



Xylex* Resin X7509
Americas: COMMERCIAL

PC+Polyester alloy. Houseware applications.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	610	kgf/cm ²	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	640	kgf/cm ²	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	6.3	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	135	%	ASTM D 638
Tensile Modulus, 50 mm/min	21800	kgf/cm ²	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	960	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	23400	kgf/cm ²	ASTM D 790
Tensile Stress, yield, 50 mm/min	60	MPa	ISO 527
Tensile Stress, break, 50 mm/min	62	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	5.8	%	ISO 527
Tensile Strain, break, 50 mm/min	133	%	ISO 527
Tensile Modulus, 1 mm/min	2300	MPa	ISO 527
Flexural Stress, break, 2 mm/min	92	MPa	ISO 178
Flexural Modulus, 2 mm/min	2250	MPa	ISO 178
IMPACT			
Izod Impact, notched, 23°C	87	cm-kgf/cm	ASTM D 256
Instrumented Impact Total Energy, 23°C	713	cm-kgf	ASTM D 3763
Izod Impact, notched 80*10*4 +23°C	9	kJ/m ²	ISO 180/1A
THERMAL			
Vicat Softening Temp, Rate B/50	126	°C	ASTM D 1525
HDT, 0.45 MPa, 3.2 mm, unannealed	119	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	106	°C	ASTM D 648
CTE, -40°C to 40°C, flow	1.04E-04	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	1.04E-04	1/°C	ASTM E 831

1) Typical values only. Variations within normal tolerances are possible for variose colours. All values are measured at least after 48 hours storage at 230C/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 by this or any other material under actual fire conditions.
 4) Own measurement according to UL.

Source, GMD, Last Update:08/05/2004

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TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
THERMAL			
CTE, -40°C to 40°C, xflow	1.04E-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	126	°C	ISO 306
HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm	106	°C	ISO 75/Ae
PHYSICAL			
Specific Gravity	1.2	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	0.4 - 0.6	%	GE Method
Mold Shrinkage, xflow, 3.2 mm	0.5 - 0.7	%	GE Method
Melt Flow Rate, 265°C/2.16kg	12	g/10 min	ASTM D 1238
Density	1.2	g/cm ³	ISO 1183
Melt Volume Rate, MVR at 265°C/2.16 kg	11	cm ³ /10 min	ISO 1133
OPTICAL			
Light Transmission	88	%	ASTM D 1003
Haze	2	%	ASTM D 1003

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PROCESSING PARAMETERS	TYPICAL 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 - 270	°C
Nozzle Temperature	250 - 270	°C
Front - Zone 3 Temperature	250 - 270	°C
Middle - Zone 2 Temperature	245 - 270	°C
Rear - Zone 1 Temperature	245 - 260	°C
Mold Temperature	45 - 60	°C
Back Pressure	0.1 - 0.5	MPa
Screw Speed	20 - 100	rpm
Shot to Cylinder Size	40 - 80	%
Vent Depth	0.013 - 0.02	mm

- Parts may initially appear hazy directly from the mold, but will clear upon reaching ambient temperature.

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