



XENOY™ Resin X5230

Europe-Africa-Middle East: COMMERCIAL

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

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yield, 5 mm/min	58	MPa	ISO 527
Tensile Stress, break, 5 mm/min	42	MPa	ISO 527
Tensile Strain, yield, 5 mm/min	3.6	%	ISO 527
Tensile Strain, break, 5 mm/min	9	%	ISO 527
Tensile Modulus, 1 mm/min	3850	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	95	MPa	ISO 178
Flexural Modulus, 2 mm/min	3750	MPa	ISO 178
IMPACT			
Izod Impact, unnotched 80*10*4 +23°C	137	kJ/m ²	ISO 180/1U
Izod Impact, unnotched 80*10*4 -30°C	120	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	10	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	7	kJ/m ²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	10	kJ/m ²	ISO 179/1eA
THERMAL			
CTE, -30°C to 80°C, flow	5.4E-05	1/°C	ISO 11359-2
CTE, -30°C to 80°C, xflow	7.4E-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	109	°C	ISO 75/Af
PHYSICAL			
Mold Shrinkage on Tensile Bar, flow (2) (5)	0.5 - 0.7	%	SABIC Method
Melt Flow Rate, 265°C/5.0 kgf	28	g/10 min	ASTM D 1238
Density	1.33	g/cm ³	ISO 1183
Water Absorption, (23°C/sat)	0.42	%	ISO 62



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TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
PHYSICAL			
Moisture Absorption (23°C / 50% RH)	0.14	%	ISO 62
Melt Volume Rate, MVR at 265°C/5.0 kg	24	cm ³ /10 min	ISO 1133



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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
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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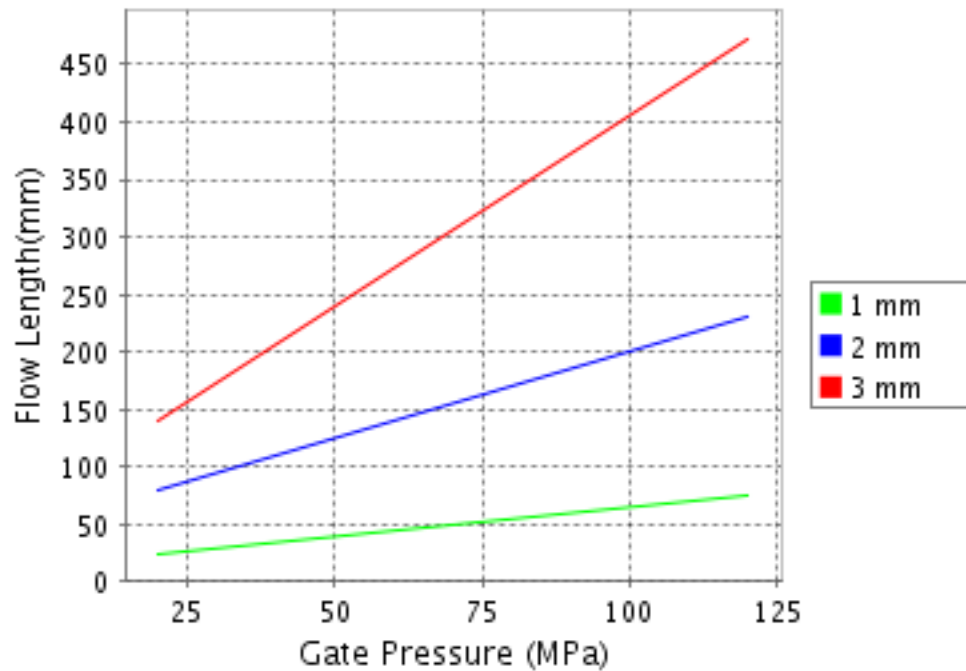
CALCULATED FLOW LENGTH INDICATION

Moldflow® Radial Flow Analysis

XENOY® X5230

Melt Temperature : 270°C

Mold Temperature : 80°C



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

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