



Xylex* Resin FXY330DF

Asia Pacific: COMMERCIAL

Polyester+PC alloy. Diffusion Effect. Color package may affect performance.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	470	kgf/cm ²	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	500	kgf/cm ²	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	5.2	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	170	%	ASTM D 638
Tensile Modulus, 50 mm/min	14600	kgf/cm ²	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	680	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	15200	kgf/cm ²	ASTM D 790
Tensile Stress, yield, 50 mm/min	49	MPa	ISO 527
Tensile Stress, break, 50 mm/min	49	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	>5.4	%	ISO 527
Tensile Strain, break, 50 mm/min	>200	%	ISO 527
Tensile Modulus, 1 mm/min	1570	MPa	ISO 527
Flexural Modulus, 2 mm/min	1600	MPa	ISO 178
IMPACT			
Izod Impact, notched, 23°C	7	cm-kgf/cm	ASTM D 256
Izod Impact, notched, 0°C	6	cm-kgf/cm	ASTM D 256
Izod Impact, notched, -30°C	5	cm-kgf/cm	ASTM D 256
Instrumented Impact Total Energy, 23°C	614	cm-kgf	ASTM D 3763
Izod Impact, notched 80*10*4 +23°C	6	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	4	kJ/m ²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	7	kJ/m ²	ISO 179/1eA
THERMAL			
Vicat Softening Temp, Rate B/50	89	°C	ASTM D 1525

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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THERMAL			
HDT, 1.82 MPa, 3.2mm, unannealed	72	°C	ASTM D 648
CTE, -40°C to 40°C, flow	8.9E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	9.4E-05	1/°C	ASTM E 831
Vicat Softening Temp, Rate B/50	92	°C	ISO 306
Vicat Softening Temp, Rate B/120	93	°C	ISO 306
PHYSICAL			
Specific Gravity	1.17	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	0.5 - 0.7	%	SABIC Method
Mold Shrinkage, xflow, 3.2 mm	0.4 - 0.6	%	SABIC Method
Melt Flow Rate, 265°C/2.16kg	14	g/10 min	ASTM D 1238
Density	1.17	g/cm ³	ISO 1183
Water Absorption, (23°C/sat)	0.7	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.27	%	ISO 62
Melt Volume Rate, MVR at 265°C/2.16 kg	13	cm ³ /10 min	ISO 1133

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PROCESSING PARAMETERS	TYPICAL VALUE	UNIT
Injection Molding		
Drying Temperature	65 - 75	°C
Drying Time	3 - 5	hrs
Drying Time (Cumulative)	8	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	245 - 265	°C
Nozzle Temperature	245 - 265	°C
Front - Zone 3 Temperature	245 - 265	°C
Middle - Zone 2 Temperature	240 - 260	°C
Rear - Zone 1 Temperature	240 - 250	°C
Mold Temperature	45 - 60	°C
Back Pressure	0.2 - 0.5	MPa
Screw Speed	20 - 100	rpm
Shot to Cylinder Size	40 - 80	%
Vent Depth	0.013 - 0.02	mm

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