



XYLEX™ Resin X7300CL
Asia Pacific: COMMERCIAL

PC+ POLYESTER unreinforced alloy developed for optical or lense market. Chemical resistance.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	490	kgf/cm ²	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	530	kgf/cm ²	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	18700	kgf/cm ²	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	840	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	19700	kgf/cm ²	ASTM D 790
Tensile Stress, yield, 50 mm/min	55	MPa	ISO 527
Tensile Stress, break, 50 mm/min	55	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	5	%	ISO 527
Tensile Strain, break, 50 mm/min	>150	%	ISO 527
Tensile Modulus, 1 mm/min	1900	MPa	ISO 527
Flexural Stress, break, 2 mm/min	71	MPa	ISO 178
Flexural Modulus, 2 mm/min	2000	MPa	ISO 178
IMPACT			
Izod Impact, notched, 23°C	67	cm-kgf/cm	ASTM D 256
Izod Impact, notched, -30°C	5	cm-kgf/cm	ASTM D 256
Instrumented Impact Total Energy, 23°C	968	cm-kgf	ASTM D 3763
Izod Impact, notched 80*10*4 +23°C	10	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*4 -10°C	5	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	7	kJ/m ²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	11	kJ/m ²	ISO 179/1eA

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 (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.

(5) Measurements made from laboratory test coupon. Actual shrinkage may vary outside of range due to differences in processing conditions, equipment, part geometry and tool design. It is recommended that mold shrinkage studies be performed with surrogate or legacy tooling prior to cutting tools for new molded article.

(6) Needs hard coat to consistently pass 60 sec Vertical Burn.

Source GMD, last updated:

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THERMAL			
Vicat Softening Temp, Rate B/50	108	°C	ASTM D 1525
HDT, 0.45 MPa, 3.2 mm, unannealed	102	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	88	°C	ASTM D 648
CTE, -40°C to 40°C, flow	1.15E-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	8.5E-05	1/°C	ISO 11359-2
CTE, 23°C to 60°C, xflow	8.5E-05	1/°C	ISO 11359-2
Vicat Softening Temp, Rate B/50	107	°C	ISO 306
Vicat Softening Temp, Rate B/120	106	°C	ISO 306
HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm	90	°C	ISO 75/Ae
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	92	°C	ISO 75/Af
PHYSICAL			
Specific Gravity	1.2	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm (5)	0.4 - 0.8	%	SABIC Method
Mold Shrinkage, xflow, 3.2 mm (5)	0.5 - 0.7	%	SABIC Method
Melt Flow Rate, 265°C/2.16kgf	21	g/10 min	ASTM D 1238
Melt Flow Rate, 300°C/1.2 kgf	44	g/10 min	ASTM D 1238
Density	1.18	g/cm ³	ISO 1183
Water Absorption, (23°C/sat)	0.5	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.12	%	ISO 62
Melt Volume Rate, MVR at 265°C/2.16 kg	20	cm ³ /10 min	ISO 1133
Melt Volume Rate, MVR at 300°C/1.2 kg	42	cm ³ /10 min	ISO 1133
OPTICAL			
Light Transmission, 2.54 mm	88	%	ASTM D 1003
Haze, 2.54 mm	2	%	ASTM D 1003

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TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
FLAME CHARACTERISTICS			
UL Recognized, 94V-2 Flame Class Rating (3)	3	mm	UL 94

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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	80 - 95	°C
Drying Time	3 - 5	hrs
Drying Time (Cumulative)	8	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	250 - 270	°C
Nozzle Temperature	250 - 270	°C
Front - Zone 3 Temperature	250 - 270	°C
Middle - Zone 2 Temperature	245 - 265	°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

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