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XENOY™ Resin 1103 Americas: COMMERCIAL

AUTOMOTIVE. Unreinforced, impact modified PBT+PC alloy. Excellent low temperature impact and chemical resistance. Range gray, black colors.

YPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	520	kgf/cm²	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	510	kgf/cm²	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	5	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	150	%	ASTM D 638
Tensile Modulus, 50 mm/min	19300	kgf/cm²	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	780	kgf/cm²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	19600	kgf/cm²	ASTM D 790
IMPACT			
Izod Impact, notched, 23°C	76	cm-kgf/cm	ASTM D 256
Instrumented Impact Total Energy, 23°C	622	cm-kgf	ASTM D 3763
THERMAL			
Vicat Softening Temp, Rate B/50	125	°C	ASTM D 1525
HDT, 0.45 MPa, 3.2 mm, unannealed	104	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	87	°C	ASTM D 648
CTE, -40°C to 40°C, flow	1.71E-04	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	2.E-04	1/°C	ASTM E 831
PHYSICAL			
Specific Gravity	1.2	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm (5)	0.8 - 1	%	SABIC Method
Melt Flow Rate, 250°C/5.0 kgf	13	g/10 min	ASTM D 1238

(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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⁽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.

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XENOY™ Resin 1103

Americas: COMMERCIAL

ROCESSING 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	255 - 275	°C
Nozzle Temperature	250 - 265	°C
Front - Zone 3 Temperature	250 - 270	°C
Middle - Zone 2 Temperature	245 - 265	°C
Rear - Zone 1 Temperature	240 - 260	°C
Mold Temperature	40 - 90	°C
Back Pressure	0.3 - 0.7	MPa
Screw Speed	40 - 80	rpm
Shot to Cylinder Size	50 - 80	%
Vent Depth	0.013 - 0.02	mm

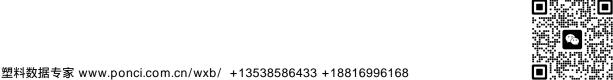
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