XYLEX™ FXY330DF resin

Polycarbonate + Polyester

SABIC Innovative Plastics Europe

Message:

Polyester+PC alloy. Diffusion Effect. Color package may affect performance.

General Information			
UL YellowCard	E45329-100164508		
RoHS Compliance	RoHS compliance		
Processing Method	Injection molding		
Physical	**Nominal Value**	**Unit**	**Test Method**
Specific Gravity	1.17	g/cm³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (265°C/2.16 kg)	15	g/10 min	ASTM D1238
Melt Volume-Flow Rate (MVR) (265°C/2.16 kg)	13.0	cm³/10min	ISO 1133
Molding Shrinkage			Internal method
Flow: 3.20mm	0.50 - 0.70	%	Internal method
Transverse flow: 3.20mm	0.40 - 0.60	%	Internal method
Water Absorption			ISO 62
Saturated, 23°C	0.70	%	ISO 62
Equilibrium, 23°C, 50% RH	0.27	%	ISO 62
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus			
-- [1]	1440	MPa	ASTM D638
--	1580	MPa	ISO 527-2/1
Tensile Strength			
Yield [2]	47.0	MPa	ASTM D638
Yield	49.0	MPa	ISO 527-2/50
Fracture [3]	49.0	MPa	ASTM D638
Fracture	50.0	MPa	ISO 527-2/50
Tensile Elongation			
Yield [4]	5.0	%	ASTM D638
Yield	> 5.0	%	ISO 527-2/50
Fracture [5]	170	%	ASTM D638
Fracture	> 200	%	ISO 527-2/50
Flexural Modulus			
50.0mm span [6]	1500	MPa	ASTM D790
-- [7]	1600	MPa	ISO 178
Flexural Stress			
--	77.0	MPa	ISO 178

Yield, 50.0mm span [8]	67.0	MPa	ASTM D790
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Notched Impact Strength [9] (23°C)	7.0	kJ/m²	ISO 179/1eA
Notched Izod Impact			
-30°C	55	J/m	ASTM D256
0°C	64	J/m	ASTM D256
23°C	70	J/m	ASTM D256
-30°C [10]	4.0	kJ/m²	ISO 180/1A
23°C [11]	7.0	kJ/m²	ISO 180/1A
Instrumented Dart Impact (23°C, Total Energy)	60.0	J	ASTM D3763
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load			
1.8 MPa, unannealed, 3.20mm	72.0	°C	ASTM D648
1.8 MPa, unannealed, 64.0mm span [12]	78.0	°C	ISO 75-2/Af
Vicat Softening Temperature			
--	90.0	°C	ASTM D1525 [13]
--	92.0	°C	ISO 306/B50
--	93.0	°C	ISO 306/B120
Linear thermal expansion coefficient			
Flow: -40 to 40°C	8.9E-5	cm/cm/°C	ASTM E831
Flow: -40 to 40°C	9.0E-5	cm/cm/°C	ISO 11359-2
Lateral: -40 to 40°C	9.4E-5	cm/cm/°C	ASTM E831
Lateral: -40 to 40°C	9.0E-5	cm/cm/°C	ISO 11359-2
Injection	**Nominal Value**	**Unit**	
Drying Temperature	66 - 77	°C	
Drying Time	3.0 - 5.0	hr	
Drying Time, Maximum	8.0	hr	
Suggested Max Moisture	0.020	%	
Suggested Shot Size	40 - 80	%	
Rear Temperature	238 - 249	°C	
Middle Temperature	238 - 260	°C	
Front Temperature	243 - 266	°C	
Nozzle Temperature	243 - 266	°C	
Processing (Melt) Temp	243 - 266	°C	
Mold Temperature	43 - 60	°C	
Back Pressure	0.172 - 0.517	MPa	
Screw Speed	20 - 100	rpm	
Vent Depth	0.013 - 0.020	mm	
NOTE			
1.	50 mm/min		
2.	Type 1, 50mm/min		

3.	Type 1, 50mm/min
4.	Type 1, 50mm/min
5.	Type 1, 50mm/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.	标准 B (120°C/h), 载荷2 (50N)

Recommended distributors for this material

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