

Xylex * Resin X7503

Americas: COMMERCIAL

Clear PC-Siloxane copolymer + Polyester alloy

Property

TYPICAL PROPERTIES ⁽¹⁾			
MECHANICAL	Value	Unit	Standard
Tensile Stress, yld, Type I, 50 mm/min	57	MPa	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	55	MPa	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	5	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	100	%	ASTM D 638
Tensile Modulus, 5 mm/min	2100	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	86	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	1900	MPa	ASTM D 790
Tensile Stress, yield, 50 mm/min	58	MPa	ISO 527
Tensile Stress, break, 50 mm/min	54	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	6	%	ISO 527
Tensile Strain, break, 50 mm/min	100	%	ISO 527
Tensile Modulus, 1 mm/min	2100	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	84	MPa	ISO 178
Flexural Modulus, 2 mm/min	2100	MPa	ISO 178
IMPACT	Value	Unit	Standard
Izod Impact, notched, 23°C	920	J/m	ASTM D 256
Izod Impact, notched, -30°C	750	J/m	ASTM D 256
Instrumented Impact Total Energy, 23°C	71	J	ASTM D 3763
Izod Impact, notched 80*10*4 +23°C	68	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	17	kJ/m ²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	70	kJ/m ²	ISO 179/1eA
THERMAL	Value	Unit	Standard
Vicat Softening Temp, Rate B/50	132	°C	ASTM D 1525
HDT, 0.45 MPa, 3.2 mm, unannealed	124	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	110	°C	ASTM D 648
CTE, -40°C to 40°C, flow	7.E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	7.E-05	1/°C	ASTM E 831
CTE, 23°C to 60°C, flow	7.7E-05	1/°C	ISO 11359-2
CTE, 23°C to 60°C, xflow	7.8E-05	1/°C	ISO 11359-2
Vicat Softening Temp, Rate B/50	130	°C	ISO 306
Vicat Softening Temp, Rate B/120	132	°C	ISO 306
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	124	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	110	°C	ISO 75/Af
PHYSICAL	Value	Unit	Standard
Specific Gravity	1.2	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	0.6 - 0.8	%	SABIC Method
Melt Flow Rate, 265°C/2.16kg	8	g/10 min	ASTM D 1238
Density	1.2	g/cm ³	ISO 1183
Water Absorption, (23°C/sat)	0.5	%	ISO 62

Moisture Absorption (23°C / 50% RH)	0.2	%	ISO 62
Melt Volume Rate, MVR at 265°C/2.16 kg	8	cm ³ /10 min	ISO 1133
OPTICAL	Value	Unit	Standard
Light Transmission	86	%	ASTM D 1003
Haze	2	%	ASTM D 1003
FLAME CHARACTERISTICS	Value	Unit	Standard
UL Recognized, 94V-2 Flame Class Rating (3)	3	mm	UL 94

Source GMD, last updated:02/01/2008

Processing

Parameter	Value	Unit
Injection Molding		
Drying Temperature	65 - 80	°C
Drying Time	3 - 5	hrs
Drying Time (Cumulative)	8	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	250 - 290	°C
Nozzle Temperature	250 - 290	°C
Front - Zone 3 Temperature	250 - 290	°C
Middle - Zone 2 Temperature	245 - 280	°C
Rear - Zone 1 Temperature	245 - 255	°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:02/01/2008

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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