



+135-3858-6433 (GuangDong)
 +188-1699-6168 (ShangHai)
 +852-6957-5415 (HongKong)

GE Plastics

XENOY® CL404

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

PBT+PC Thermoplastic Alloy

XENOY CL404 has been specially developed for extrusion and blow moulding applications, where higher melt strength is desired. XENOY CL404 is a high impact material combined with good UV weathering performance and chemical resistance.

Features

Heat Stabilized

High Impact

Light stabilized

TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
MECHANICAL			
Tensile Stress, yield, 50 mm/min	45	MPa	ISO 527
Tensile Stress, break, 50 mm/min	40	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	4.5	%	ISO 527
Tensile Strain, break, 50 mm/min	90	%	ISO 527
Tensile Modulus, 1 mm/min	2000	MPa	ISO 527
Flexural Modulus, 2 mm/min	1900	MPa	ISO 178
IMPACT			
Izod Impact, unnotched 80*10*4 +23°C	NB	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	50	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*4 -20°C	45	kJ/m ²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	50	kJ/m ²	ISO 179/1eA
Charpy 23°C, Unnotch Edgew 80*10*4 sp=62mm	NB	kJ/m ²	ISO 179/1eU
THERMAL			
CTE, 23°C to 80°C, flow	1.1E-04	1/°C	ISO 11359-2
Ball Pressure Test, 75°C +/- 2°C	PASSES	-	IEC 60695-10-2
Vicat B/50	123	°C	ISO 306
Vicat B/120	125	°C	ISO 306
HDT/Be, 0.45MPa Edgew 120*10*4 sp=100mm	105	°C	ISO 75/Be
HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm	87	°C	ISO 75/Ae
PHYSICAL			
Mold Shrinkage on Tensile Bar, flow (2)	0.7 - 1.1	%	ASTM D 955
Density	1.2	g/cm ³	ISO 1183

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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Water Absorption, (23°C/sat) 1L	0.5	%	ISO 62
Moisture Absorption (23°C / 50% RH) 1L	0.15	%	ISO 62
Melt Volume Rate, MVR at 250°C/5.0 kg	5	cm ³ /10 min	ISO 1133
ELECTRICAL			
Volume Resistivity	1.E+15	Ohm-cm	IEC 60093
Surface Resistivity, ROA	>1.E+15	Ohm	IEC 60093
Dielectric Strength, in oil, 3.2 mm	17	kV/mm	IEC 60243-1
Relative Permittivity, 50/60 Hz	3.3	-	IEC 60250
Relative Permittivity, 1 MHz	3.1	-	IEC 60250
Dissipation Factor, 50/60 Hz	0.002	-	IEC 60250
Dissipation Factor, 1 MHz	0.02	-	IEC 60250
FLAME CHARACTERISTICS			
UL Compliant, 94HB Flame Class Rating (3)(4)	1.6	mm	UL 94 by GE

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PROCESSING PARAMETERS	TYPICAL VALUE	UNIT
Profile Extrusion		
Drying Temperature	110	°C
Drying Time	2 - 4	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	235 - 270	°C
Barrel - Zone 1 Temperature	220 - 250	°C
Barrel - Zone 2 Temperature	230 - 260	°C
Barrel - Zone 3 Temperature	230 - 270	°C
Barrel - Zone 4 Temperature	230 - 270	°C
Hopper Temperature	40 - 60	°C
Adapter Temperature	240 - 260	°C
Die Temperature	240 - 260	°C
Calibrator Temperature	70 - 90	°C

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