

XYLEX™ X7300 resin

Polycarbonate + Polyester
SABIC Innovative Plastics Asia Pacific

Message:
PC+POLYESTER unreinforced alloy. High flow, chemically resistant with excellent optical quality. UV-stabilized.

General Information			
Additive	UV stabilizer		
Features	High liquidity		
	Good chemical resistance		
Processing Method	Injection molding		
Multi-Point Data	Thermal Conductivity vs. Temperature (ASTM E1530)		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
--	1.20	g/cm ³	ASTM D792
--	1.18	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (265°C/2.16 kg)	21	g/10 min	ASTM D1238
Melt Volume-Flow Rate (MVR) (265°C/2.16 kg)	21.0	cm ³ /10min	ISO 1133
Molding Shrinkage			Internal method
Flow: 3.20mm	0.40 - 0.80	%	Internal method
Transverse flow: 3.20mm	0.50 - 0.70	%	Internal method
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	1840	MPa	ASTM D638
--	1900	MPa	ISO 527-2/1
Tensile Strength			
Yield ²	49.0	MPa	ASTM D638
Yield	55.0	MPa	ISO 527-2/50
Fracture ³	52.0	MPa	ASTM D638
Fracture	55.0	MPa	ISO 527-2/50
Tensile Elongation			
Yield ⁴	5.0	%	ASTM D638
Yield	5.0	%	ISO 527-2/50
Fracture ⁵	150	%	ASTM D638
Fracture	> 150	%	ISO 527-2/50
Flexural Modulus			
50.0mm span ⁶	1940	MPa	ASTM D790
-- ⁷	2000	MPa	ISO 178

Flexural Stress			
--	71.0	MPa	ISO 178
Yield, 50.0mm span ⁸	83.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	660	J/m	ASTM D256
23°C ⁹	9.0	kJ/m ²	ISO 180/1A
Instrumented Dart Impact (23°C, Total Energy)	95.0	J	ASTM D3763
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, unannealed, 3.20mm	102	°C	ASTM D648
1.8 MPa, unannealed, 3.20mm	88.0	°C	ASTM D648
1.8 MPa, unannealed, 100 mm span ¹⁰	90.0	°C	ISO 75-2/Ae
Vicat Softening Temperature			
--	108	°C	ASTM D1525 ¹¹
--	106	°C	ISO 306/B120
Linear thermal expansion coefficient			
Flow: -40 to 40°C	1.2E-4	cm/cm/°C	ASTM E831
Flow: 23 to 60°C	8.5E-5	cm/cm/°C	ISO 11359-2
Lateral: -40 to 40°C	1.1E-4	cm/cm/°C	ASTM E831
Lateral: 23 to 60°C	8.5E-5	cm/cm/°C	ISO 11359-2
Optical	Nominal Value	Unit	Test Method
Transmittance (2540 µm)	88.0	%	ASTM D1003
Haze (2540 µm)	2.0	%	ASTM D1003
Injection	Nominal Value	Unit	
Drying Temperature	82.2 - 93.3	°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	243 - 266	°C	
Front Temperature	249 - 271	°C	
Nozzle Temperature	249 - 271	°C	
Processing (Melt) Temp	249 - 271	°C	
Mold Temperature	43.3 - 60.0	°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
10.	120*10*4 mm
11.	标准 B (120°C/h), 载荷2 (50N)

The information and data on this page are provided by manufacturers and document providers. SHANGHAI SUSHENG assumes no legal liability. It is strongly recommended to verify all technical data with material suppliers before final material selection. All rights belong to the original authors. If any infringement occurs, please contact us immediately.

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

