



XENOY™ Resin 1102

Europe-Africa-Middle East: COMMERCIAL

Unreinforced PC/polyester alloy. Excellent low temperature impact/chemical resistance to automotive fluids.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	550	kgf/cm ²	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	150	%	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	830	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	20000	kgf/cm ²	ASTM D 790
Tensile Stress, yield, 50 mm/min	50	MPa	ISO 527
Tensile Stress, break, 50 mm/min	45	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	4.5	%	ISO 527
Tensile Strain, break, 50 mm/min	115	%	ISO 527
Flexural Stress, yield, 2 mm/min	72	MPa	ISO 178
Flexural Modulus, 2 mm/min	1870	MPa	ISO 178
IMPACT			
Izod Impact, notched, 23°C	81	cm-kgf/cm	ASTM D 256
Izod Impact, notched, 0°C	70	cm-kgf/cm	ASTM D 256
Izod Impact, notched, -30°C	65	cm-kgf/cm	ASTM D 256
Izod Impact, notched 80*10*4 +23°C	54	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*4 0°C	52	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	44	kJ/m ²	ISO 180/1A
Charpy 0°C, V-notch Edgew 80*10*3 sp=62mm	50	kJ/m ²	ISO 179/1eA
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	55	kJ/m ²	ISO 179/1eA
Charpy -30°C, V-notch Edgew 80*10*4 sp=62mm	40	kJ/m ²	ISO 179/1eA
Charpy -30°C, Unnotch Edgew 80*10*4 sp=62mm	NB	kJ/m ²	ISO 179/1eU
THERMAL			
HDT, 0.45 MPa, 6.4 mm, unannealed	110	°C	ASTM D 648

(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:

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TYPICAL PROPERTIES¹	TYPICAL VALUE	Unit	Standard
THERMAL			
HDT, 1.82 MPa, 6.4 mm, unannealed	90	°C	ASTM D 648
CTE, -40°C to 40°C, flow	1.E-04	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	1.1E-04	1/°C	ISO 11359-2
Vicat Softening Temp, Rate A/50	155	°C	ISO 306
Vicat Softening Temp, Rate B/120	120	°C	ISO 306
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	79	°C	ISO 75/Af
PHYSICAL			
Specific Gravity	1.19	-	ASTM D 792
Specific Volume	0.83	cm³/g	ASTM D 792
Mold Shrinkage, flow, 3.2 mm (5)	0.8 - 1	%	SABIC Method
Mold Shrinkage, xflow, 3.2 mm (5)	0.8 - 1	%	SABIC Method
Density	1.19	g/cm³	ISO 1183
Melt Flow Rate, 250°C/5.0 kg	13	g/10 min	ISO 1133
Melt Volume Rate, MVR at 250°C/2.16 kg	6	cm³/10 min	ISO 1133
Melt Volume Rate, MVR at 250°C/5.0 kg	12	cm³/10 min	ISO 1133

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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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