

XENOY™ X2300WX resin

Polycarbonate + PET

SABIC Innovative Plastics

Message:

Unreinforced, opaque PC+PET alloy. Chemical resistance, dimensional stability/mechanical performance. UV-stabilized.

General Information			
Additive	UV stabilizer		
Features	UV Stabilized		
	Good dimensional stability		
	Good chemical resistance		
Appearance	Opacity		
Processing Method	Injection molding		
Multi-Point Data	Coefficient of Thermal Expansion vs. Temperature (ASTM E831)		
	Flexural DMA (ASTM D4065)		
	Pressure-Volume-Temperature (PVT - Zoller Method)		
	Specific Heat vs. Temperature (ASTM D3417)		
	Tensile Fatigue		
	Tensile Stress vs. Strain (ASTM D638)		
	Thermal Conductivity vs. Temperature (ASTM E1530)		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.21	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (266°C/5.0 kg)	35	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm)	0.80 - 1.0	%	Internal method
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ¹	2410	MPa	ASTM D638
Tensile Strength ²			ASTM D638
Yield	58.6	MPa	ASTM D638
Fracture	44.8	MPa	ASTM D638
Tensile Elongation ³			ASTM D638
Yield	5.0	%	ASTM D638
Fracture	120	%	ASTM D638
Flexural Modulus ⁴ (50.0 mm Span)	2210	MPa	ASTM D790
Flexural Strength ⁵ (Yield, 50.0 mm Span)	86.2	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	640	J/m	ASTM D256
Instrumented Dart Impact (23°C, Total Energy)	48.6	J	ASTM D3763

Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, unannealed, 3.20mm	127	°C	ASTM D648
1.8 MPa, unannealed, 3.20mm	110	°C	ASTM D648
Linear thermal expansion coefficient			ASTM E831
Flow: -40 to 40°C	7.2E-5	cm/cm/°C	ASTM E831
Lateral: -40 to 40°C	7.2E-5	cm/cm/°C	ASTM E831
Injection	Nominal Value	Unit	
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	249 - 271	°C	
Middle Temperature	254 - 277	°C	
Front Temperature	260 - 282	°C	
Nozzle Temperature	254 - 277	°C	
Processing (Melt) Temp	260 - 282	°C	
Mold Temperature	66 - 93	°C	
Back Pressure	0.345 - 0.552	MPa	
Screw Speed	50 - 80	rpm	
Vent Depth	0.013 - 0.020	mm	
NOTE			
1.	50 mm/min		
2.	Type 1, 50mm/min		
3.	Type 1, 50mm/min		
4.	1.3 mm/min		
5.	1.3 mm/min		

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