

XYLEX™ X7509HP resin

Polycarbonate + Polyester
SABIC Innovative Plastics

Message:

PC+Polyester alloy. Houseware applications. USA/Europe Food contact. this grade will no longer be supported with biocompatibility information and should not be used for medical applications which require biocompatibility. Alternative grade HX7509HP.

General Information			
UL YellowCard	E121562-483059		
Features	Food Contact Acceptable		
Uses	Household Goods		
Agency Ratings	EU Food Contact, Unspecified Rating		
	FDA Food Contact, Unspecified Rating		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.20	g/cm³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (265°C/2.16 kg)	12	g/10 min	ASTM D1238
Melt Volume-Flow Rate (MVR) (265°C/2.16 kg)	11.5	cm³/10min	ISO 1133
Molding Shrinkage			Internal Method
Flow : 3.20 mm	0.40 to 0.60	%	
Across Flow : 3.20 mm	0.50 to 0.70	%	
Water Absorption			ISO 62
Saturation, 23°C	0.12	%	
Equilibrium, 23°C, 50% RH	0.050	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	2150	MPa	ASTM D638
--	2300	MPa	ISO 527-2/1
Tensile Strength			
Yield ²	60.0	MPa	ASTM D638
Yield	60.0	MPa	ISO 527-2/50
Break ³	63.0	MPa	ASTM D638
Break	62.0	MPa	ISO 527-2/50
Tensile Elongation			
Yield ⁴	6.3	%	ASTM D638
Yield	5.8	%	ISO 527-2/50
Break ⁵	140	%	ASTM D638
Break	130	%	ISO 527-2/50

Flexural Modulus			
50.0 mm Span ⁶	2300	MPa	ASTM D790
-- ⁷	2260	MPa	ISO 178
Flexural Stress			
--	92.0	MPa	ISO 178
Yield, 50.0 mm Span ⁸	95.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ⁹ (23°C)	10	kJ/m ²	ISO 179/1eA
Notched Izod Impact			
-30°C	70	J/m	ASTM D256
23°C	850	J/m	ASTM D256
-30°C ¹⁰	8.0	kJ/m ²	ISO 180/1A
23°C ¹¹	9.0	kJ/m ²	ISO 180/1A
Instrumented Dart Impact (23°C, Total Energy)	77.0	J	ASTM D3763
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed, 3.20 mm	119	°C	ASTM D648
1.8 MPa, Unannealed, 3.20 mm	106	°C	ASTM D648
1.8 MPa, Unannealed, 100 mm Span ¹²	106	°C	ISO 75-2/Ae
1.8 MPa, Unannealed, 64.0 mm Span ¹³	108	°C	ISO 75-2/Af
Vicat Softening Temperature			
--	126	°C	ASTM D1525, ISO 306/B120 12 ¹⁴
--	125	°C	ISO 306/B50
CLTE			
Flow : -40 to 40°C	1.0E-4	cm/cm/°C	ASTM E831
Flow : -40 to 40°C	6.8E-5	cm/cm/°C	ISO 11359-2
Flow : 23 to 60°C	9.0E-5	cm/cm/°C	ISO 11359-2
Transverse : -40 to 40°C	1.0E-4	cm/cm/°C	ASTM E831
Transverse : -40 to 40°C	6.8E-5	cm/cm/°C	ISO 11359-2
Transverse : 23 to 60°C	9.0E-5	cm/cm/°C	ISO 11359-2
Injection	Nominal Value	Unit	
Drying Temperature	65.6 to 79.4	°C	
Drying Time	3.0 to 5.0	hr	
Drying Time, Maximum	8.0	hr	
Suggested Max Moisture	0.020	%	
Suggested Shot Size	40 to 80	%	
Rear Temperature	243 to 260	°C	
Middle Temperature	243 to 271	°C	
Front Temperature	249 to 271	°C	
Nozzle Temperature	249 to 271	°C	
Processing (Melt) Temp	249 to 271	°C	

Mold Temperature	43.3 to 60.0	°C
Back Pressure	0.103 to 0.517	MPa
Screw Speed	20 to 100	rpm
Vent Depth	0.013 to 0.020	mm

NOTE

1.	50 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.	120*10*4 mm
13.	80*10*4 mm
14.	Rate B (120°C/h), Loading 2 (50 N)

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