

XENOY™ X5100 resin

Polycarbonate + Polyester
SABIC Innovative Plastics Europe

Message:

XENOY X5100 is a semi-crystalline, impact modified PC-PBT blend with excellent flow. (PC+PBT-I).

General Information			
UL YellowCard	E45329-100750700		
Additive	Impact Modifier		
Features	Good Flow		
	Impact Modified		
	Semi Crystalline		
RoHS Compliance	RoHS Compliant		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.22	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (250°C/2.16 kg)	13.0	cm ³ /10min	ISO 1133
Molding Shrinkage - Flow ¹	0.70 to 1.0	%	Internal Method
Water Absorption			ISO 62
Saturation, 23°C	0.50	%	
Equilibrium, 23°C, 50% RH	0.15	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2150	MPa	ISO 527-2/1
Tensile Stress			ISO 527-2/50
Yield	54.0	MPa	
Break	40.0	MPa	
Tensile Strain			ISO 527-2/50
Yield	4.5	%	
Break	50	%	
Flexural Modulus ²	2050	MPa	ISO 178
Flexural Stress	80.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-30°C ³	15	kJ/m ²	
0°C ⁴	40	kJ/m ²	
23°C ⁵	50	kJ/m ²	
Charpy Unnotched Impact Strength ⁶ (-30°C)	No Break		ISO 179/1eU
Notched Izod Impact Strength ⁷			ISO 180/1A

-30°C	18	kJ/m ²	
-20°C	20	kJ/m ²	
-10°C	35	kJ/m ²	
0°C	40	kJ/m ²	
23°C	45	kJ/m ²	
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature ⁸			
0.45 MPa, Unannealed, 100 mm Span	105	°C	ISO 75-2/Be
1.8 MPa, Unannealed, 100 mm Span	84.0	°C	ISO 75-2/Ae
Vicat Softening Temperature			
--	135	°C	ISO 306/A50
--	117	°C	ISO 306/B50
--	120	°C	ISO 306/B120
Ball Pressure Test (75°C)	Pass		IEC 60695-10-2
CLTE			ISO 11359-2
Flow : 23 to 80°C	8.5E-5	cm/cm/°C	
Transverse : -40 to 40°C	8.0E-5	cm/cm/°C	
Thermal Conductivity	0.20	W/m/K	ISO 8302
Fill Analysis	Nominal Value	Unit	Test Method
Melt Viscosity (260°C, 1500 sec ⁻¹)	215	Pa · s	ISO 11443
Injection	Nominal Value	Unit	
Drying Temperature	90.0 to 100	°C	
Drying Time	2.0 to 4.0	hr	
Suggested Max Moisture	0.020	%	
Hopper Temperature	40.0 to 60.0	°C	
Rear Temperature	230 to 250	°C	
Middle Temperature	240 to 265	°C	
Front Temperature	250 to 270	°C	
Nozzle Temperature	250 to 265	°C	
Processing (Melt) Temp	255 to 270	°C	
Mold Temperature	60.0 to 80.0	°C	
NOTE			
1.	Tensile Bar		
2.	2.0 mm/min		
3.	80*10*4 sp=62mm		
4.	80*10*3 sp=62mm		
5.	80*10*4 sp=62mm		
6.	80*10*4 sp=62mm		
7.	80*10*4		
8.	120*10*4 mm		

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