Adapter - Zone 5 Temperature	235 - 245	°C
Head - Zone 6 - Top Temperature	235 - 245	°C
Head - Zone 7 - Bottom Temperature	235 - 245	°C
Mold Temperature	65 - 90	°C
Die Temperature	240 - 250	°C

• Purge with HDPE prior to changing screw, head, or die tooling and/or machine shutdown.
• Use moderate-slow screw speeds to keep melt temperature in suggested range. Suggested screw speed: 15 - 50 rpm. Actual rpm should be adjusted for desired output.
• Processing temperature must be measured with a hand-held probe as opposed to an internal-head probe.
• A reverse barrel profile may increase output while maintaining the melt temperature.

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