

XENOY™ 1102 resin

Polycarbonate + PBT

SABIC Innovative Plastics

Message:

Unreinforced PC/polyester alloy. Excellent low temperature impact/chemical resistance to automotive fluids.

General Information			
UL YellowCard	E207780-100080987		
Features	Low temperature impact resistance		
	Good chemical resistance		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
--	1.20	g/cm ³	ASTM D792
--	1.19	g/cm ³	ISO 1183
Specific Volume	0.830	cm ³ /g	ASTM D792
Melt Volume-Flow Rate (MVR) (250°C/2.16 kg)	6.00	cm ³ /10min	ISO 1133
Molding Shrinkage			Internal method
Flow: 3.20mm	0.80 - 1.0	%	Internal method
Transverse flow: 3.20mm	0.80 - 1.0	%	Internal method
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength			
Yield ¹	54.5	MPa	ASTM D638
Yield	50.0	MPa	ISO 527-2/50
Fracture	45.0	MPa	ISO 527-2/50
Tensile Strain			
Yield	4.5	%	ISO 527-2/50
Fracture ²	150	%	ASTM D638
Fracture	120	%	ISO 527-2/50
Flexural Modulus			
50.0mm span ³	1970	MPa	ASTM D790
-- ⁴	1880	MPa	ISO 178
Flexural Stress			
--	72.0	MPa	ISO 178
Yield, 50.0mm span ⁵	82.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
-30°C	640	J/m	ASTM D256

0°C	690	J/m	ASTM D256
23°C	800	J/m	ASTM D256
-30°C ⁶	44	kJ/m ²	ISO 180/1A
0°C ⁷	52	kJ/m ²	ISO 180/1A
23°C ⁸	51	kJ/m ²	ISO 180/1A

Thermal	Nominal Value	Unit	Test Method
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Deflection Temperature Under Load

0.45 MPa, unannealed, 6.40mm	110	°C	ASTM D648
0.45 MPa, unannealed, 64.0mm span ⁹	103	°C	ISO 75-2/Bf
1.8 MPa, unannealed, 6.40mm	90.6	°C	ASTM D648
1.8 MPa, unannealed, 64.0mm span ¹⁰	79.4	°C	ISO 75-2/Af

Injection	Nominal Value	Unit
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Drying Temperature	110	°C
Drying Time	4.0 - 6.0	hr
Drying Time, Maximum	8.0	hr
Suggested Max Moisture	0.020	%
Suggested Shot Size	50 - 80	%
Rear Temperature	243 - 266	°C
Middle Temperature	249 - 271	°C
Front Temperature	254 - 277	°C
Nozzle Temperature	254 - 271	°C
Processing (Melt) Temp	260 - 277	°C
Mold Temperature	65.6 - 87.8	°C
Back Pressure	0.345 - 0.689	MPa
Screw Speed	50 - 80	rpm
Vent Depth	0.013 - 0.020	mm

NOTE

1.	Type 1, 50mm/min
2.	Type 1, 50mm/min
3.	1.3 mm/min
4.	2.0 mm/min
5.	1.3 mm/min
6.	80*10*4
7.	80*10*4
8.	80*10*4
9.	80*10*4 mm
10.	80*10*4 mm

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