

Xylex * Resin X8303CL

Europe-Africa-Middle East: COMMERCIAL

Low processing Temperature, high flow with excellent impact. For In Mold Decoration /Labeling.

Property

TYPICAL PROPERTIES ⁽¹⁾			
	Value	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	46	MPa	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	44	MPa	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	5	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	140	%	ASTM D 638
Tensile Modulus, 5 mm/min	1680	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	72	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	1620	MPa	ASTM D 790
Tensile Stress, yield, 50 mm/min	48	MPa	ISO 527
Tensile Stress, break, 50 mm/min	43	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	6	%	ISO 527
Tensile Strain, break, 50 mm/min	140	%	ISO 527
Tensile Modulus, 1 mm/min	1690	MPa	ISO 527
Flexural Stress, break, 2 mm/min	72	MPa	ISO 178
Flexural Modulus, 2 mm/min	1720	MPa	ISO 178
IMPACT			
	Value	Unit	Standard
Izod Impact, notched, 23°C	1000	J/m	ASTM D 256
Izod Impact, notched, -30°C	100	J/m	ASTM D 256
Instrumented Impact Total Energy, 23°C	65	J	ASTM D 3763
Izod Impact, notched 80*10*4 +23°C	20	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	9	kJ/m ²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	14	kJ/m ²	ISO 179/1eA
THERMAL			
	Value	Unit	Standard
Vicat Softening Temp, Rate B/50	98	°C	ASTM D 1525
HDT, 0.45 MPa, 3.2 mm, unannealed	92	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	80	°C	ASTM D 648
CTE, -40°C to 40°C, flow	9.E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	9.E-05	1/°C	ASTM E 831
CTE, 23°C to 60°C, flow	9.2E-05	1/°C	ISO 11359-2
CTE, 23°C to 60°C, xflow	9.8E-05	1/°C	ISO 11359-2
Vicat Softening Temp, Rate B/50	100	°C	ISO 306
Vicat Softening Temp, Rate B/120	100	°C	ISO 306
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	90	°C	ISO 75/Af
PHYSICAL			
	Value	Unit	Standard
Specific Gravity	1.2	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	0.4 - 0.8	%	SABIC Method
Melt Flow Rate, 265°C/2.16kg	32	g/10 min	ASTM D 1238
Density	1.2	g/cm ³	ISO 1183
Water Absorption, (23°C/sat)	0.5	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.2	%	ISO 62

Melt Volume Rate, MVR at 265°C/2.16 kg	30	cm ³ /10 min	ISO 1133
OPTICAL	Value	Unit	Standard
Light Transmission	88	%	ASTM D 1003
Haze	2	%	ASTM D 1003

Source GMD, last updated:01/04/2008

Processing

Parameter	Value	Unit
Injection Molding		
Drying Temperature	70 - 80	°C
Drying Time	3 - 5	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	240 - 270	°C
Nozzle Temperature	240 - 270	°C
Front - Zone 3 Temperature	240 - 270	°C
Middle - Zone 2 Temperature	235 - 265	°C
Rear - Zone 1 Temperature	235 - 255	°C
Mold Temperature	50 - 70	°C
Screw Speed	20 - 100	rpm

Source GMD, last updated:01/04/2008

THESE PROPERTY VALUES ARE NOT INTENDED FOR SPECIFICATION PURPOSES.

PLEASE CHECK WITH YOUR [\(LOCAL SALES OFFICE\)](#) FOR AVAILABILITY IN YOUR REGION

(1) Typical values only. Variations within normal tolerances are possible for various colors. All values are measured after at least 48 hours storage at 23°C/50% relative humidity. All properties, except the melt volume and melt flow rates, are measured on injection molded samples. All samples tested under ISO test standards are prepared according to ISO 294.

(2) Only typical data for selection purposes. Not to be used for part or tool design.

(3) This rating is not intended to reflect hazards presented by this or any other material under actual fire conditions.

(4) Internal measurements according to UL standards.

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