



XYLEX™ Resin X7200MR
Americas: COMMERCIAL

Mold Release version of X7200

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	560	kgf/cm ²	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	570	kgf/cm ²	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	5	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	135	%	ASTM D 638
Tensile Modulus, 50 mm/min	19100	kgf/cm ²	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	850	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	19900	kgf/cm ²	ASTM D 790
Hardness, Shore D, 10S reading	75	-	ASTM D 2240
Tensile Stress, yield, 50 mm/min	55	MPa	ISO 527
Tensile Stress, break, 50 mm/min	56	MPa	ISO 527
Tensile Strain, yield, 5 mm/min	5	%	ISO 527
Tensile Strain, break, 50 mm/min	>150	%	ISO 527
Tensile Modulus, 1 mm/min	2000	MPa	ISO 527
Flexural Stress, break, 2 mm/min	75	MPa	ISO 178
Flexural Modulus, 2 mm/min	2000	MPa	ISO 178
IMPACT			
Izod Impact, notched, 23°C	91	cm-kgf/cm	ASTM D 256
Instrumented Impact Total Energy, 23°C	968	cm-kgf	ASTM D 3763
Izod Impact, notched 80*10*4 +23°C	8	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*4 -10°C	5	kJ/m ²	ISO 180/1A
THERMAL			
Vicat Softening Temp, Rate B/50	115	°C	ASTM D 1525
HDT, 0.45 MPa, 3.2 mm, unannealed	96	°C	ASTM D 648



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THERMAL			
HDT, 1.82 MPa, 3.2mm, unannealed	90	°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
Ball Pressure Test, approximate maximum	105	°C	IEC 60695-10-2
Vicat Softening Temp, Rate 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
Mold Shrinkage, flow, 3.2 mm (5)	0.5 - 0.7	%	SABIC Method
Mold Shrinkage, xflow, 3.2 mm (5)	0.5 - 0.7	%	SABIC Method
Melt Flow Rate, 265°C/2.16kgf	12	g/10 min	ASTM D 1238
Density	1.18	g/cm ³	ISO 1183
Melt Volume Rate, MVR at 265°C/2.16 kg	12	cm ³ /10 min	ISO 1133
OPTICAL			
Light Transmission, 2.54 mm	88	%	ASTM D 1003
Haze, 2.54 mm	1.1	%	ASTM D 1003
Refractive Index	1.557	-	ISO 489
ELECTRICAL			
Volume Resistivity	>1.E+15	Ohm-cm	ASTM D 257
Surface Resistivity	>1.E+15	Ohm	ASTM D 257
FLAME CHARACTERISTICS			
UL Recognized, 94V-2 Flame Class Rating (3)	3	mm	UL 94
Glow Wire Flammability Index 750°C, passes at	1	mm	IEC 60695-2-12



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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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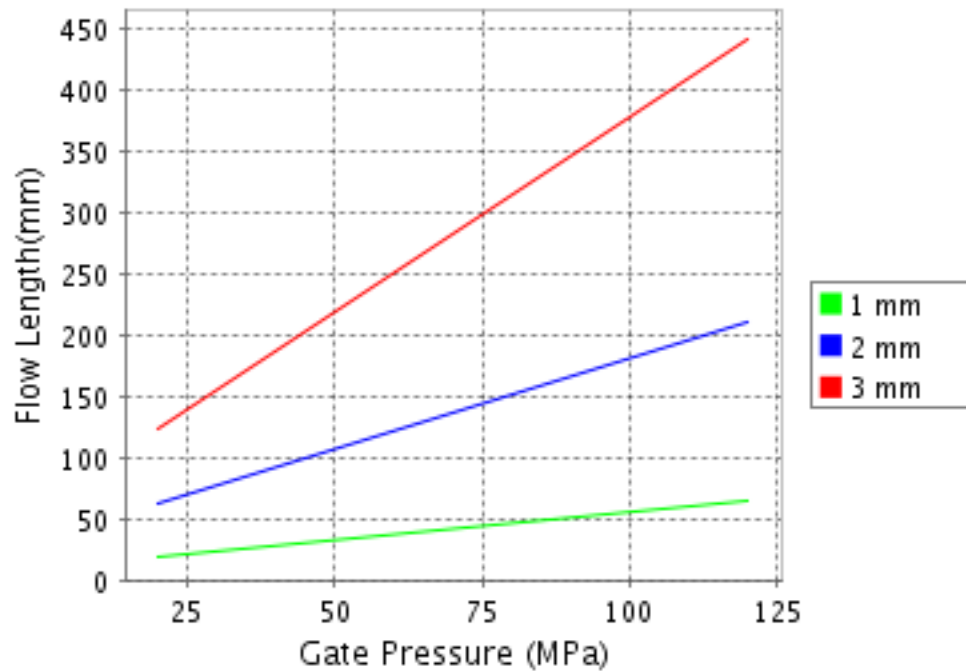
CALCULATED FLOW LENGTH INDICATION

Moldflow® Radial Flow Analysis

XYLEX® X7200MR

Melt Temperature : 280°C

Mold Temperature : 90°C



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

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