

XYLEX™ X8303CL resin

Polycarbonate + Polyester
SABIC Innovative Plastics Asia Pacific

Message:

PC+ POLYESTER, Transparent, Low processing Temperature, High flow with excellent impact, UV stabilized, OQ quality. For In Mold Decoration /Labeling.

General Information			
Additive	UV Stabilizer		
Features	High Flow		
	High Impact Resistance		
Uses	Labels		
Appearance	Clear/Transparent		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.20	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (265°C/2.16 kg)	30	g/10 min	ASTM D1238
Melt Volume-Flow Rate (MVR) (265°C/2.16 kg)	27.5	cm ³ /10min	ISO 1133
Molding Shrinkage - Flow (3.20 mm)	0.40 to 0.80	%	Internal Method
Water Absorption			ISO 62
Saturation, 23°C	0.50	%	
Equilibrium, 23°C, 50% RH	0.20	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	1680	MPa	ASTM D638
--	1690	MPa	ISO 527-2/1
Tensile Strength			
Yield ²	46.0	MPa	ASTM D638
Yield	48.0	MPa	ISO 527-2/50
Break ³	44.0	MPa	ASTM D638
Break	43.0	MPa	ISO 527-2/50
Tensile Elongation			
Yield ⁴	5.0	%	ASTM D638
Yield	6.0	%	ISO 527-2/50
Break ⁵	140	%	ASTM D638
Break	140	%	ISO 527-2/50
Flexural Modulus			
50.0 mm Span ⁶	1620	MPa	ASTM D790
-- ⁷	1720	MPa	ISO 178

Flexural Stress			
--	72.0	MPa	ISO 178
Yield, 50.0 mm Span ⁸	72.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ⁹ (23°C)	14	kJ/m ²	ISO 179/1eA
Notched Izod Impact			
-30°C	100	J/m	ASTM D256
23°C	1000	J/m	ASTM D256
-30°C ¹⁰	9.0	kJ/m ²	ISO 180/1A
23°C ¹¹	20	kJ/m ²	ISO 180/1A
Instrumented Dart Impact (23°C, Total Energy)	65.0	J	ASTM D3763
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed, 3.20 mm	92.0	°C	ASTM D648
1.8 MPa, Unannealed, 3.20 mm	80.0	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ¹²	90.0	°C	ISO 75-2/Af
Vicat Softening Temperature			
--	98.0	°C	ASTM D1525 ¹³
--	100	°C	ISO 306/B50, ISO 306/B120
CLTE			
Flow : -40 to 40°C	9.0E-5	cm/cm/°C	ASTM E831
Flow : 23 to 60°C	9.2E-5	cm/cm/°C	ISO 11359-2
Transverse : -40 to 40°C	9.0E-5	cm/cm/°C	ASTM E831
Transverse : 23 to 60°C	9.8E-5	cm/cm/°C	ISO 11359-2
Injection	Nominal Value	Unit	
Drying Temperature	70.0 to 80.0	°C	
Drying Time	3.0 to 5.0	hr	
Suggested Max Moisture	0.020	%	
Rear Temperature	235 to 255	°C	
Middle Temperature	235 to 265	°C	
Front Temperature	240 to 270	°C	
Nozzle Temperature	240 to 270	°C	
Processing (Melt) Temp	240 to 270	°C	
Mold Temperature	50.0 to 70.0	°C	
Screw Speed	20 to 100	rpm	
NOTE			
1.	5.0 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.	80*10*4 mm
13.	Rate B (120°C/h), Loading 2 (50 N)

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