



## XYLEX™ Resin X5230

### Asia Pacific: COMMERCIAL

Mineral filled PC/PET blend with high flow, high heat, dimensional stability, low shrinkage and low CTE, especially for painted applications

TYPICAL PROPERTIES <sup>1</sup>	TYPICAL VALUE	Unit	Standard
<b>MECHANICAL</b>			
Tensile Stress, yield, 5 mm/min	53	MPa	ISO 527
Tensile Stress, break, 5 mm/min	34	MPa	ISO 527
Tensile Strain, yield, 5 mm/min	3.4	%	ISO 527
Tensile Strain, break, 5 mm/min	21	%	ISO 527
Tensile Modulus, 1 mm/min	3990	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	90	MPa	ISO 178
Flexural Modulus, 2 mm/min	3810	MPa	ISO 178
<b>IMPACT</b>			
Izod Impact, unnotched 80*10*4 +23°C	135	kJ/m <sup>2</sup>	ISO 180/1U
Izod Impact, unnotched 80*10*4 -30°C	115	kJ/m <sup>2</sup>	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	8	kJ/m <sup>2</sup>	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	6	kJ/m <sup>2</sup>	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	14	kJ/m <sup>2</sup>	ISO 179/1eA
<b>THERMAL</b>			
CTE, -30°C to 80°C, flow	4.5E-05	1/°C	ISO 11359-2
CTE, -30°C to 80°C, xflow	9.7E-05	1/°C	ISO 11359-2
Vicat Softening Temp, Rate B/50	137	°C	ISO 306
Vicat Softening Temp, Rate B/120	140	°C	ISO 306
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	100	°C	ISO 75/Af
<b>PHYSICAL</b>			
Mold Shrinkage on Tensile Bar, flow (2) (5)	0.5 - 0.6	%	SABIC Method
Melt Flow Rate, 265°C/5.0 kgf	28	g/10 min	ASTM D 1238
Density	1.33	g/cm <sup>3</sup>	ISO 1183
Water Absorption, (23°C/sat)	0.42	%	ISO 62

(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
<b>PHYSICAL</b>			
Moisture Absorption (23°C / 50% RH)	0.14	%	ISO 62
Melt Volume Rate, MVR at 265°C/5.0 kg	24	cm³/10 min	ISO 1133

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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
<b>Injection Molding</b>		
Drying Temperature	110 - 120	°C
Drying Time	4 - 6	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	265 - 275	°C
Nozzle Temperature	260 - 275	°C
Front - Zone 3 Temperature	260 - 280	°C
Middle - Zone 2 Temperature	250 - 275	°C
Rear - Zone 1 Temperature	240 - 270	°C
Hopper Temperature	60 - 80	°C
Mold Temperature	60 - 100	°C

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