

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 Flow		
Processing Method	Injection Molding		
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 : 3.20 mm	0.40 to 0.80	%	
Across Flow : 3.20 mm	0.50 to 0.70	%	
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
Break ³	52.0	MPa	ASTM D638
Break	55.0	MPa	ISO 527-2/50
Tensile Elongation			
Yield ⁴	5.0	%	ASTM D638
Yield	5.0	%	ISO 527-2/50
Break ⁵	150	%	ASTM D638
Break	> 150	%	ISO 527-2/50
Flexural Modulus			
50.0 mm Span ⁶	1940	MPa	ASTM D790
-- ⁷	2000	MPa	ISO 178
Flexural Stress			
--	71.0	MPa	ISO 178
Yield, 50.0 mm 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, 3.20 mm	102	°C	ASTM D648
1.8 MPa, Unannealed, 3.20 mm	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
CLTE			
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
Transverse : -40 to 40°C	1.1E-4	cm/cm/°C	ASTM E831
Transverse : 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 to 93.3	°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	238 to 249	°C	
Middle Temperature	243 to 266	°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	0.172 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
10.	120*10*4 mm
11.	Rate B (120°C/h), Loading 2 (50 N)

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