



XENOY™ Resin X2500UV

Europe-Africa-Middle East: COMMERCIAL

XENOY X2500UV is a medium viscosity, unfilled, elastomer modified PC/PET blend with excellent heat and impact performance. ISO1043-label: PC+PET-I.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yield	7600	psi	ASTM D 638
Tensile Stress, yld, Type I, 2.0 in/min	8100	psi	ASTM D 638
Tensile Stress, brk, Type I, 2.0 in/min	7900	psi	ASTM D 638
Tensile Strain, yield	5	%	ASTM D 638
Tensile Strain, break	100	%	ASTM D 638
Tensile Strain, yld, Type I, 2.0 in/min	5	%	ASTM D 638
Tensile Strain, brk, Type I, 2.0 in/min	80	%	ASTM D 638
Tensile Modulus, 2.0 in/min	319000	psi	ASTM D 638
Flexural Stress	11400	psi	ASTM D 790
Flexural Stress, yld, 0.05 in/min, 2 in span	11400	psi	ASTM D 790
Flexural Modulus	304000	psi	ASTM D 790
Flexural Modulus, 0.05 in/min, 2 in span	311000	psi	ASTM D 790
Taber Abrasion, CS-17, 1 kg	20	mg/1000cy	SABIC Method
Tensile Stress, yield, 50 mm/min	57	MPa	ISO 527
Tensile Stress, break, 50 mm/min	56	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	5	%	ISO 527
Tensile Strain, break, 50 mm/min	70	%	ISO 527
Tensile Modulus, 1 mm/min	2200	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	80	MPa	ISO 178
Flexural Modulus, 2 mm/min	2150	MPa	ISO 178
Hardness, H358/30	95	MPa	ISO 2039-1

(1) Typical values only. Variations within normal tolerances are possible for various colors. All values are measured after at least 48 hours storage at 23°C/50% relative humidity. All properties, except the melt volume and melt flow rates, are measured on injection molded samples. All samples tested under ISO test standards are prepared according to ISO 294.

(2) Only typical data for selection purposes. 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) Internal measurements according to UL standards.
(5) Measurements made from laboratory test coupon. Actual shrinkage may vary outside of range due to differences in processing conditions, equipment, part geometry and tool design. It is recommended that mold shrinkage studies be performed with surrogate or legacy tooling prior to cutting tools for new molded article.
(6) Needs hard coat to consistently pass 60 sec Vertical Burn.

Source GMD, last updated:





XENOY™ Resin X2500UV

Europe-Africa-Middle East: COMMERCIAL

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
IMPACT			
Izod Impact, notched, 73°F	11.2	ft-lb/in	ASTM D 256
Izod Impact, notched, 32°F	8.4	ft-lb/in	ASTM D 256
Izod Impact, notched, -22°F	3.7	ft-lb/in	ASTM D 256
Instrumented Impact Total Energy, 73°F	531	in-lb	ASTM D 3763
Izod Impact, unnotched 80*10*4 -30°C	NB	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	40	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	25	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*4 -40°C	15	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 -30°C, V-notch Edgew 80*10*4 sp=62mm	30	kJ/m ²	ISO 179/1eA
Charpy -30°C, Unnotch Edgew 80*10*4 sp=62mm	NB	kJ/m ²	ISO 179/1eU
THERMAL			
Vicat Softening Temp, Rate B/50	275	°F	ASTM D 1525
HDT, 264 psi, 0.125 in, unannealed	226	°F	ASTM D 648
CTE, flow, -40°F to 100°F	4.44E-05	1/°F	ASTM E 831
CTE, xflow, -40°F to 100°F	4.72E-05	1/°F	ASTM E 831
Thermal Conductivity	0.18	W/m-°C	ISO 8302
CTE, 23°C to 80°C, flow	8.2E-05	1/°C	ISO 11359-2
CTE, 23°C to 80°C, xflow	8.7E-05	1/°C	ISO 11359-2
Ball Pressure Test, 125°C +/- 2°C	PASSES	-	IEC 60695-10-2
Vicat Softening Temp, Rate A/50	145	°C	ISO 306
Vicat Softening Temp, Rate B/50	135	°C	ISO 306
Vicat Softening Temp, Rate B/120	136	°C	ISO 306
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	108	°C	ISO 75/Af

(1) Typical values only. Variations within normal tolerances are possible for various colors. All values are measured after at least 48 hours storage at 23°C/50% relative humidity. All properties, except the melt volume and melt flow rates, are measured on injection molded samples. All samples tested under ISO test standards are prepared according to ISO 294.

(2) Only typical data for selection purposes. 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) Internal measurements according to UL standards.
(5) Measurements made from laboratory test coupon. Actual shrinkage may vary outside of range due to differences in processing conditions, equipment, part geometry and tool design. It is recommended that mold shrinkage studies be performed with surrogate or legacy tooling prior to cutting tools for new molded article.
(6) Needs hard coat to consistently pass 60 sec Vertical Burn.

Source GMD, last updated:





XENOV™ Resin X2500UV

Europe-Africa-Middle East: COMMERCIAL

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
PHYSICAL			
Specific Gravity	1.21	-	ASTM D 792
Mold Shrinkage, flow (2) (5)	0.5 - 0.8	%	SABIC Method
Mold Shrinkage, flow, 0.125" (5)	0.5 - 0.8	%	SABIC Method
Mold Shrinkage, xflow (2) (5)	0.5 - 0.8	%	SABIC Method
Melt Flow Rate, 265°C/2.16kgf	9	g/10 min	ASTM D 1238
Density	0.04	lb/in ³	ISO 1183
Water Absorption, equilibrium, 73°F	0.7	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.2	%	ISO 62
Melt Volume Rate, MVR at 265°C/1.2 kg	4	cm ³ /10 min	ISO 1133
ELECTRICAL			
Volume Resistivity	>1.E+14	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, 1 MHz	3.1	-	IEC 60250
Dissipation Factor, 50/60 Hz	0.002	-	IEC 60250
Dissipation Factor, 1 MHz	0.02	-	IEC 60250
Relative Permittivity, 50/60 Hz	3.3	-	IEC 60250
FLAME CHARACTERISTICS			
UL Compliant, 94HB Flame Class Rating (3)(4)	0.059	in	UL 94 by SABIC-IP
Glow Wire Flammability Index 750°C, passes at	0.106	in	IEC 60695-2-12

(1) Typical values only. Variations within normal tolerances are possible for various colors. All values are measured after at least 48 hours storage at 23°C/50% relative humidity. All properties, except the melt volume and melt flow rates, are measured on injection molded samples. All samples tested under ISO test standards are prepared according to ISO 294.

(2) Only typical data for selection purposes. 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) Internal measurements according to UL standards.

(5) Measurements made from laboratory test coupon. Actual shrinkage may vary outside of range due to differences in processing conditions, equipment, part geometry and tool design. It is recommended that mold shrinkage studies be performed with surrogate or legacy tooling prior to cutting tools for new molded article.

(6) Needs hard coat to consistently pass 60 sec Vertical Burn.

Source GMD, last updated:





XENOY™ Resin X2500UV

Europe-Africa-Middle East: COMMERCIAL

PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	230 - 250	°F
Drying Time	4 - 6	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	510 - 530	°F
Nozzle Temperature	500 - 530	°F
Front - Zone 3 Temperature	500 - 540	°F
Middle - Zone 2 Temperature	480 - 530	°F
Rear - Zone 1 Temperature	460 - 520	°F
Hopper Temperature	140 - 180	°F
Mold Temperature	140 - 210	°F

(1) Typical values only. Variations within normal tolerances are possible for various colors. All values are measured after at least 48 hours storage at 23°C/50% relative humidity. All properties, except the melt volume and melt flow rates, are measured on injection molded samples. All samples tested under ISO test standards are prepared according to ISO 294.

(2) Only typical data for selection purposes. 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) Internal measurements according to UL standards.

(5) Measurements made from laboratory test coupon. Actual shrinkage may vary outside of range due to differences in processing conditions, equipment, part geometry and tool design. It is recommended that mold shrinkage studies be performed with surrogate or legacy tooling prior to cutting tools for new molded article.

(6) Needs hard coat to consistently pass 60 sec Vertical Burn.

Source GMD, last updated:

