XENOY® *2230EU*

Americas: COMMERCIAL

Unreinforced, opaque PC+PET alloy. Chemical resistance, dimensional stabil- ity and mechanical performance. UV stabilized/easy flow version of 2230.

TYPICAL PROPERTIES [1]	TYPICAL VALUE	UNIT	STANDARD
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	55	MPa	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	120	%	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	86	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	2240	MPa	ASTM D 790
Hardness, Rockwell R	115	-	ASTM D 785
IMPACT			
Izod Impact, notched, 23°C	801	J/m	ASTM D 256
Gardner, 23°C	54	J	ASTM D 3029
THERMAL			
HDT, 0.45 MPa, 6.4 mm, unannealed	129	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	121	°C	ASTM D 648
CTE, -40°C to 40°C, flow	5.4E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	6.12E-05	1/°C	ASTM E 831
Relative Temp Index, Elec	75	°C	UL 746B
Relative Temp Index, Mech w/impact	75	°C	UL 746B
Relative Temp Index, Mech w/o impact	75	°C	UL 746B
PHYSICAL			
Specific Gravity	1.22	-	ASTM D 792
Specific Volume	0.82	cm^3/g	ASTM D 792
Water Absorption, 24 hours	0.14	%	ASTM D 570
Water Absorption, equilibrium, 23C	0.6	%	ASTM D 570
Mold Shrinkage, flow, 3.2 mm	0.6 - 0.9	%	GE Method
Mold Shrinkage on Tensile Bar, xflow (2)	0.6 - 0.9	%	GE Method
ELECTRICAL			
Volume Resistivity	2.1E+16	Ohm-cm	ASTM D 257
Dielectric Strength, in air, 3.2 mm	21.3	kV/mm	ASTM D 149
Relative Permittivity, 100 Hz	3.6	-	ASTM D 150
Relative Permittivity, 1 MHz	3.2	-	ASTM D 150
Dissipation Factor, 100 Hz	0.002	-	ASTM D 150
Dissipation Factor, 1 MHz	0.005	-	ASTM D 150

1) Typical values only. Variations within normal tolerances are possible for variose colours.All values are measured at least after 48 hours storage at 23°C/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 by this or any other material under actual fire conditions.
4) Own measurement according to UL.

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TYPICAL PROPERTIES [1]	TYPICAL VALUE	UNIT	STANDARD
FLAME CHARACTERISTICS			
UL Recognized, 94HB Flame Class Rating (3)	0.8	mm	UL 94
UV-light, water exposure/immersion	F1	-	UL 746C

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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 - 280	°C
Nozzle Temperature	255 - 275	°C
Front - Zone 3 Temperature	260 - 280	°C
Middle - Zone 2 Temperature	255 - 275	°C
Rear - Zone 1 Temperature	250 - 270	°C
Mold Temperature	65 - 95	°C
Back Pressure	0.3 - 0.6	MPa
Screw Speed	50 - 80	rpm
Shot to Cylinder Size	50 - 80	%
Vent Depth	0.013 - 0.02	mm

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