XYLEX™ *X7200*

Europe-Africa-Middle East: COMMERCIAL

General purpose, unreinforced PC+polyester alloy with excellent optical quality. UV-stabilized.

TYPICAL PROPERTIES [1]	TYPICAL VALUE	UNIT	STANDARD
MECHANICAL			
Tensile Str, yld, Type I, 50 mm/min	56	MPa	ASTM D 638
Tensile Str, brk, Type I, 50 mm/min	56	MPa	ASTM D 638
Tensile Elong, yld, Type I, 50 mm/min	5	%	ASTM D 638
Tensile Elong, brk, Type I, 50 mm/min	135	%	ASTM D 638
Tensile Modulus, 50 mm/min	1880	MPa	ASTM D 638
Flex Stress, yld, 1.3 mm/min, 50 mm span	84	MPa	ASTM D 790
Flex Mod, 1.3 mm/min, 50 mm span	1970	MPa	ASTM D 790
Tensile Stress, yield, 50 mm/min	55	MPa	ISO 527
Tensile Stress, break, 50 mm/min	56	MPa	ISO 527
Tensile Strain, break, 50 mm/min	>150	%	ISO 527
Tensile Modulus, 1 mm/min	2000	MPa	ISO 527
Flexural Strength, break, 2 mm/min	75	MPa	ISO 178
Flexural Modulus, 2 mm/min	2000	MPa	ISO 178
IMPACT			
Izod Impact, notched, 23°C	710	J/m	ASTM D 256
Instrumented Impact Total Energy, 23°C	95	J	ASTM D 3763
Izod Impact, notched 80*10*4 +23°C	8	kJ/m²	ISO 180/1A
Izod Impact, notched 80*10*4 -10°C	5	kJ/m²	ISO 180/1A
THERMAL			
Vicat Softening Temp, Rate B	115	°C	ASTM D 1525
HDT, 0.45 MPa, 3.2 mm, unannealed	97	°C	ASTM D 648
HDT, 1.84 MPa, 3.2mm, unannealed	91	°C	ASTM D 648
CTE, -40°C to 40°C, flow	1.05E-04	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	1.05E-04	1/°C	ASTM E 831
Thermal Conductivity	0.23	W/m-°C	ISO 8302
CTE, 23°C to 60°C, flow	8.E-05	1/°C	ISO 11359-2
CTE, 23°C to 60°C, xflow	8.E-05	1/°C	ISO 11359-2
Vicat B/120	115	°C	ISO 306
HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm	99	°C	ISO 75/Ae
PHYSICAL			
Specific Gravity	1.2	-	ASTM D 792

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, expect 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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TYPICAL PROPERTIES [1]	TYPICAL VALUE	UNIT	STANDARD
Mold Shrinkage, flow, 3.2 mm	0.5 - 0.7	%	ASTM D 955
Mold Shrinkage, xflow, 3.2 mm	0.5 - 0.7	%	ASTM D 955
Melt Flow Rate, 265°C/2.16kg	12	g/10 min	ASTM D 1238
Melt Flow Rate, 300°C/1.2 kgf	15	g/10 min	ASTM D 1238
Density	1.18	g/cm³	ISO 1183
Melt Volume Rate, MVR at 265°C/2.16 kg	12	cm³/10 min	ISO 1133
Melt Volume Rate, MVR at 300°C/1.2 kg	14	cm³/10 min	ISO 1133
OPTICAL			
Light Transmission	88	%	ASTM D 1003
Haze	1.1	%	ASTM D 1003
FLAME CHARACTERISTICS			
UL Recognized, 94V-2 Flame Class Rating (3)	0.8	mm	UL 94

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PROCESSING PARAMETERS	TYPICAL VALUE	UNIT
Injection Molding		
Drying Temperature	80 - 95	°C
Drying Time	3 - 5	hrs
Drying Time (Cumulative)	8	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	250 - 270	°C
Nozzle Temperature	250 - 270	°C
Front - Zone 3 Temperature	250 - 270	°C
Middle - Zone 2 Temperature	245 - 265	°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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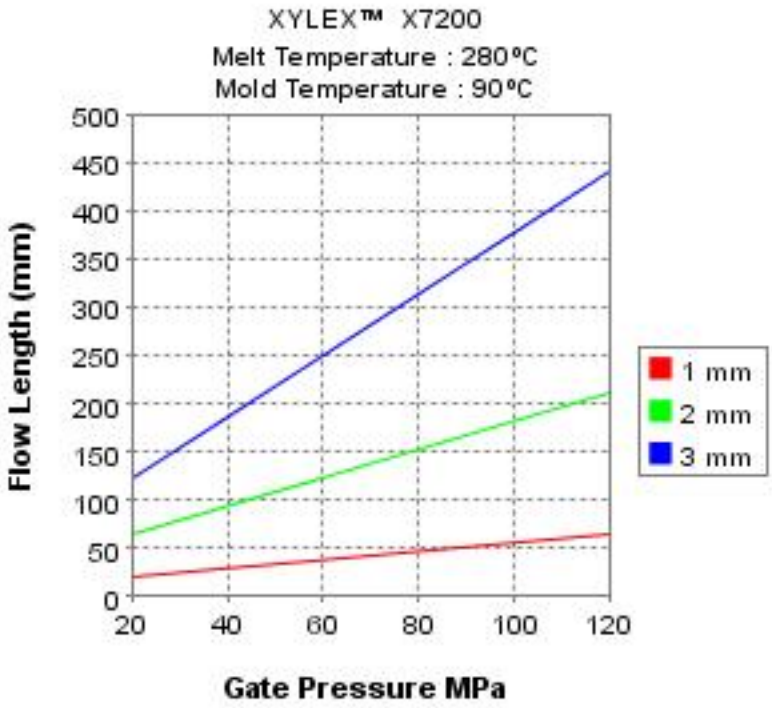
CALCULATED FLOW LENGTH INDICATION

Moldflow® Radial Flow Analysis



Note: Technical support is recommended if Gate Pressure is greater than 80 MPa. Contact your local representative.

® Moldflow is a registered trademark of the Moldflow Corporation.

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