XYLEX™ X7519HP resin

Polycarbonate + Polyester

SABIC Innovative Plastics

Message:

Good Chemical Resistance, XYLEX grade with good dishwasher performance, USA/Europe Food Contact Comment: While molding of thicker parts, cooling speed has an influence of transparency. Thicker parts may form opaque areas in the centre due to slow cooling.

General Information			
Features	Food Contact Acceptable Good Chemical Resistance		
Processing Method	Injection Molding		
Physical	**Nominal Value**	**Unit**	**Test Method**
Specific Gravity	1.19	g/cm³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	13	g/10 min	ASTM D1238
Melt Volume-Flow Rate (MVR) (300°C/1.2 kg)	10.0	cm³/10min	ISO 1133
Molding Shrinkage - Flow (3.20 mm)	0.70 to 0.80	%	Internal Method
Water Absorption			ISO 62
Saturation, 23°C	0.16	%	
Equilibrium, 23°C, 50% RH	0.14	%	
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus			
-- [1]	2470	MPa	ASTM D638
--	2370	MPa	ISO 527-2/1
Tensile Strength			
Yield [2]	58.0	MPa	ASTM D638
Yield	61.0	MPa	ISO 527-2/50
Break [3]	66.0	MPa	ASTM D638
Break	66.0	MPa	ISO 527-2/50
Tensile Elongation			
Yield [4]	2.0	%	ASTM D638
Yield	6.0	%	ISO 527-2/50
Break [5]	120	%	ASTM D638
Break	130	%	ISO 527-2/50
Flexural Modulus			
50.0 mm Span [6]	2240	MPa	ASTM D790
-- [7]	2030	MPa	ISO 178
Flexural Stress			
--	90.0	MPa	ISO 178
Yield, 50.0 mm Span [8]	98.0	MPa	ASTM D790

Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength [9] (23°C)	13	kJ/m²	ISO 179/1eA
Notched Izod Impact			
-30°C	100	J/m	ASTM D256
23°C	700	J/m	ASTM D256
-30°C [10]	8.0	kJ/m²	ISO 180/1A
23°C [11]	10	kJ/m²	ISO 180/1A
Instrumented Dart Impact (23°C, Total Energy)	74.0	J	ASTM D3763
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load			
1.8 MPa, Unannealed, 3.20 mm	113	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span [12]	112	°C	ISO 75-2/Af
Vicat Softening Temperature			
--	130	°C	ASTM D1525, ISO 306/B50 11 [13]
--	132	°C	ISO 306/B120
CLTE			
Flow : -40 to 40°C	6.5E-5	cm/cm/°C	ASTM E831
Flow : -40 to 40°C	7.5E-5	cm/cm/°C	ISO 11359-2
Transverse : -40 to 40°C	6.7E-5	cm/cm/°C	ASTM E831
Transverse : -40 to 40°C	7.5E-5	cm/cm/°C	ISO 11359-2
Injection	**Nominal Value**	**Unit**	
Drying Temperature	85.0 to 100	°C	
Drying Time	2.0 to 3.0	hr	
Drying Time, Maximum	8.0	hr	
Suggested Max Moisture	0.020	%	
Suggested Shot Size	40 to 80	%	
Hopper Temperature	50.0	°C	
Rear Temperature	275 to 285	°C	
Middle Temperature	280 to 290	°C	
Front Temperature	290 to 300	°C	
Nozzle Temperature	280 to 290	°C	
Processing (Melt) Temp	280 to 300	°C	
Mold Temperature	65.0 to 75.0	°C	
Back Pressure	0.100 to 0.500	MPa	
Screw Speed	20 to 100	rpm	
NOTE			
1.	5.0 mm/min		
2.	Type I, 50 mm/min		
3.	Type I, 50 mm/min		
4.	Type I, 50 mm/min		
5.	Type I, 50 mm/min		

6.	1.3 mm/min
7.	2.0 mm/min
8.	1.3 mm/min
9.	80*10*4 sp=62mm
10.	80*10*4
11.	80*10*4
12.	80*10*4 mm
13.	Rate B (120°C/h), Loading 2 (50 N)

Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China