

XYLEX™ X5230 resin

Polycarbonate + PET

SABIC Innovative Plastics Asia Pacific

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 filler		
Features	Good dimensional stability		
	Low CLTE		
	Sprayable		
	High liquidity		
	Heat resistance, high		
	Low shrinkage		
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 - 0.60	%	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	3990	MPa	ISO 527-2/1
Tensile Stress			ISO 527-2/5
Yield	53.0	MPa	ISO 527-2/5
Fracture	34.0	MPa	ISO 527-2/5
Tensile Strain			ISO 527-2/5
Yield	3.4	%	ISO 527-2/5
Fracture	21	%	ISO 527-2/5
Flexural Modulus ²	3820	MPa	ISO 178
Flexural Stress	90.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ³ (23°C)	14	kJ/m ²	ISO 179/1eA
Notched Izod Impact ⁴			ISO 180/1A
-30°C	6.0	kJ/m ²	ISO 180/1A
23°C	8.0	kJ/m ²	ISO 180/1A

Unnotched Izod Impact Strength ⁵			ISO 180/1U
-30°C	120	kJ/m ²	ISO 180/1U
23°C	140	kJ/m ²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature ⁶ (1.8 MPa, Unannealed, 64.0 mm Span)	100	°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	4.5E-5	cm/cm/°C	ISO 11359-2
Horizontal: -30 to 80°C	9.7E-5	cm/cm/°C	ISO 11359-2
Injection	Nominal Value	Unit	
Drying Temperature	110 - 120	°C	
Drying Time	4.0 - 6.0	hr	
Suggested Max Moisture	0.020	%	
Hopper Temperature	60 - 80	°C	
Rear Temperature	240 - 270	°C	
Middle Temperature	250 - 275	°C	
Front Temperature	260 - 280	°C	
Nozzle Temperature	260 - 275	°C	
Processing (Melt) Temp	265 - 275	°C	
Mold Temperature	60 - 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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