

XENOY™ X5230 resin

Polycarbonate + PET

SABIC Innovative Plastics Europe

Message:

Mineral filled PC/PET blend with high flow, high heat, dimensional stability, low shrinkage and low CTE, especially for painted applications

General Information			
Filler / Reinforcement	Mineral		
Features	Good Dimensional Stability		
	High Flow		
	High Heat Resistance		
	Low CLTE		
	Low Shrinkage		
	Paintable		
RoHS Compliance	RoHS Compliant		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.33	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (265°C/5.0 kg)	28	g/10 min	ASTM D1238
Melt Volume-Flow Rate (MVR) (265°C/5.0 kg)	24.0	cm ³ /10min	ISO 1133
Molding Shrinkage - Flow ¹	0.50 to 0.70	%	Internal Method
Water Absorption			ISO 62
Saturation, 23°C	0.42	%	
Equilibrium, 23°C, 50% RH	0.14	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	3850	MPa	ISO 527-2/1
Tensile Stress			ISO 527-2/5
Yield	58.0	MPa	
Break	42.0	MPa	
Tensile Strain			ISO 527-2/5
Yield	3.6	%	
Break	9.0	%	
Flexural Modulus ²	3750	MPa	ISO 178
Flexural Stress	95.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ³ (23°C)	10	kJ/m ²	ISO 179/1eA
Notched Izod Impact Strength ⁴			ISO 180/1A
-30°C	7.0	kJ/m ²	

23°C	10	kJ/m ²	
Unnotched Izod Impact Strength ⁵			ISO 180/1U
-30°C	120	kJ/m ²	
23°C	140	kJ/m ²	
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature ⁶ (1.8 MPa, Unannealed, 64.0 mm Span)	109	°C	ISO 75-2/Af
Vicat Softening Temperature			
--	137	°C	ISO 306/B50
--	140	°C	ISO 306/B120
CLTE			ISO 11359-2
Flow : -30 to 80°C	5.4E-5	cm/cm/°C	
Transverse : -30 to 80°C	7.4E-5	cm/cm/°C	
Injection	Nominal Value	Unit	
Drying Temperature	110 to 120	°C	
Drying Time	4.0 to 6.0	hr	
Suggested Max Moisture	0.020	%	
Hopper Temperature	60.0 to 80.0	°C	
Rear Temperature	240 to 270	°C	
Middle Temperature	250 to 275	°C	
Front Temperature	260 to 280	°C	
Nozzle Temperature	260 to 275	°C	
Processing (Melt) Temp	265 to 275	°C	
Mold Temperature	60.0 to 100	°C	
NOTE			
1.	Tensile Bar		
2.	2.0 mm/min		
3.	80*10*4 sp=62mm		
4.	80*10*4		
5.	80*10*4		
6.	80*10*4 mm		

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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



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