



## XYLEX™ Resin X8300

### Asia Pacific: COMMERCIAL

PC+Polyester, UV Stabilized, Transparent

TYPICAL PROPERTIES <sup>1</sup>	TYPICAL VALUE	Unit	Standard
<b>MECHANICAL</b>			
Tensile Stress, yld, Type I, 50 mm/min	470	kgf/cm <sup>2</sup>	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	460	kgf/cm <sup>2</sup>	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	15400	kgf/cm <sup>2</sup>	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	720	kgf/cm <sup>2</sup>	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	17100	kgf/cm <sup>2</sup>	ASTM D 790
Hardness, Shore D, 10S reading	73	-	ASTM D 2240
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	>5	%	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
<b>IMPACT</b>			
Izod Impact, notched, 23°C	114	cm-kgf/cm	ASTM D 256
Izod Impact, notched, -30°C	7	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	8	kJ/m <sup>2</sup>	ISO 180/1A
Izod Impact, notched 80*10*4 -10°C	5	kJ/m <sup>2</sup>	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	7	kJ/m <sup>2</sup>	ISO 180/1A

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(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.

(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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<b>IMPACT</b>			
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	10	kJ/m <sup>2</sup>	ISO 179/1eA
<b>THERMAL</b>			
Vicat Softening Temp, Rate B/50	91	°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
Thermal Conductivity	0.23	W/m-°C	ISO 8302
CTE, -40°C to 40°C, flow	1.05E-04	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	1.05E-04	1/°C	ISO 11359-2
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
Ball Pressure Test, approximate maximum	85	°C	IEC 60695-10-2
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
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	78	°C	ISO 75/Af
<b>PHYSICAL</b>			
Specific Gravity	1.2	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm (5)	0.5 - 0.8	%	SABIC Method
Mold Shrinkage, xflow, 3.2 mm (5)	0.4 - 0.6	%	SABIC Method
Melt Flow Rate, 265°C/2.16kgf	15	g/10 min	ASTM D 1238
Density	1.17	g/cm <sup>3</sup>	ISO 1183
Water Absorption, (23°C/sat)	0.05	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.2	%	ISO 62
Melt Volume Rate, MVR at 265°C/2.16 kg	15	cm <sup>3</sup> /10 min	ISO 1133

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<b>OPTICAL</b>			
Light Transmission, 2.54 mm	88	%	ASTM D 1003
Haze, 2.54 mm	1	%	ASTM D 1003
Refractive Index	1.539	-	ISO 489
<b>ELECTRICAL</b>			
Volume Resistivity	>1.E+15	Ohm-cm	ASTM D 257
Surface Resistivity	>1.E+15	Ohm	ASTM D 257
Comparative Tracking Index (UL) {PLC}	0	PLC Code	UL 746A
<b>FLAME CHARACTERISTICS</b>			
UL Recognized, 94V-2 Flame Class Rating (3)	3	mm	UL 94
Glow Wire Flammability Index 750°C, passes at	1	mm	IEC 60695-2-12

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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
<b>Injection Molding</b>		
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

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