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

XENOY™ RESIN X2300WX

REGION AMERICAS

DESCRIPTION

Unreinforced, opaque PC+PET alloy. Chemical resistance, dimensional stability/mechanical performance. UV-stabilized.

TYPICAL PROPERTY VALUES

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	58	MPa	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	44	MPa	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	5	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	120	%	ASTM D 638
Tensile Modulus, 50 mm/min	2410	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	86	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	2200	MPa	ASTM D 790
IMPACT			
Izod Impact, notched, 23°C	640	J/m	ASTM D 256
Instrumented Impact Total Energy, 23°C	48	J	ASTM D 3763
THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	126	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	110	°C	ASTM D 648
CTE, -40°C to 40°C, flow	7.2E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	7.2E-05	1/°C	ASTM E 831
PHYSICAL			
Specific Gravity	1.21	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	0.8 – 1	%	SABIC method
Melt Flow Rate, 266°C/5.0 kgf	35	g/10 min	ASTM D 1238
INJECTION MOLDING			
Drying Temperature	110	°C	
Drying Time	4 – 6	hrs	
Drying Time (Cumulative)	8	hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	260 – 280	°C	
Nozzle Temperature	255 – 275	°C	
Front - Zone 3 Temperature	260 – 280	°C	
Middle - Zone 2 Temperature	255 – 275	°C	
Rear - Zone 1 Temperature	250 – 270	°C	
Mold Temperature	65 – 95	°C	
Back Pressure	0.3 – 0.6	MPa	
Screw Speed	50 – 80	rpm	
Shot to Cylinder Size	50 – 80	%	
Vent Depth	0.013 – 0.02	mm	