



Xenoy* Resin X4850

Americas: COMMERCIAL

Xenoy X4850 is a hydrostable, high modulus, high ductile PC/PBT blend. Furthermore, this resin provides high chemical resistance, very low creep, low CTE, excellent fatigue and high heat dimensional stability. The X4850 could be positioned for body panels, safety equipment, housings, door handles, spring-loaded applications, medical device enclosures, outdoor sports equipment.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	65	MPa	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	55	MPa	ASTM D 638
Tensile Stress, yld, Type I, 5 mm/min	58	MPa	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	60	MPa	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	3.7	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	130	%	ASTM D 638
Tensile Strain, yld, Type I, 5 mm/min	3.8	%	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	140	%	ASTM D 638
Tensile Modulus, 5 mm/min	4000	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	99	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	3700	MPa	ASTM D 790
Taber Abrasion, CS-17, 1 kg	30	mg/1000cy	SABIC Method
Tensile Stress, yield, 5 mm/min	58	MPa	ISO 527
Tensile Stress, break, 5 mm/min	50	MPa	ISO 527
Tensile Stress, yield, 50 mm/min	63	MPa	ISO 527
Tensile Stress, break, 50 mm/min	45	MPa	ISO 527
Tensile Strain, yield, 5 mm/min	3.4	%	ISO 527
Tensile Strain, break, 5 mm/min	80	%	ISO 527
Tensile Strain, yield, 50 mm/min	3.5	%	ISO 527
Tensile Strain, break, 50 mm/min	30	%	ISO 527
Tensile Modulus, 1 mm/min	3850	MPa	ISO 527

1) Typical values only. Variations within normal tolerances are possible for various colours. All values are measured at least after 48 hours storage at 23°C/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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TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
MECHANICAL			
Flexural Stress, yield, 2 mm/min	94	MPa	ISO 178
Flexural Modulus, 2 mm/min	3500	MPa	ISO 178
Hardness, H358/30	105	MPa	ISO 2039-1
IMPACT			
Izod Impact, notched, 23°C	180	J/m	ASTM D 256
Izod Impact, notched, 0°C	120	J/m	ASTM D 256
Izod Impact, notched, -30°C	100	J/m	ASTM D 256
Multiaxial Impact	100	J	ISO 6603
Instrumented Impact Total Energy, 23°C	60	J	ASTM D 3763
Instrumented Impact Total Energy, -20°C	60	J	ASTM D 3763
Izod Impact, unnotched 80*10*4 +23°C	NB	kJ/m ²	ISO 180/1U
Izod Impact, unnotched 80*10*4 -30°C	NB	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	20	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*4 0°C	11	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	7	kJ/m ²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	20	kJ/m ²	ISO 179/1eA
Charpy -30°C, V-notch Edgew 80*10*4 sp=62mm	11	kJ/m ²	ISO 179/1eA
Charpy 23°C, Unnotch Edgew 80*10*4 sp=62mm	NB	kJ/m ²	ISO 179/1eU
Charpy -30°C, Unnotch Edgew 80*10*4 sp=62mm	NB	kJ/m ²	ISO 179/1eU
THERMAL			
Vicat Softening Temp, Rate B/50	134	°C	ASTM D 1525
HDT, 0.45 MPa, 3.2 mm, unannealed	125	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	101	°C	ASTM D 648
CTE, -40°C to 40°C, flow	5.2E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	7.5E-05	1/°C	ASTM E 831

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THERMAL			
Thermal Conductivity	0.2	W/m-°C	ISO 8302
CTE, -30°C to 80°C, flow	6.3E-05	1/°C	ISO 11359-2
CTE, -30°C to 80°C, xflow	8.1E-05	1/°C	ISO 11359-2
Vicat Softening Temp, Rate B/50	133	°C	ISO 306
Vicat Softening Temp, Rate B/120	135	°C	ISO 306
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	121	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	99	°C	ISO 75/Af
PHYSICAL			
Specific Gravity	1.31	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	0.7 - 0.9	%	SABIC Method
Melt Flow Rate, 266°C/5.0 kgf	4.5	g/10 min	ASTM D 1238
Density	1.31	g/cm ³	ISO 1183
Water Absorption, (23°C/sat)	0.42	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.14	%	ISO 62
Melt Volume Rate, MVR at 265°C/5.0 kg	4	cm ³ /10 min	ISO 1133

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PROCESSING PARAMETERS	TYPICAL VALUE	UNIT
Injection Molding		
Drying Temperature	90 - 100	°C
Drying Time	2 - 4	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	255 - 270	°C
Nozzle Temperature	250 - 265	°C
Front - Zone 3 Temperature	250 - 270	°C
Middle - Zone 2 Temperature	240 - 265	°C
Rear - Zone 1 Temperature	230 - 250	°C
Hopper Temperature	40 - 60	°C
Mold Temperature	60 - 80	°C

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