

## Xenoy\* Resin 1402B

Americas: COMMERCIAL

Blowmoldable, unreinforced PC/polyester alloy. Characterized by high melt viscosity/strength with excellent low temperature impact.

### Property

TYPICAL PROPERTIES <sup>(1)</sup>			
MECHANICAL	Value	Unit	Standard
Tensile Stress, yld, Type I, 50 mm/min	48	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	68	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	1990	MPa	ASTM D 790
IMPACT	Value	Unit	Standard
Izod Impact, notched, 23°C	694	J/m	ASTM D 256
Izod Impact, notched, -30°C	534	J/m	ASTM D 256
Modified Gardner, 23°C	44	J	ASTM D 3029
THERMAL	Value	Unit	Standard
HDT, 1.82 MPa, 6.4 mm, unannealed	96	°C	ASTM D 648
PHYSICAL	Value	Unit	Standard
Specific Gravity	1.19	-	ASTM D 792
Specific Volume	0.84	cm <sup>3</sup> /g	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	0.9 - 1.1	%	SABIC Method
Mold Shrinkage on Tensile Bar, xflow (2)	0.9 - 1.1	%	SABIC Method

Source GMD, last updated:01/05/2000

### Processing

Parameter	Value	Unit
Extrusion Blow Molding		
Drying Temperature	95 - 100	°C
Drying Time	4 - 6	hrs
Drying Time (Cumulative)	24	hrs
Maximum Moisture Content	0.01 - 0.02	%
Minimum Moisture Content	0.02	%
Melt Temperature (Parison)	240 - 250	°C
Barrel - Zone 1 Temperature	235 - 245	°C
Barrel - Zone 2 Temperature	235 - 245	°C
Barrel - Zone 3 Temperature	235 - 245	°C
Barrel - Zone 4 Temperature	235 - 245	°C
Adapter - Zone 5 Temperature	235 - 245	°C
Head - Zone 6 - Top Temperature	235 - 245	°C
Head - Zone 7 - Bottom Temperature	235 - 245	°C
Mold Temperature	65 - 90	°C
Die Temperature	240 - 250	°C

Source GMD, last updated:01/05/2000

- Purge with HDPE prior to changing screw, head, or die tooling and/or machine shutdown.
- Use moderate-slow screw speeds to keep melt temperature in suggested range. Suggested screw speed: 15 - 50 rpm. Actual rpm should be adjusted for desired output.
- Processing temperature must be measured with a hand-held probe as opposed to an internal-head probe.

- A reverse barrel profile may increase output while maintaining the melt 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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