

XYLEX™ X7507 resin

Polycarbonate + Polyester

SABIC Innovative Plastics

Message:

F-1 weathering certified in natural color, specially designed for Pool & Spa applications. Currently available in natural color only.

General Information			
UL YellowCard	E45329-100134007		
Uses	Mineral spring recuperation supplies		
RoHS Compliance	RoHS compliance		
Appearance	Natural color		
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)	8.0	g/10 min	ASTM D1238
Melt Volume-Flow Rate (MVR) (265°C/2.16 kg)	5.00	cm ³ /10min	ISO 1133
Molding Shrinkage - Flow (3.20 mm)	0.50 - 0.80	%	Internal method
Water Absorption			ISO 62
Saturated, 23°C	0.32	%	ISO 62
Equilibrium, 23°C, 50% RH	0.12	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	2300	MPa	ASTM D638
--	2660	MPa	ISO 527-2/1
Tensile Strength			
Yield ²	61.0	MPa	ASTM D638
Yield	62.0	MPa	ISO 527-2/50
Fracture ³	65.0	MPa	ASTM D638
Fracture	59.0	MPa	ISO 527-2/50
Tensile Elongation			
Yield ⁴	6.0	%	ASTM D638
Yield	5.4	%	ISO 527-2/50
Fracture ⁵	130	%	ASTM D638
Fracture	110	%	ISO 527-2/50
Flexural Modulus			
50.0mm span ⁶	2320	MPa	ASTM D790
-- ⁷	2190	MPa	ISO 178
Flexural Stress			
--	92.0	MPa	ISO 178

Yield, 50.0mm span ⁸	96.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ⁹ (23°C)	20	kJ/m ²	ISO 179/1eA
Notched Izod Impact			
-30°C	200	J/m	ASTM D256
23°C	990	J/m	ASTM D256
-30°C ¹⁰	6.0	kJ/m ²	ISO 180/1A
23°C ¹¹	9.0	kJ/m ²	ISO 180/1A
Instrumented Dart Impact (23°C, Total Energy)	79.0	J	ASTM D3763
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
1.8 MPa, unannealed, 3.20mm	104	°C	ASTM D648
1.8 MPa, unannealed, 64.0mm span ¹²	105	°C	ISO 75-2/ Af
Vicat Softening Temperature			
--	125	°C	ASTM D1525, ISO 306/B50 11 ¹³
--	127	°C	ISO 306/B120
Linear thermal expansion coefficient			
Flow: -40 to 40°C	6.0E-5	cm/cm/°C	ASTM E831, ISO 11359-2
Lateral: -40 to 40°C	7.0E-5	cm/cm/°C	ASTM E831
Lateral: -40 to 40°C	6.3E-5	cm/cm/°C	ISO 11359-2
Optical	Nominal Value	Unit	Test Method
Transmittance (2540 µm)	> 85.0	%	ASTM D1003
Haze (2540 µm)	1.6	%	ASTM D1003
Injection	Nominal Value	Unit	
Drying Temperature	82.2 - 93.3	°C	
Drying Time	3.0 - 5.0	hr	
Drying Time, Maximum	8.0	hr	
Suggested Max Moisture	0.020	%	
Suggested Shot Size	40 - 80	%	
Rear Temperature	238 - 249	°C	
Middle Temperature	243 - 266	°C	
Front Temperature	249 - 271	°C	
Nozzle Temperature	249 - 271	°C	
Processing (Melt) Temp	249 - 271	°C	
Mold Temperature	43.3 - 60.0	°C	
Back Pressure	0.172 - 0.517	MPa	
Screw Speed	20 - 100	rpm	
Vent Depth	0.013 - 0.020	mm	
NOTE			
1.	5.0 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 mm
13.	标准 B (120°C/h), 载荷2 (50N)

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