

Xylex * Resin EXXY0021

Americas: DEVELOPMENTAL

Will be commercialized as FXX285DM. PRELIMINARY. Transparent PC+polyester alloy with DIAMOND SPARKLE additives. Low temperature impact. Color package may affect performance.

Property

TYPICAL PROPERTIES ⁽¹⁾			
MECHANICAL	Value	Unit	Standard
Tensile Stress, yld, Type I, 50 mm/min	42	MPa	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	41	MPa	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	4.5	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	125	%	ASTM D 638
Tensile Modulus, 50 mm/min	1440	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	64	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	1620	MPa	ASTM D 790
IMPACT	Value	Unit	Standard
Izod Impact, notched, 23°C	694	J/m	ASTM D 256
Izod Impact, notched, -20°C	528	J/m	ASTM D 256
Izod Impact, notched, -30°C	240	J/m	ASTM D 256
Instrumented Impact Total Energy, 23°C	51	J	ASTM D 3763
Instrumented Impact Total Energy, -30°C	56	J	ASTM D 3763
Izod Impact, notched 80*10*4 +23°C	50	kJ/m ²	ISO 180/1A
THERMAL	Value	Unit	Standard
Vicat Softening Temp, Rate B/50	92	°C	ASTM D 1525
HDT, 0.45 MPa, 3.2 mm, unannealed	78	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	75	°C	ASTM D 648
PHYSICAL	Value	Unit	Standard
Specific Gravity	1.45	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	0.5 - 0.7	%	SABIC Method
Mold Shrinkage, xflow, 3.2 mm	0.6 - 0.7	%	SABIC Method
Melt Flow Rate, 265°C/2.16kg	8	g/10 min	ASTM D 1238

Source GMD, last updated:08/22/2003

Processing

Parameter	Value	Unit
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

Source GMD, last updated:08/22/2003

- Parts may initially appear hazy directly from the mold, but will clear upon reaching ambient temperature.

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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