



Xylex * Resin FXY310DM

Americas: COMMERCIAL

PC+Polyester alloy in special effects colors. Impact Modified

Property

MECHANICAL Value Unit Standard	TYPICAL PROPERTIES (1)			
Tensile Stress, brk, Type I, 50 mm/min Tensile Strain, yld, Type I, 50 mm/min 4.5 % ASTM D 638 Tensile Strain, jud, Type I, 50 mm/min 1.25 % ASTM D 638 Tensile Strain, jud, Type I, 50 mm/min 1.25 % ASTM D 638 Tensile Modulus, 50 mm/min 1.450 MPa ASTM D 638 Tensile Modulus, 50 mm/min 1.450 MPa ASTM D 638 Tensile Modulus, 1.3 mm/min, 50 mm span 6.4 MPa ASTM D 790 Flexural Modulus, 1.3 mm/min, 50 mm span 1.620 MPa ASTM D 790 Tensile Stress, yield, 50 mm/min 3.9 MPa ISO 527 Tensile Stress, break, 50 mm/min 3.9 MPa ISO 527 Tensile Stress, break, 50 mm/min 3.6 % ISO 527 Tensile Strain, break, 50 mm/min 1.27.7 % ISO 527 Tensile Strain, break, 50 mm/min 1.27.7 % ISO 527 Tensile Modulus, 1 mm/min 1.690 MPa ISO 527 Tensile Modulus, 2 mm/min 1.430 MPa ISO 527 Tensile Modulus, 2 mm/min 1.440 MPa ISO 527 Tensile Modulus, 2 mm/min 1.450 MPa ISO 527 Tensile Modulus, 2 mm/min 1.450 MPa ISO 527 Tensile Modulus, 2 mm/min 1.450 MPa ISO 527 Tensile Stress, break, 50 mm/min 1.450 MPa ISO 527 Tensile Modulus, 2 mm/min 1.450 MPa ISO 527 Tensile Stress, break, 50 mm/min 1.450 MPa ISO 527 Tensile Stress, break, 50 mm/min 1.450 MPa ISO 527 Tensile Stress, break, 50 mm/min 1.450 MPa ISO 527 Tensile Stress, break, 50 mm/min 1.450 MPa ISO 527 Tensile Stress, break, 50 mm/min 1.450 MPa ISO 527 Tensile Stress, break, 50 mm/min 1.450 MPa ISO 527 Tensile Stress, break, 50 mm/min 1.450 MPa ISO 527 Tensile Stress, break, 50 mm/min 1.450 MPa ISO 527 Tensile Stress, break, 50 mm/min 1.450 MPa ISO 527 Tensile Stress, yld, 50 mm/min 1.450 MPa ISO 527 Tensile Stress, yld, 50 mm/min 1.450 MPa ISO 527 Tensile Stress, yld, 50 mm/min 1.450 MPa ISO 527 Tensile Stress, yld, 50 mm/min 1.450 MPa ISO 527 Tensile Stress, yld, 50 mm/min 1.450 MPa ISO 527 Tensile Stress, yld, 10 mm/min 1.450 MPa ISO 527 Tensile	MECHANICAL	Value	Unit	Standard
Tensile Strain, yld, Type I, 50 mm/min	Tensile Stress, yld, Type I, 50 mm/min	42	MPa	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min 1125 % ASTM D 638 Tensile Modulus, 50 mm/min 11450 MPa ASTM D 638 Tensile Modulus, 50 mm/min 11450 MPa ASTM D 638 Tensile Modulus, 1.3 mm/min, 50 mm span 164 MPa ASTM D 790 Flexural Modulus, 1.3 mm/min, 50 mm span 1620 MPa ASTM D 790 Tensile Stress, yield, 50 mm/min 189 MPa ISO 527 Tensile Stress, piedk, 50 mm/min 199 MPa ISO 527 Tensile Stress, piedk, 50 mm/min 190 MPa ISO 527 Tensile Strain, break, 50 mm/min 1127.7 % ISO 527 Tensile Strain, break, 50 mm/min 1127.7 % ISO 527 Tensile Modulus, 1 mm/min 11690 MPa ISO 527 Tensile Modulus, 2 mm/min 11430 MPa ISO 527 Tensile Strain, break, 50 mm/min 11430 MPa ISO 527 Tensile Strain, break, 50 mm/min 11430 MPa ISO 527 Tensile Strain, break, 50 mm/min 11430 MPa ISO 527 Tensile Strain, break, 50 mm/min 11430 MPa ISO 527 Tensile Strain, break, 50 mm/min 11430 MPa ISO 527 Tensile Strain, break, 50 mm/min 11430 MPa ISO 527 Tensile Strain, break, 50 mm/min 11430 MPa ISO 527 Tensile Strain, preak 50 MPa ISO 527 Tensile Strain	Tensile Stress, brk, Type I, 50 mm/min	41	MPa	ASTM D 638
Tensile Modulus, 50 mm/min Flexural Stress, yld, 1.3 mm/min, 50 mm span Flexural Stress, yld, 1.3 mm/min, 50 mm span 1620 MPa ASTM D 790 Flexural Modulus, 1.3 mm/min, 50 mm span 1620 MPa ASTM D 790 Tensile Stress, yield, 50 mm/min 39 MPa ISO 527 Tensile Stress, break, 50 mm/min 39 MPa ISO 527 Tensile Strain, break, 50 mm/min 127.7 % ISO 527 Tensile Strain, break, 50 mm/min 127.7 % ISO 527 Tensile Modulus, 1 mm/min 1690 MPa ISO 527 Tensile Modulus, 2 mm/min 1690 MPa ISO 527 Tensile Strain, preak 50 mm/min 1890 MPa ISO 152 J ASTM D 256 Instrumented Impact Total Energy, 23°C 481 M D 256 ISO 180/1A Izod Impact, notched, 20°C ASTM D 648 ISO 178/16A Value Unit Standard Vicat Softening Temp, Rate B/50 92 °C ASTM D 648 The The Male Tengery 100 ASTM D 648 The The The Male Tengery 100 ASTM D 648 The	Tensile Strain, yld, Type I, 50 mm/min	4.5	%	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span flexural Modulus, 50 mm/min flexibress, break, 50 mm/min flexibress, break, 50 mm/min gay MPa ISO 527 flexile Stress, break, 50 mm/min gay MPa ISO 527 flexile Strain, break, 50 mm/min flexibress, 50 mm/min	Tensile Strain, brk, Type I, 50 mm/min	125	%	ASTM D 638
Flexural Modulus, 1.3 mm/min, 50 mm span 1620 MPa ASTM D 790 Tensile Stress, yield, 50 mm/min 39 MPa ISO 527 Tensile Stress, break, 50 mm/min 39 MPa ISO 527 Tensile Strein, yield, 50 mm/min 36 A ISO 527 Tensile Strain, yield, 50 mm/min 37 A ISO 527 Tensile Strain, yield, 50 mm/min 38 A ISO 527 Tensile Strain, yield, 50 mm/min 39 MPa ISO 527 Tensile Strain, yield, 50 mm/min 127.7 % ISO 527 Tensile Strain, break, 50 mm/min 127.7 % ISO 527 Tensile Modulus, 2 mm/min 1430 MPa ISO 527 Tensile Modulus, 2 mm/min 1430 MPa ISO 178 Tensile Modulus, 2 mm/min 1430 MPa ISO 178 Tensile Modulus, 2 mm/min 1430 MPa ISO 178 Tensile Modulus, 2 mm/min 1430 MPa ISO 180 Tensile Modulus, 2 mm/min 1430 MPa 150 180 Tensile Modulus, 2 mm/min 1660 Tensile Modulus, 2 mm/min 1660 Tensile Modulus, 2 mm/min 1660 Tensile	Tensile Modulus, 50 mm/min	1450	MPa	ASTM D 638
Tensile Stress, yield, 50 mm/min Tensile Stress, break, 50 mm/min 39 MPa ISO 527 Tensile Stress, break, 50 mm/min 30 MPa ISO 527 Tensile Strain, yield, 50 mm/min 31 MPa ISO 527 Tensile Strain, pield, 50 mm/min 32 MPa ISO 527 Tensile Strain, pield, 50 mm/min 32 MPa ISO 527 Tensile Strain, preak, 50 mm/min 38 MPa ISO 527 Tensile Strain, preak, 50 mm/min 39 MPa ISO 527 Tensile Strain, preak, 50 mm/min 30 MPa ISO 527 Tensile Modulus, 1 mm/min 30 MPa ISO 527 Tensile Modulus, 2 mm/min 30 MPa ISO 527 Tensile Modulus, 2 mm/min 41 MPaCT 41 Wue 41 Standard 42 ISO 178 42 J/m ASTM D 256 43 kJ/m² ISO 180/1A 42 ISO 178/1A 42 ISO 178/1A 42 ISO 180/1A 42 ISO 180/1A 43 ISO 180/1A 43 ISO 180/1A 44 ISO 179/1eA 45 ISO 180/1A 46 KJ/m² ISO 180/1A 47 ISO 180/1A 48 ISO 179/1eA 48 ISO 179/1eA 49 KJ/m² ISO 180/1A 49 ISO 179/1eA 40 ISO 180/1A 40 ISO 180/	Flexural Stress, yld, 1.3 mm/min, 50 mm span	64	MPa	ASTM D 790
Tensile Stress, break, 50 mm/min 39 MPa ISO 527 Tensile Strain, yield, 50 mm/min 3.6 % ISO 527 Tensile Strain, break, 50 mm/min 127.7 % ISO 527 Tensile Modulus, 1 mm/min 1690 MPa ISO 527 Flexural Modulus, 2 mm/min 1430 MPa ISO 527 Flexural Modulus, 2 mm/min 1430 MPa ISO 178 IMPACT Value Unit Standard Izod Impact, notched, 23°C 694 J/m ASTM D 256 Instrumented Impact Total Energy, 23°C 52 J ASTM D 256 Instrumented Impact Total Energy, 23°C 52 J ASTM D 256 Ison Impact, notched 80°10°4 +23°C 49 kJ/m² ISO 180/1A Izod Impact, notched 80°10°4 +23°C 49 kJ/m² ISO 180/1A Izod Impact, notched 80°10°4 +23°C 49 kJ/m² ISO 180/1A Izod Impact, notched 80°10°4 +23°C 49 kJ/m² ISO 180/1A Izod Impact, notched 80°10°4 +23°C 49 kJ/m² ISO 180/1A <t< td=""><td>Flexural Modulus, 1.3 mm/min, 50 mm span</td><td>1620</td><td>MPa</td><td>ASTM D 790</td></t<>	Flexural Modulus, 1.3 mm/min, 50 mm span	1620	MPa	ASTM D 790
Tensile Strain, yield, 50 mm/min 3.6 % ISO 527 Tensile Strain, break, 50 mm/min 127.7 % ISO 527 Tensile Modulus, 1 mm/min 1690 MPa ISO 527 Tensile Modulus, 2 mm/min 1430 MPa ISO 178 IMPACT Value Unit Standard Izod Impact, notched, 23°C 694 J/m ASTM D 256 Izod Impact, notched, -20°C 529 J/m ASTM D 256 Instrumented Impact Total Energy, 23°C 52 J ASTM D 3763 Izod Impact, notched 80°10°4 +23°C 499 KJ/m² ISO 180/1A Izod Impact, notched 80°10°4 -10°C 36 KJ/m² ISO 180/1A Izod Impact, notched 80°10°4 -10°C 36 KJ/m² ISO 180/1A Tensile Modulus, 2 mm/min 66 KJ/m² ISO 180/1A Thermal Value Unit Standard Vical Softening Temp, Rate B/50 92 °C ASTM D 1525 HDT, 0.45 MPa, 3.2 mm, unannealed 75 °C ASTM D 648 HDT, 1.82 MPa, 3.2 mm, unannealed 75 °C ASTM D 648 CTE, -40°C to 40°C, flow 8.3E-05 1/°C ASTM E 831 CTE, -40°C to 40°C, xflow 8.78E-05 1/°C ASTM E 831 Vicat Softening Temp, Rate B/50 93 °C ISO 306 Vicat Softening Temp, Rate B/50 93 °C ISO 306 Vicat Softening Temp, Rate B/50 94 °C ISO 306 Vicat Softening Temp, Rate B/120 94 °C ISO 306 HDT/Ae, 1.8 MPa Edgew 120°10°4 sp=100mm 76 °C ISO 75/Ae PHYSICAL Value Unit Standard Specific Gravity 1.15 - ASTM D 792 Mold Shrinkage, flow, 3.2 mm 0.5 · 0.7 % SABIC Method Mold Shrinkage, xflow, 3.2 mm ASTM D 1238 Water Absorption, (23°C/sat) 9.021 % ISO 62	Tensile Stress, yield, 50 mm/min	39	MPa	ISO 527
Tensile Strain, break, 50 mm/min 127.7 % ISO 527 Tensile Modulus, 1 mm/min 1690 MPa ISO 527 Tensile Modulus, 2 mm/min 1430 MPa ISO 178 MPACT Value Unit Standard Izod Impact, notched, 23°C 694 J/m ASTM D 256 Izod Impact, notched, -20°C 529 J/m ASTM D 256 Instrumented Impact Total Energy, 23°C 529 J/m ASTM D 3763 Izod Impact, notched 80°10°4 +23°C Instrumented Impact Total Energy, 23°C 52 J ASTM D 3763 Izod Impact, notched 80°10°4 +23°C 49 kJ/m² ISO 180/1A Izod Impact, notched 80°10°4 +23°C 49 kJ/m² ISO 180/1A Charpy 23°C, V-notch Edgew 80°10°4 sp=62mm 66 kJ/m² ISO 179/1eA THERMAL Value Unit Standard Vicat Softening Temp, Rate B/50 492 °C ASTM D 1525 HDT, 0.45 MPa, 3.2 mm, unannealed 79 °C ASTM D 648 HDT, 1.82 MPa, 3.2mm, unannealed 75 °C ASTM D 648 CTE, -40°C to 40°C, flow 8.3E-05 11°C ASTM E 831 CTE, -40°C to 40°C, flow 8.73E-05 11°C ASTM E 831 CTE, -40°C to 40°C, flow 70 SATM E 831 CTE, -40°C to 40°C, flow 8.73E-05 11°C ASTM E 831 CTE, -40°C to 40°C, flow Notest Softening Temp, Rate B/50 93 °C ISO 306 Vicat Softening Temp, Rate B/50 94 °C ISO 306 Vicat Softening Temp, Rate B/50 95 °C ASTM D 792 Mold Shrinkage, flow, 3.2 mm 0.5 - 0.7 % SABIC Method Mold Shrinkage, flow, 3.2 mm 0.6 - 0.7 % SABIC Method Mold Shrinkage, flow, 3.2 mm 0.6 - 0.7 % SABIC Method Mold Shrinkage, flow, 3.2 mm 0.6 - 0.7 % SABIC Method Mold Shrinkage, flow, 3.2 mm 0.6 - 0.7 % SABIC Method Mold Shrinkage, flow, 3.2 mm 0.6 - 0.7 % SABIC Method Mold Shrinkage, flow, 3.2 mm 0.6 - 0.7 % SABIC Method Mold Shrinkage, flow, 3.2 mm 0.6 - 0.7 % SABIC Method Mold Shrinkage, flow, 3.2 mm 0.6 - 0.7 % SABIC Method Mold Shrinkage, flow, 3.2 mm 0.6 - 0.7 % SABIC Method Mold Shrinkage, flow, 3.2 mm 0.6 - 0.7 % SABIC Method Mold Shrinkage, flow, 3.2 mm 0.6 - 0.7 % SABIC Method Mold Shrinkage, flow, 3.2 mm 0.6 - 0.7 % SABIC Method Mold Shrinkage, flow, 3.2 mm 0.6 - 0.7 % SABIC Method Mold Shrinkage, flow, 3.2 mm 0.6 - 0.7 % SABIC Method Mold Shrinkage, flow, 3.2 mm 0.7 - 0.7 % S	Tensile Stress, break, 50 mm/min	39	MPa	ISO 527
Tensile Modulus, 1 mm/min 1690	Tensile Strain, yield, 50 mm/min	3.6	%	ISO 527
Flexural Modulus, 2 mm/min	Tensile Strain, break, 50 mm/min	127.7	%	ISO 527
IMPACT Izod Impact, notched, 23°C 694 J/m ASTM D 256 Izod Impact, notched, -20°C 529 J/m ASTM D 256 Izod Impact, notched, -20°C 529 J/m ASTM D 256 Instrumented Impact Total Energy, 23°C 52 J ASTM D 3763 Izod Impact, notched 80°10°4 +23°C 49 kJ/m² ISO 180/1A Izod Impact, notched 80°10°4 +23°C 49 kJ/m² ISO 180/1A Izod Impact, notched 80°10°4 +23°C 49 kJ/m² ISO 180/1A Izod Impact, notched 80°10°4 sp=62mm 66 kJ/m² ISO 179/1eA	Tensile Modulus, 1 mm/min	1690	MPa	ISO 527
Izod Impact, notched, 23°C 694 J/m ASTM D 256 Izod Impact, notched, -20°C 529 J/m ASTM D 256 Instrumented Impact Total Energy, 23°C 52 J ASTM D 3763 Izod Impact, notched 80°10°4 + 23°C 49 KJ/m² ISO 180/1A Izod Impact, notched 80°10°4 -10°C 36 KJ/m² ISO 180/1A Izod Impact, notched 80°10°4 -10°C 36 KJ/m² ISO 180/1A Izod Impact, notched 80°10°4 sp=62mm 66 KJ/m² ISO 180/1A Izod Impact, notched 80°10°4 sp=62mm 66 KJ/m² ISO 179/1eA ISO 180/1A ISO 62	Flexural Modulus, 2 mm/min	1430	MPa	ISO 178
Izod Impact, notched, -20°C 529 J/m ASTM D 256 Instrumented Impact Total Energy, 23°C 52 J ASTM D 3763 Izod Impact, notched 80*10*4 +23°C 49 KJ/m² ISO 180/1A Izod Impact, notched 80*10*4 +23°C 49 KJ/m² ISO 180/1A Izod Impact, notched 80*10*4 +10°C 36 KJ/m² ISO 180/1A Izod Impact, notched 80*10*4 +10°C 36 KJ/m² ISO 180/1A IsO 179/1eA THERMAL Value Unit Standard Vicat Softening Temp, Rate B/50 92 °C ASTM D 1525 ASTM D 1525 ASTM D 1525 ASTM D 1525 ASTM D 648 ADT, 1.82 MPa, 3.2 mm, unannealed 75 °C ASTM D 648 ASTM D 6	IMPACT	Value	Unit	Standard
Instrumented Impact Total Energy, 23°C 52	Izod Impact, notched, 23°C	694	J/m	ASTM D 256
Izod Impact, notched 80*10*4 +23°C	Izod Impact, notched, -20°C	529	J/m	ASTM D 256
Izod Impact, notched 80*10*4 -10°C 36	Instrumented Impact Total Energy, 23°C	52	J	ASTM D 3763
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm 66 kJ/m² ISO 179/1eA THERMAL Value Unit Standard Vicat Softening Temp, Rate B/50 92 °C ASTM D 1525 HDT, 0.45 MPa, 3.2 mm, unannealed 79 °C ASTM D 648 HDT, 1.82 MPa, 3.2mm, unannealed 75 °C ASTM D 648 CTE, -40°C to 40°C, flow 8.3E-05 1/°C ASTM E 831 CTE, -40°C to 40°C, xflow 8.73E-05 1/°C ASTM E 831 Vicat Softening Temp, Rate B/50 93 °C ISO 306 Vicat Softening Temp, Rate B/120 94 °C ISO 306 HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm 76 °C ISO 75/Ae PHYSICAL Value Unit Standard Specific Gravity 1.15 - 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	Izod Impact, notched 80*10*4 +23°C	49	kJ/m²	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 79 °C ASTM D 648 HDT, 1.82 MPa, 3.2mm, unannealed 75 °C ASTM D 648 CTE, -40 °C to 40 °C, flow 8.3E-05 1/°C ASTM E 831 CTE, -40 °C to 40 °C, xflow 8.73E-05 1/°C ASTM E 831 Vicat Softening Temp, Rate B/50 93 °C ISO 306 Vicat Softening Temp, Rate B/120 94 °C ISO 306 HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm 76 °C ISO 75/Ae PHYSICAL Value Unit Standard Specific Gravity 1.15 - 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 Density 1.15 g/cm³ ISO 1183 Water Absorption, (23°C/sat)	Izod Impact, notched 80*10*4 -10°C	36	kJ/m²	ISO 180/1A
Vicat Softening Temp, Rate B/50 92 °C ASTM D 1525 HDT, 0.45 MPa, 3.2 mm, unannealed 79 °C ASTM D 648 HDT, 1.82 MPa, 3.2mm, unannealed 75 °C ASTM D 648 CTE, -40°C to 40°C, flow 8.3E-05 1/°C ASTM E 831 CTE, -40°C to 40°C, xflow 8.73E-05 1/°C ASTM E 831 Vicat Softening Temp, Rate B/50 93 °C ISO 306 Vicat Softening Temp, Rate B/120 94 °C ISO 306 HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm 76 °C ISO 75/Ae PHYSICAL Value Unit Standard Specific Gravity 1.15 - 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 Density 1.15 g/cm³ ISO 1183 Water Absorption, (23°C/sat) 0.21 % ISO 62	Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	66	kJ/m²	ISO 179/1eA
HDT, 0.45 MPa, 3.2 mm, unannealed 79 °C ASTM D 648 HDT, 1.82 MPa, 3.2mm, unannealed 75 °C ASTM D 648 CTE, -40°C to 40°C, flow 8.3E-05 1/°C ASTM E 831 CTE, -40°C to 40°C, xflow 8.73E-05 1/°C ASTM E 831 Vicat Softening Temp, Rate B/50 93 °C ISO 306 Vicat Softening Temp, Rate B/120 94 °C ISO 306 HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm 76 °C ISO 75/Ae PHYSICAL Value Unit Standard Specific Gravity 1.15 - 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 Density 1.15 g/cm³ ISO 1183 Water Absorption, (23°C/sat) 1.021 % ISO 62	THERMAL	Value	Unit	Standard
HDT, 1.82 MPa, 3.2mm, unannealed 75 °C ASTM D 648 CTE, -40°C to 40°C, flow 8.3E-05 1/°C ASTM E 831 CTE, -40°C to 40°C, xflow 8.73E-05 1/°C ASTM E 831 Vicat Softening Temp, Rate B/50 93 °C ISO 306 Vicat Softening Temp, Rate B/120 94 °C ISO 306 HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm 76 °C ISO 75/Ae PHYSICAL Value Unit Standard Specific Gravity 1.15 - 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 Density 1.15 g/cm³ ISO 1183 Water Absorption, (23°C/sat) 0.21 % ISO 62	Vicat Softening Temp, Rate B/50	92	°C	ASTM D 1525
CTE, -40°C to 40°C, flow 8.3E-05 1/°C ASTM E 831 CTE, -40°C to 40°C, xflow 8.73E-05 1/°C ASTM E 831 Vicat Softening Temp, Rate B/50 93 °C ISO 306 Vicat Softening Temp, Rate B/120 94 °C ISO 306 HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm 76 °C ISO 75/Ae PHYSICAL Value Unit Standard Specific Gravity 1.15 - 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 Density 1.15 g/cm³ ISO 1183 Water Absorption, (23°C/sat) 0.21 % ISO 62	HDT, 0.45 MPa, 3.2 mm, unannealed	79	°C	ASTM D 648
CTE, -40°C to 40°C, xflow 8.73E-05 1/°C ASTM E 831 Vicat Softening Temp, Rate B/50 93 °C ISO 306 Vicat Softening Temp, Rate B/120 94 °C ISO 306 HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm 76 °C ISO 75/Ae PHYSICAL Value Unit Standard Specific Gravity 1.15 - 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 Density 1.15 g/cm³ ISO 1183 Water Absorption, (23°C/sat) 0.21 % ISO 62	HDT, 1.82 MPa, 3.2mm, unannealed	75	°C	ASTM D 648
Vicat Softening Temp, Rate B/50 93 °C ISO 306 Vicat Softening Temp, Rate B/120 94 °C ISO 306 HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm 76 °C ISO 75/Ae PHYSICAL Value Unit Standard Specific Gravity 1.15 - 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 Density 1.15 g/cm³ ISO 1183 Water Absorption, (23°C/sat) 0.21 % ISO 62	CTE, -40°C to 40°C, flow	8.3E-05	1/°C	ASTM E 831
Vicat Softening Temp, Rate B/120 94 °C ISO 306 HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm 76 °C ISO 75/Ae PHYSICAL Value Unit Standard Specific Gravity 1.15 - 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 Density 1.15 g/cm³ ISO 1183 Water Absorption, (23°C/sat) 0.21 % ISO 62	CTE, -40°C to 40°C, xflow	8.73E-05	1/°C	ASTM E 831
HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm 76 °C ISO 75/Ae PHYSICAL Value Unit Standard Specific Gravity 1.15 - 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 Density 1.15 g/cm³ ISO 1183 Water Absorption, (23°C/sat) 0.21 % ISO 62	Vicat Softening Temp, Rate B/50	93	°C	ISO 306
PHYSICAL Value Unit Standard Specific Gravity 1.15 - 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 Density 1.15 g/cm³ ISO 1183 Water Absorption, (23°C/sat) 0.21 % ISO 62	Vicat Softening Temp, Rate B/120	94	°C	ISO 306
Specific Gravity 1.15 - 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 Density 1.15 g/cm³ ISO 1183 Water Absorption, (23°C/sat) 0.21 % ISO 62	HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm	76	°C	ISO 75/Ae
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 Density 1.15 g/cm³ ISO 1183 Water Absorption, (23°C/sat) 0.21 % ISO 62	PHYSICAL	Value	Unit	Standard
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 Density 1.15 g/cm³ ISO 1183 Water Absorption, (23°C/sat) 0.21 % ISO 62	Specific Gravity	1.15	-	ASTM D 792
Melt Flow Rate, 265°C/2.16kg 8 g/10 min ASTM D 1238 Density 1.15 g/cm³ ISO 1183 Water Absorption, (23°C/sat) 0.21 % ISO 62	Mold Shrinkage, flow, 3.2 mm	0.5 - 0.7	%	SABIC Method
Density 1.15 g/cm³ ISO 1183 Water Absorption, (23°C/sat) 0.21 % ISO 62	Mold Shrinkage, xflow, 3.2 mm	0.6 - 0.7	%	SABIC Method
Water Absorption, (23°C/sat) 0.21 % ISO 62	Melt Flow Rate, 265°C/2.16kg	8	g/10 min	ASTM D 1238
	Density	1.15	g/cm³	ISO 1183
Melt Volume Rate, MVR at 265°C/2.16 kg 8 cm³/10 min ISO 1133	Water Absorption, (23°C/sat)	0.21	%	ISO 62
	Melt Volume Rate, MVR at 265°C/2.16 kg	8	cm ³ /10 min	ISO 1133

Source GMD, last updated:09/15/2004

Parameter		
Injection Molding	Value	Unit
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:09/15/2004

• 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.

DISCIAIMER: THE MATERIALS AND PRODUCTS OF THE BUSINESSES MAKING UP THE SABIC INNOVATIVE

- (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.

PLASTICS COMPANY, ITS SUBSIDIARIES AND AFFILIATES ("SABIC IP"), ARE SOLD SUBJECT TO SABIC IP'S STANDARD CONDITIONS OF SALE, WHICH ARE INCLUDED IN THE APPLICABLE DISTRIBUTOR OR OTHER SALES AGREEMENT, PRINTED ON THE BACK OF ORDER ACKNOWLEDGMENTS AND INVOICES, AND AVAILABLE UPON REQUEST. ALTHOUGH ANY INFORMATION, RECOMMENDATIONS, OR ADVICE CONTAINED HEREIN IS GIVEN IN GOOD FAITH, SABIC IP MAKES NO WARRANTY OR GUARANTEE, EXPRESS OR IMPLIED, (I) THAT THE RESULTS DESCRIBED HEREIN WILL BE OBTAINED UNDER END-USE CONDITIONS, OR (II) AS TO THE EFFECTIVENESS OR SAFETY OF ANY DESIGN INCORPORATING SABIC IP MATERIALS, PRODUCTS, RECOMMENDATIONS OR ADVICE. EXCEPT AS PROVIDED IN SABIC IP'S STANDARD CONDITIONS OF SALE, SABIC IP AND ITS REPRESENTATIVES SHALL IN NO EVENT BE RESPONSIBLE FOR ANY LOSS RESULTING FROM ANY USE OF ITS MATERIALS OR PRODUCTS DESCRIBED HEREIN. Each user bears full responsibility for making its own determination as to the suitability of SABIC IP's materials, products, recommendations, or advice for its own particular use. Each user must identify and perform all tests and analyses necessary to assure that its finished parts incorporating SABIC IP materials or products will be safe and suitable for use under end-use conditions. Nothing in this or any other document, nor any oral recommendation or advice, shall be deemed to alter, vary, supersede, or waive any provision of SABIC IP's Standard Conditions of Sale or this Disclaimer, unless any such modification is specifically agreed to in a writing signed by SABIC IP. No statement contained herein concerning a possible or suggested use of any material, product or design is intended, or should be construed, to grant any license under any patent or other intellectual property right of SABIC Innovative Plastics Company or any of its subsidiaries or affiliates covering such use or design, or as a recommendation for the use of such material, product or design in the infringement of any patent or other intellectual property right

© 1997-2008 SABIC Innovative Plastics Company.All rights reserved

^{*} Xylex is a trademark of the SABIC Innovative Plastics Company