

Xylex * Resin X7325WX

Americas: COMMERCIAL

PC+Polyester, UV-Stabilized, Weatherable, Opaque

Property

TYPICAL PROPERTIES ⁽¹⁾			
	Value	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	40	MPa	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	32	MPa	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	4.7	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	120	%	ASTM D 638
Tensile Modulus, 50 mm/min	1440	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	56	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	1580	MPa	ASTM D 790
Tensile Stress, yield, 50 mm/min	40	MPa	ISO 527
Tensile Stress, break, 50 mm/min	32	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	4.2	%	ISO 527
Tensile Strain, break, 50 mm/min	119	%	ISO 527
Flexural Stress, yield, 2 mm/min	47	MPa	ISO 178
Flexural Modulus, 2 mm/min	1480	MPa	ISO 178
IMPACT			
Izod Impact, notched, 23°C	640	J/m	ASTM D 256
Izod Impact, notched, -30°C	64	J/m	ASTM D 256
Instrumented Impact Total Energy, 23°C	85	J	ASTM D 3763
Izod Impact, notched 80*10*4 +23°C	44	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	4	kJ/m ²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	46	kJ/m ²	ISO 179/1eA
THERMAL			
Vicat Softening Temp, Rate B/50	79	°C	ASTM D 1525
HDT, 0.45 MPa, 3.2 mm, unannealed	75	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	65	°C	ASTM D 648
Vicat Softening Temp, Rate B/50	79	°C	ISO 306
Vicat Softening Temp, Rate B/120	81	°C	ISO 306
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	64	°C	ISO 75/Af
PHYSICAL			
Specific Gravity	1.16	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	0.5 - 0.8	%	SABIC Method
Mold Shrinkage, xflow, 3.2 mm	0.5 - 0.8	%	SABIC Method
Melt Flow Rate, 266°C/5.0 kgf	42	g/10 min	ASTM D 1238
Density	1.15	g/cm ³	ISO 1183
Melt Flow Rate, 250°C/5.0 kg	19	g/10 min	ISO 1133
Melt Volume Rate, MVR at 265°C/5.0 kg	35	cm ³ /10 min	ISO 1133

Source GMD, last updated:09/28/2004

Processing

Parameter

Injection Molding	Value	Unit
Drying Temperature	30 - 50	°C
Drying Time	3 - 5	hrs
Drying Time (Cumulative)	7	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	230 - 265	°C
Nozzle Temperature	230 - 265	°C
Front - Zone 3 Temperature	230 - 265	°C
Middle - Zone 2 Temperature	240 - 260	°C
Rear - Zone 1 Temperature	240 - 250	°C
Mold Temperature	25 - 55	°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

Source GMD, last updated:09/28/2004

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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