

## Xylex\* Resin X7300

### Americas: COMMERCIAL

PC+POLYESTER unreinforced alloy. High flow, chemically resistant with excellent optical quality. UV-stabilized.

TYPICAL PROPERTIES <sup>1</sup>	TYPICAL VALUE	UNIT	STANDARD
<b>MECHANICAL</b>			
Tensile Stress, yld, Type I, 50 mm/min	490	kgf/cm <sup>2</sup>	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	530	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	18700	kgf/cm <sup>2</sup>	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	840	kgf/cm <sup>2</sup>	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	19700	kgf/cm <sup>2</sup>	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
<b>IMPACT</b>			
Izod Impact, notched, 23°C	67	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	9	kJ/m <sup>2</sup>	ISO 180/1A
<b>THERMAL</b>			
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

1) Typical values only. Variations within normal tolerances are possible for various colours. All values are measured at least after 48 hours storage at 23°C/50% relative humidity. All properties, except the melt volume rate are measured on injection moulded samples. All samples are prepared according to ISO 294.

2) Only typical data for material selection purpose. Not to be used for part or tool design.  
3) This rating is not intended to reflect hazards presented this or any other material under actual fire conditions.  
4) Own measurement according to UL.  
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.

Source, GMD, Last Update:

PLEASE CONTACT YOUR LOCAL SALES OFFICE FOR AVAILABILITY IN YOUR AREA.

DISCLAIMER : THE MATERIALS, PRODUCTS AND SERVICES OF SABIC INNOVATIVE PLASTICS HOLDING BV, ITS SUBSIDIARIES AND AFFILIATES ("SELLER"), ARE SOLD SUBJECT TO SELLER'S STANDARD CONDITIONS OF SALE, WHICH CAN BE FOUND AT <http://www.sabic-ip.com> AND ARE AVAILABLE UPON REQUEST. ALTHOUGH ANY INFORMATION OR RECOMMENDATION CONTAINED HEREIN IS GIVEN IN GOOD FAITH, SELLER MAKES NO WARRANTY OR GUARANTEE, EXPRESS OR IMPLIED, (i) THAT THE RESULTS DESCRIBED HEREIN WILL BE OBTAINED UNDER END-USE CONDITIONS, OR (ii) AS TO THE EFFECTIVENESS OR SAFETY OF ANY DESIGN INCORPORATING SELLER'S PRODUCTS, SERVICES OR RECOMMENDATIONS. EXCEPT AS PROVIDED IN SELLER'S STANDARD CONDITIONS OF SALE, SELLER SHALL NOT BE RESPONSIBLE FOR ANY LOSS RESULTING FROM ANY USE OF ITS PRODUCTS OR SERVICES DESCRIBED HEREIN. Each user is responsible for making its own determination as to the suitability of Seller's products, services or recommendations for the user's particular use through appropriate end-use testing and analysis. Nothing in any document or oral statement shall be deemed to alter or waive any provision of Seller's Standard Conditions of Sale or this Disclaimer, unless it is specifically agreed to in a writing signed by Seller. No statement by Seller concerning a possible use of any product, service or design is intended, or should be construed, to grant any license under any patent or other intellectual property right of Seller or as a recommendation for the use of such product, service or design in a manner that infringes any patent or other intellectual property right.

SABIC Innovative Plastics is a trademark of SABIC Holding Europe BV

\* Xylex is a trademark of SABIC INNOVATIVE PLASTICS HOLDING BV

© 1997-2010 SABIC INNOVATIVE PLASTICS HOLDING BV. All rights reserved

## Xylex\* Resin X7300

### Americas: COMMERCIAL

TYPICAL PROPERTIES <sup>1</sup>	TYPICAL VALUE	UNIT	STANDARD
<b>THERMAL</b>			
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/120	106	°C	ISO 306
HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm	90	°C	ISO 75/Ae
<b>PHYSICAL</b>			
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/2.16kg	21	g/10 min	ASTM D 1238
Density	1.18	g/cm <sup>3</sup>	ISO 1183
Melt Volume Rate, MVR at 265°C/2.16 kg	21	cm <sup>3</sup> /10 min	ISO 1133
<b>OPTICAL</b>			
Light Transmission, 2.54 mm	88	%	ASTM D 1003
Haze, 2.54 mm	2	%	ASTM D 1003

1) Typical values only. Variations within normal tolerances are possible for various colours. All values are measured at least after 48 hours storage at 23°C/50% relative humidity. All properties, except the melt volume rate are measured on injection moulded samples. All samples are prepared according to ISO 294.

2) Only typical data for material selection purpose. Not to be used for part or tool design.  
3) This rating is not intended to reflect hazards presented this or any other material under actual fire conditions.  
4) Own measurement according to UL.  
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.

Source, GMD, Last Update:

PLEASE CONTACT YOUR LOCAL SALES OFFICE FOR AVAILABILITY IN YOUR AREA.

DISCLAIMER : THE MATERIALS, PRODUCTS AND SERVICES OF SABIC INNOVATIVE PLASTICS HOLDING BV, ITS SUBSIDIARIES AND AFFILIATES ("SELLER"), ARE SOLD SUBJECT TO SELLER'S STANDARD CONDITIONS OF SALE, WHICH CAN BE FOUND AT <http://www.sabic-ip.com>. AND ARE AVAILABLE UPON REQUEST. ALTHOUGH ANY INFORMATION OR RECOMMENDATION CONTAINED HEREIN IS GIVEN IN GOOD FAITH, SELLER MAKES NO WARRANTY OR GUARANTEE, EXPRESS OR IMPLIED, (i) THAT THE RESULTS DESCRIBED HEREIN WILL BE OBTAINED UNDER END-USE CONDITIONS, OR (ii) AS TO THE EFFECTIVENESS OR SAFETY OF ANY DESIGN INCORPORATING SELLER'S PRODUCTS, SERVICES OR RECOMMENDATIONS. EXCEPT AS PROVIDED IN SELLER'S STANDARD CONDITIONS OF SALE, SELLER SHALL NOT BE RESPONSIBLE FOR ANY LOSS RESULTING FROM ANY USE OF ITS PRODUCTS OR SERVICES DESCRIBED HEREIN. Each user is responsible for making its own determination as to the suitability of Seller's products, services or recommendations for the user's particular use through appropriate end-use testing and analysis. Nothing in any document or oral statement shall be deemed to alter or waive any provision of Seller's Standard Conditions of Sale or this Disclaimer, unless it is specifically agreed to in a writing signed Seller. No statement Seller concerning a possible use of any product, service or design is intended, or should be construed, to grant any license under any patent or other intellectual property right of Seller or as a recommendation for the use of such product, service or design in a manner that infringes any patent or other intellectual property right.

SABIC Innovative Plastics is a trademark of SABIC Holding Europe BV

\* Xylex is a trademark of SABIC INNOVATIVE PLASTICS HOLDING BV

© 1997-2010 SABIC Innovative Plastics IP BV. All rights reserved

## Xylex\* Resin X7300

### Americas: COMMERCIAL

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

1) Typical values only. Variations within normal tolerances are possible for various colours. All values are measured at least after 48 hours storage at 23°C/50% relative humidity.  
All properties, except the melt volume rate are measured on injection moulded samples.  
All samples are prepared according to ISO 294.

2) Only typical data for material selection purpose. Not to be used for part or tool design.  
3) This rating is not intended to reflect hazards presented this or any other material under actual fire conditions.  
4) Own measurement according to UL.  
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.

Source, GMD, Last Update:

PLEASE CONTACT YOUR LOCAL SALES OFFICE FOR AVAILABILITY IN YOUR AREA.

DISCLAIMER : THE MATERIALS, PRODUCTS AND SERVICES OF SABIC INNOVATIVE PLASTICS HOLDING BV, ITS SUBSIDIARIES AND AFFILIATES ("SELLER"), ARE SOLD SUBJECT TO SELLER'S STANDARD CONDITIONS OF SALE, WHICH CAN BE FOUND AT <http://www.sabic-ip.com>. AND ARE AVAILABLE UPON REQUEST. ALTHOUGH ANY INFORMATION OR RECOMMENDATION CONTAINED HEREIN IS GIVEN IN GOOD FAITH, SELLER MAKES NO WARRANTY OR GUARANTEE, EXPRESS OR IMPLIED, (i) THAT THE RESULTS DESCRIBED HEREIN WILL BE OBTAINED UNDER END-USE CONDITIONS, OR (ii) AS TO THE EFFECTIVENESS OR SAFETY OF ANY DESIGN INCORPORATING SELLER'S PRODUCTS, SERVICES OR RECOMMENDATIONS. EXCEPT AS PROVIDED IN SELLER'S STANDARD CONDITIONS OF SALE, SELLER SHALL NOT BE RESPONSIBLE FOR ANY LOSS RESULTING FROM ANY USE OF ITS PRODUCTS OR SERVICES DESCRIBED HEREIN. Each user is responsible for making its own determination as to the suitability of Seller's products, services or recommendations for the user's particular use through appropriate end-use testing and analysis. Nothing in any document or oral statement shall be deemed to alter or waive any provision of Seller's Standard Conditions of Sale or this Disclaimer, unless it is specifically agreed to in a writing signed Seller. No statement Seller concerning a possible use of any product, service or design is intended, or should be construed, to grant any license under any patent or other intellectual property right of Seller or as a recommendation for the use of such product, service or design in a manner that infringes any patent or other intellectual property right.

SABIC Innovative Plastics is a trademark of SABIC Holding Europe BV

\* Xylex is a trademark of SABIC INNOVATIVE PLASTICS HOLDING BV

© 1997-2010 SABIC Innovative Plastics IP BV. All rights reserved

**Xylex\* Resin X7300**  
**Americas: COMMERCIAL**

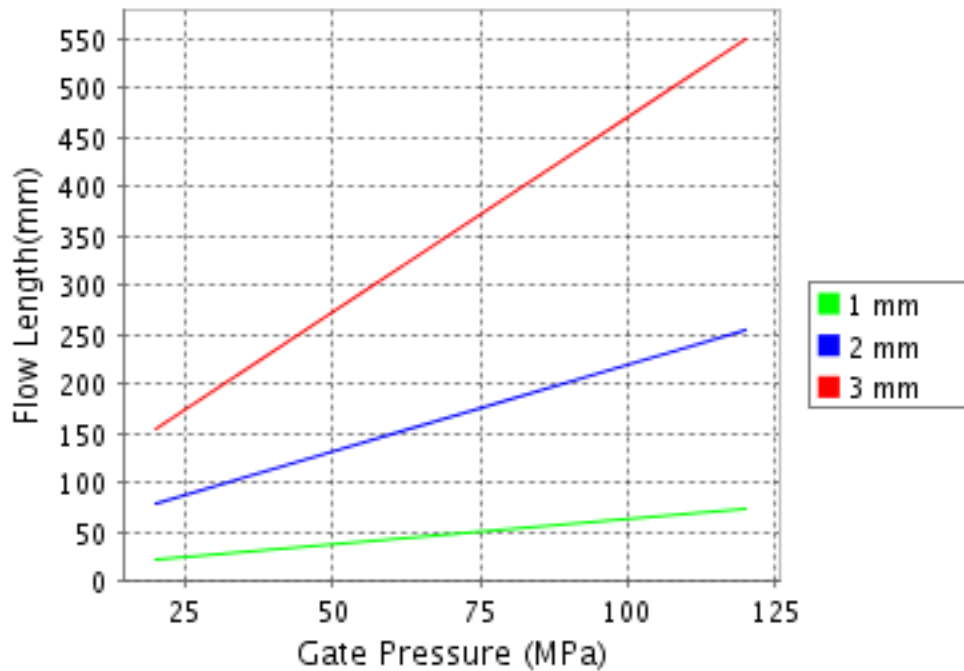
**CALCULATED FLOW LENGTH INDICATION**

**Moldflow® Radial Flow Analysis**

**Xylex\* X7300**

**Melt Temperature : 280°C**

**Mold Temperature : 90°C**



**Note: Technical support is recommended if Gate Pressure is greater than 80 MPa. Contact your local representative.**

**® Moldflow is a registered trademark of the Moldflow Corporation.**

1) Typical values only. Variations within normal tolerances are possible for various colours. All values are measured at least after 48 hours storage at 23°C/50% relative humidity. All properties, except the melt volume rate are measured on injection moulded samples. All samples are prepared according to ISO 294.

2) Only typical data for material selection purpose. Not to be used for part or tool design.  
3) This rating is not intended to reflect hazards presented this or any other material under actual fire conditions.  
4) Own measurement according to UL.  
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.

Source, GMD, Last Update:

**PLEASE CONTACT YOUR LOCAL SALES OFFICE FOR AVAILABILITY IN YOUR AREA.**

**DISCLAIMER :** THE MATERIALS, PRODUCTS AND SERVICES OF SABIC INNOVATIVE PLASTICS HOLDING BV, ITS SUBSIDIARIES AND AFFILIATES ("SELLER"), ARE SOLD SUBJECT TO SELLER'S STANDARD CONDITIONS OF SALE, WHICH CAN BE FOUND AT <http://www.sabic-ip.com>. AND ARE AVAILABLE UPON REQUEST. ALTHOUGH ANY INFORMATION OR RECOMMENDATION CONTAINED HEREIN IS GIVEN IN GOOD FAITH, SELLER MAKES NO WARRANTY OR GUARANTEE, EXPRESS OR IMPLIED, (i) THAT THE RESULTS DESCRIBED HEREIN WILL BE OBTAINED UNDER END-USE CONDITIONS, OR (ii) AS TO THE EFFECTIVENESS OR SAFETY OF ANY DESIGN INCORPORATING SELLER'S PRODUCTS, SERVICES OR RECOMMENDATIONS. EXCEPT AS PROVIDED IN SELLER'S STANDARD CONDITIONS OF SALE, SELLER SHALL NOT BE RESPONSIBLE FOR ANY LOSS RESULTING FROM ANY USE OF ITS PRODUCTS OR SERVICES DESCRIBED HEREIN. Each user is responsible for making its own determination as to the suitability of Seller's products, services or recommendations for the user's particular use through appropriate end-use testing and analysis. Nothing in any document or oral statement shall be deemed to alter or waive any provision of Seller's Standard Conditions of Sale or this Disclaimer, unless it is specifically agreed to in a writing signed Seller. No statement Seller concerning a possible use of any product, service or design is intended, or should be construed, to grant any license under any patent or other intellectual property right of Seller or as a recommendation for the use of such product, service or design in a manner that infringes any patent or other intellectual property right.

SABIC Innovative Plastics is a trademark of SABIC Holding Europe BV

\* Xylex is a trademark of SABIC INNOVATIVE PLASTICS HOLDING BV

© 1997-2010 SABIC Innovative Plastics IP BV. All rights reserved