

XYLEXTM RESIN X8519

REGION AMERICAS

DESCRIPTION

PC+POLYESTER, Injection Molding Transparency

TYPICAL PROPERTY VALUES

Revision 20181012

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	57	MPa	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	45	MPa	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	6	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	91	%	ASTM D 638
Tensile Modulus, 50 mm/min	2000	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	83	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	2170	MPa	ASTM D 790
Tensile Stress, yield, 50 mm/min	56	MPa	ISO 527
Tensile Stress, break, 50 mm/min	52	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	6	%	ISO 527
Tensile Strain, break, 50 mm/min	118	%	ISO 527
Tensile Modulus, 1 mm/min	1940	MPa	ISO 527
Flexural Stress, break, 2 mm/min	85	MPa	ISO 178
Flexural Modulus, 2 mm/min	1900	MPa	ISO 178
IMPACT			
Izod Impact, notched, 23°C	483	J/m	ASTM D 256
Izod Impact, notched, -30°C	35	J/m	ASTM D 256
Instrumented Impact Total Energy, 23°C	67	J	ASTM D 3763
Izod Impact, notched 80°10'4 +23°C	14	kJ/m ²	ISO 180/1A
Izod Impact, notched 80°10'4 -10°C	7	kJ/m ²	ISO 180/1A
Izod Impact, notched 80°10'4 -30°C	6	kJ/m ²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80°10'4 sp=62mm	22	kJ/m ²	ISO 179/1eA
THERMAL			
Vicat Softening Temp, Rate B/50	112	°C	ASTM D 1525
HDT, 0.45 MPa, 3.2 mm, unannealed	107	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	95	°C	ASTM D 648
CTE, -40°C to 40°C, flow	6.46E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	6.48E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, flow	6.4E-06	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	6.38E-05	1/°C	ISO 11359-2
CTE, 23°C to 60°C, flow	6.47E-05	1/°C	ISO 11359-2
CTE, 23°C to 60°C, xflow	6.66E-05	1/°C	ISO 11359-2
Vicat Softening Temp, Rate B/50	113	°C	ISO 306
Vicat Softening Temp, Rate B/120	116	°C	ISO 306
HDT/Ae, 1.8 MPa Edgew 120°10'4 sp=100mm	97	°C	ISO 75/Ae

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
PHYSICAL			
Specific Gravity	1.21	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	0.47	%	SABIC method
Mold Shrinkage, xflow, 3.2 mm	0.48	%	SABIC method
Melt Flow Rate, 265°C/2.16kgf	13	g/10 min	ASTM D 1238
Density	1.21	g/cm ³	ISO 1183
Moisture Absorption (23°C / 50% RH)	0.23	%	ISO 62
Melt Volume Rate, MVR at 265°C/2.16 kg	12	cm ³ /10 min	ISO 1133
OPTICAL			
Light Transmission, 2.54 mm	87	%	ASTM D 1003
Haze, 2.54 mm	0.3	%	ASTM D 1003
INJECTION MOLDING			
Drying Temperature	65 – 75	°C	
Drying Time	3 – 5	hrs	
Drying Time (Cumulative)	8	hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	245 – 265	°C	
Nozzle Temperature	245 – 265	°C	
Front - Zone 3 Temperature	245 – 265	°C	
Middle - Zone 2 Temperature	240 – 260	°C	
Rear - Zone 1 Temperature	240 – 250	°C	
Mold Temperature	45 – 60	°C	
Back Pressure	0.2 – 0.5	MPa	
Screw Speed	20 – 100	rpm	
Shot to Cylinder Size	40 – 80	%	
Vent Depth	0.013 – 0.02	mm	

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