

Xylex * Resin X8300CL

Europe-Africa-Middle East: COMMERCIAL

PC+Polyester, UV Stabilized, Transparent, OQ Quality

Property

TYPICAL PROPERTIES ⁽¹⁾			
	Value	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	47	MPa	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	46	MPa	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	5	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	150	%	ASTM D 638
Tensile Modulus, 50 mm/min	1520	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	71	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	1680	MPa	ASTM D 790
Tensile Stress, yield, 50 mm/min	55	MPa	ISO 527
Tensile Stress, break, 50 mm/min	54	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	>200	%	ISO 527
Tensile Strain, break, 50 mm/min	>200	%	ISO 527
Tensile Modulus, 1 mm/min	1600	MPa	ISO 527
Flexural Stress, break, 2 mm/min	78	MPa	ISO 178
Flexural Modulus, 2 mm/min	1700	MPa	ISO 178
IMPACT			
Izod Impact, notched, 23°C	1120	J/m	ASTM D 256
Instrumented Impact Total Energy, 23°C	95	J	ASTM D 3763
Izod Impact, notched 80*10*4 +23°C	8	kJ/m ²	ISO 180/1A
THERMAL			
Vicat Softening Temp, Rate B/50	96	°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	1.05E-04	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	1.05E-04	1/°C	ASTM E 831
CTE, 23°C to 60°C, flow	9.E-05	1/°C	ISO 11359-2
CTE, 23°C to 60°C, xflow	9.E-05	1/°C	ISO 11359-2
Vicat Softening Temp, Rate B/120	96	°C	ISO 306
HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm	80	°C	ISO 75/Ae
PHYSICAL			
Specific Gravity	1.2	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	0.5 - 0.8	%	SABIC Method
Melt Flow Rate, 265°C/2.16kg	15	g/10 min	ASTM D 1238
Density	1.17	g/cm ³	ISO 1183
Melt Volume Rate, MVR at 265°C/2.16 kg	15	cm ³ /10 min	ISO 1133

Source GMD, last updated:2008/10/09

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:2008/10/09

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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