+135-3858-6433 (GuangDong)
+188-1699-6168 (ShangHai)
+852-6957-5415 (HongKong)

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[1]	TYPICAL VALUE	Unit	Standard
MECHANICAL			
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
IMPACT			
Izod Impact, unnotched 80*10*4 +23°C	135	kJ/m²	ISO 180/1U
Izod Impact, unnotched 80*10*4 -30°C	115	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	8	kJ/m²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	6	kJ/m²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	14	kJ/m²	ISO 179/1eA
THERMAL			
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
PHYSICAL			
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/cm³	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	cm³/10 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