

XENOY™ X5630Q resin

Polycarbonate + PET

SABIC Innovative Plastics Europe

Message:

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

General Information			
Filler / Reinforcement	Mineral filler		
Features	Good dimensional stability		
	Sprayable		
	Low shrinkage		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.35	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (265°C/5.0 kg)	20	g/10 min	ASTM D1238
Melt Volume-Flow Rate (MVR) (265°C/5.0 kg)	17.0	cm ³ /10min	ISO 1133
Molding Shrinkage - Flow ¹	0.50 - 0.70	%	Internal method
Water Absorption			ISO 62
Saturated, 23°C	0.42	%	ISO 62
Equilibrium, 23°C, 50% RH	0.14	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	4340	MPa	ISO 527-2/1
Tensile Stress			ISO 527-2/5
Yield	53.0	MPa	ISO 527-2/5
Fracture	41.0	MPa	ISO 527-2/5
Tensile Strain			ISO 527-2/5
Yield	3.3	%	ISO 527-2/5
Fracture	14	%	ISO 527-2/5
Flexural Modulus ²	4110	MPa	ISO 178
Flexural Stress	92.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ³ (23°C)	16	kJ/m ²	ISO 179/1eA
Notched Izod Impact ⁴			ISO 180/1A
-30°C	4.0	kJ/m ²	ISO 180/1A
23°C	6.0	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength ⁵			ISO 180/1U
-30°C	80	kJ/m ²	ISO 180/1U
23°C	120	kJ/m ²	ISO 180/1U

Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature ⁶ (1.8 MPa, Unannealed, 64.0 mm Span)	108	°C	ISO 75-2/Af
Vicat Softening Temperature			
--	137	°C	ISO 306/B50
--	140	°C	ISO 306/B120
Linear thermal expansion coefficient			ISO 11359-2
Flow: -30 to 80°C	3.8E-5	cm/cm/°C	ISO 11359-2
Horizontal: -30 to 80°C	1.0E-4	cm/cm/°C	ISO 11359-2
Injection	Nominal Value	Unit	
Drying Temperature	110	°C	
Drying Time	4.0 - 6.0	hr	
Drying Time, Maximum	8.0	hr	
Suggested Max Moisture	0.020	%	
Suggested Shot Size	50 - 80	%	
Rear Temperature	243 - 266	°C	
Middle Temperature	249 - 271	°C	
Front Temperature	254 - 277	°C	
Nozzle Temperature	254 - 271	°C	
Processing (Melt) Temp	260 - 277	°C	
Mold Temperature	65.6 - 87.8	°C	
Back Pressure	0.345 - 0.689	MPa	
Screw Speed	50 - 80	rpm	
Vent Depth	0.013 - 0.020	mm	
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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