



XENOY® 5220U

Europe-Africa-Middle East: **COMMERCIAL**

PBT+PC Thermoplastic Alloy

XENOY 5220U is an impact modified PC+PBT blend with excellent chemical resistance, good UV stability and good flow. XENOY 5220U has excellent room temperature and low temperature impact. This grade is very similar to XENOY XD1588 and/or XENOY CL100.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
MECHANICAL			
Tensile Stress, yield, 50 mm/min	50	MPa	ISO 527
Tensile Strain, break, 50 mm/min	120	%	ISO 527
Tensile Modulus, 1 mm/min	2050	MPa	ISO 527
IMPACT			
Izod Impact, unnotched 80*10*4 +23°C	55	kJ/m ²	ISO 180/1U
Izod Impact, unnotched 80*10*4 -30°C	35	kJ/m ²	ISO 180/1U
THERMAL			
Vicat B/120	125	°C	ISO 306
HDT/Be, 0.45MPa Edgew 120*10*4 sp=100mm	105	°C	ISO 75/Be
PHYSICAL			
Density	1.22	g/cm ³	ISO 1183
Melt Volume Rate, MVR at 250°C/5.0 kg	17	cm ³ /10 min	ISO 1133

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 by 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	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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