+135-3858-6433 (GuangDong)
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XYLEX™ Resin X8303CL
Americas: COMMERCIAL

PC+ POLYESTER, Transparent, Low processing Temperature, High flow with excellent impact, UV stabilized, OQ quality. For In Mold Decoration /Labeling.

TYPICAL PROPERTIES[1]	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	460	kgf/cm²	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	440	kgf/cm²	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	5	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	140	%	ASTM D 638
Tensile Modulus, 5 mm/min	17100	kgf/cm²	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	730	kgf/cm²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	16500	kgf/cm²	ASTM D 790
Tensile Stress, yield, 50 mm/min	48	MPa	ISO 527
Tensile Stress, break, 50 mm/min	43	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	6	%	ISO 527
Tensile Strain, break, 50 mm/min	140	%	ISO 527
Tensile Modulus, 1 mm/min	1690	MPa	ISO 527
Flexural Stress, break, 2 mm/min	72	MPa	ISO 178
Flexural Modulus, 2 mm/min	1720	MPa	ISO 178
IMPACT			
Izod Impact, notched, 23°C	101	cm-kgf/cm	ASTM D 256
Izod Impact, notched, -30°C	10	cm-kgf/cm	ASTM D 256
Instrumented Impact Total Energy, 23°C	662	cm-kgf	ASTM D 3763
Izod Impact, notched 80*10*4 +23°C	20	kJ/m²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	9	kJ/m²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	14	kJ/m²	ISO 179/1eA
THERMAL			
Vicat Softening Temp, Rate B/50	98	°C	ASTM D 1525

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TYPICAL PROPERTIES[1]	TYPICAL VALUE	Unit	Standard
THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	92	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	80	°C	ASTM D 648
CTE, -40°C to 40°C, flow	9.E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	9.E-05	1/°C	ASTM E 831
CTE, 23°C to 60°C, flow	9.2E-05	1/°C	ISO 11359-2
CTE, 23°C to 60°C, xflow	9.8E-05	1/°C	ISO 11359-2
Vicat Softening Temp, Rate B/50	100	°C	ISO 306
Vicat Softening Temp, Rate B/120	100	°C	ISO 306
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	90	°C	ISO 75/Af
PHYSICAL			
Specific Gravity	1.2	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm (5)	0.4 - 0.8	%	SABIC Method
Melt Flow Rate, 265°C/2.16kgf	30	g/10 min	ASTM D 1238
Density	1.2	g/cm³	ISO 1183
Water Absorption, (23°C/sat)	0.5	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.2	%	ISO 62
Melt Volume Rate, MVR at 265°C/2.16 kg	27	cm³/10 min	ISO 1133

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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	70 - 80	°C
Drying Time	3 - 5	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	240 - 270	°C
Nozzle Temperature	240 - 270	°C
Front - Zone 3 Temperature	240 - 270	°C
Middle - Zone 2 Temperature	235 - 265	°C
Rear - Zone 1 Temperature	235 - 255	°C
Mold Temperature	50 - 70	°C
Screw Speed	20 - 100	rpm