

XYLEX™ X8409AC resin

Polycarbonate + Polyester

SABIC Innovative Plastics

Message:

PC + Polyester, Injection (Blow) Molding, or Extrusion Blow molding grade, Chemical Resistance and Transparency

General Information			
Features	Good chemical resistance		
RoHS Compliance	RoHS compliance		
Appearance	Clear/transparent		
Processing Method	Extrusion blow 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)	4.8	g/10 min	ASTM D1238
Melt Volume-Flow Rate (MVR) (265°C/2.16 kg)	3.80	cm ³ /10min	ISO 1133
Molding Shrinkage			Internal method
Flow: 3.20mm	0.50 - 0.80	%	Internal method
Transverse flow: 3.20mm	0.50 - 0.80	%	Internal method
Water Absorption			ISO 62
Saturated, 23°C	0.37	%	ISO 62
Equilibrium, 23°C, 50% RH	0.13	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	2370	MPa	ASTM D638
--	2180	MPa	ISO 527-2/1
Tensile Strength			
Yield ²	57.0	MPa	ASTM D638
Yield	60.0	MPa	ISO 527-2/50
Fracture ³	55.0	MPa	ASTM D638
Fracture	60.0	MPa	ISO 527-2/50
Tensile Elongation			
Yield ⁴	6.0	%	ASTM D638
Yield	5.8	%	ISO 527-2/50
Fracture ⁵	92	%	ASTM D638
Fracture	120	%	ISO 527-2/50
Flexural Modulus			
50.0mm span ⁶	2220	MPa	ASTM D790
-- ⁷	2000	MPa	ISO 178
Flexural Stress			

--	89.0	MPa	ISO 178
Yield, 50.0mm span ⁸	94.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ⁹ (23°C)	8.0	kJ/m ²	ISO 179/1eA
Notched Izod Impact			
-30°C	200	J/m	ASTM D256
23°C	850	J/m	ASTM D256
-30°C ¹⁰	8.0	kJ/m ²	ISO 180/1A
-10°C ¹¹	8.0	kJ/m ²	ISO 180/1A
23°C ¹²	10	kJ/m ²	ISO 180/1A
Instrumented Dart Impact (23°C, Total Energy)	70.0	J	ASTM D3763
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, unannealed, 3.20mm	116	°C	ASTM D648
1.8 MPa, unannealed, 3.20mm	104	°C	ASTM D648
1.8 MPa, unannealed, 100 mm span ¹³	102	°C	ISO 75-2/Ae
Vicat Softening Temperature			
--	123	°C	ASTM D1525, ISO 306/B120 10 ¹⁴
--	121	°C	ISO 306/B50
Linear thermal expansion coefficient			
Flow: -40 to 40°C	1.0E-4	cm/cm/°C	ASTM E831, ISO 11359-2
Flow: 23 to 60°C	6.0E-5	cm/cm/°C	ISO 11359-2
Lateral: -40 to 40°C	1.0E-4	cm/cm/°C	ASTM E831, ISO 11359-2
Lateral: 23 to 60°C	7.0E-5	cm/cm/°C	ISO 11359-2
Thermal Conductivity	0.23	W/m/K	ISO 8302
Optical	Nominal Value	Unit	Test Method
Refractive Index	1.576		ASTM D542
Transmittance (2540 µm)	88.0	%	ASTM D1003
Haze (2540 µm)	1.5	%	ASTM D1003
Extrusion	Nominal Value	Unit	
Drying Temperature	76.7 - 87.8	°C	
Drying Time	4.0 - 6.0	hr	
Suggested Max Moisture	5.0E-3 - 0.020	%	
Cylinder Zone 1 Temp.	235 - 260	°C	
Cylinder Zone 2 Temp.	235 - 260	°C	
Cylinder Zone 3 Temp.	235 - 260	°C	
Cylinder Zone 4 Temp.	235 - 260	°C	
Cylinder Zone 5 Temp.	235 - 260	°C	
Adapter Temperature	235 - 260	°C	
Extrusion instructions			

Drying Time (Cumulative): 24 hrsHead - Zone 6 - Top Temperature: 241 - 271 °CHead - Zone 7 - Bottom Temperature: 241 - 271 °CHead - Zone 7 - Middle Temperature: 241 - 271 °CMelt Temperature (Parison): 249 - 271 °CMold Temperature: 32 - 77 °C

NOTE

1.	50 mm/min
2.	Type 1, 50mm/min
3.	Type 1, 50mm/min
4.	Type 1, 50mm/min
5.	Type 1, 50mm/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
13.	120*10*4 mm
14.	标准 B (120°C/h), 载荷2 (50N)

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