

XENOY™ X2420 resin

Polycarbonate + Polyester

SABIC Innovative Plastics Asia Pacific

Message:

XENOYX2420 is a 10% glass filled, high flow, impact modified, injection moldable grade designed for high flow and impact strength. X2420 has enhanced melt flowability, impact ductility and broad color space.

General Information			
UL YellowCard	E207780-101543168		
Filler / Reinforcement	Glass Fiber,10% Filler by Weight		
Additive	Impact Modifier		
Features	Ductile		
	Good Flow		
	High Flow		
	High Impact Resistance		
	Impact Modified		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.28	g/cm ³	ASTM D792, ISO 1183
Melt Volume-Flow Rate (MVR)			ISO 1133
265°C/2.16 kg	12.0	cm ³ /10min	
300°C/1.2 kg	26.0	cm ³ /10min	
Molding Shrinkage			Internal Method
Flow : 3.20 mm	0.15 to 0.25	%	
Across Flow : 3.20 mm	0.30 to 0.40	%	
Water Absorption			ISO 62
Saturation, 23°C	0.020	%	
Equilibrium, 23°C, 50% RH	0.040	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ¹	3800	MPa	ASTM D638
Tensile Strength			
Yield ²	50.0	MPa	ASTM D638
Yield	51.0	MPa	ISO 527-2/5
Break ³	35.0	MPa	ASTM D638
Break	37.0	MPa	ISO 527-2/5
Tensile Elongation			
Yield ⁴	3.0	%	ASTM D638
Yield	3.0	%	ISO 527-2/5
Break	7.0	%	ISO 527-2/5

Flexural Modulus ⁵ (50.0 mm Span)	3500	MPa	ASTM D790
Flexural Strength ⁶ (Yield, 50.0 mm Span)	90.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ⁷			ISO 179/1eA
-30°C	7.0	kJ/m ²	
23°C	15	kJ/m ²	
Charpy Unnotched Impact Strength ⁸			ISO 179/1eU
-30°C	95	kJ/m ²	
23°C	95	kJ/m ²	
Notched Izod Impact			
23°C	210	J/m	ASTM D256
-30°C ⁹	8.0	kJ/m ²	ISO 180/1A
23°C ¹⁰	14	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	1600	J/m	ASTM D4812
-30°C ¹¹	74	kJ/m ²	ISO 180/1U
23°C ¹²	110	kJ/m ²	ISO 180/1U
Instrumented Dart Impact (23°C, Total Energy)	36.0	J	ASTM D3763
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed, 3.20 mm	111	°C	
1.8 MPa, Unannealed, 3.20 mm	101	°C	
Vicat Softening Temperature	118	°C	ISO 306/B120
CLTE			
Flow : -40 to 40°C	5.0E-5	cm/cm/°C	ASTM E831
Flow : 23 to 80°C	4.0E-5	cm/cm/°C	ISO 11359-2
Transverse : -40 to 40°C	8.0E-5	cm/cm/°C	ASTM E831
Transverse : 23 to 80°C	9.0E-5	cm/cm/°C	ISO 11359-2
RTI Elec	75.0	°C	UL 746
RTI Imp	75.0	°C	UL 746
RTI Str	75.0	°C	UL 746
Flammability	Nominal Value		Test Method
Flame Rating (0.400 mm)	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	95.0 to 105	°C	
Drying Time	3.0 to 4.0	hr	
Drying Time, Maximum	8.0	hr	
Suggested Max Moisture	0.020	%	
Suggested Shot Size	30 to 80	%	
Hopper Temperature	60.0 to 80.0	°C	
Rear Temperature	250 to 280	°C	

Middle Temperature	255 to 290	°C
Front Temperature	255 to 290	°C
Nozzle Temperature	260 to 290	°C
Processing (Melt) Temp	260 to 290	°C
Mold Temperature	60.0 to 90.0	°C
Back Pressure	0.300 to 0.700	MPa
Screw Speed	40 to 70	rpm
Vent Depth	0.038 to 0.076	mm

NOTE

1.	5.0 mm/min
2.	Type I, 5.0 mm/min
3.	Type I, 5.0 mm/min
4.	Type I, 5.0 mm/min
5.	1.3 mm/min
6.	1.3 mm/min
7.	80*10*4 sp=62mm
8.	80*10*4 sp=62mm
9.	80*10*4
10.	80*10*4
11.	80*10*4
12.	80*10*4

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