



Xenoy* Resin X1200UV

Americas: COMMERCIAL

PBT+PC, Low temperture impact resistance, UV Stabilized

TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	56	MPa	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	56	MPa	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	4.5	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	147	%	ASTM D 638
Tensile Modulus, 50 mm/min	2300	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	87	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	2290	MPa	ASTM D 790
Tensile Stress, yield, 50 mm/min	54	MPa	ISO 527
Tensile Stress, break, 50 mm/min	55	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	4.6	%	ISO 527
Tensile Strain, break, 50 mm/min	157	%	ISO 527
Flexural Stress, yield, 2 mm/min	82	MPa	ISO 178
Flexural Modulus, 2 mm/min	1630	MPa	ISO 178
IMPACT			
Izod Impact, notched, 23°C	828	J/m	ASTM D 256
Izod Impact, notched, -30°C	668	J/m	ASTM D 256
Instrumented Impact Total Energy, 23°C	145	J	ASTM D 3763
Izod Impact, notched 80*10*4 +23°C	56	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	35	kJ/m ²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	69	kJ/m ²	ISO 179/1eA
THERMAL			
Vicat Softening Temp, Rate B/50	119	°C	ASTM D 1525
HDT, 1.82 MPa, 3.2mm, unannealed	88	°C	ASTM D 648

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, 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
THERMAL			
CTE, -40°C to 40°C, flow	7.55E+01	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	8.E+01	1/°C	ISO 11359-2
Vicat Softening Temp, Rate B/50	123	°C	ISO 306
Vicat Softening Temp, Rate B/120	124	°C	ISO 306
PHYSICAL			
Specific Gravity	1.21	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	0.9 - 1	%	SABIC Method
Mold Shrinkage, xflow, 3.2 mm	0.9 - 1	%	SABIC Method
Melt Flow Rate, 250°C/5.0 kgf	15.3	g/10 min	ASTM D 1238
Density	1.21	g/cm ³	ISO 1183
Melt Volume Rate, MVR at 250°C/5.0 kg	15	cm ³ /10 min	ISO 1133

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Source, GMD, Last Update: 12/13/2004





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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 - 275	°C
Nozzle Temperature	255 - 270	°C
Front - Zone 3 Temperature	255 - 275	°C
Middle - Zone 2 Temperature	250 - 270	°C
Rear - Zone 1 Temperature	245 - 265	°C
Mold Temperature	65 - 90	°C
Back Pressure	0.3 - 0.7	MPa
Screw Speed	50 - 80	rpm
Shot to Cylinder Size	50 - 80	%
Vent Depth	0.013 - 0.02	mm

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