

Xylex* Resin X8303

Americas: COMMERCIAL

Low processing Temperature, high flow with excellent impact

TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	460	kgf/cm ²	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	440	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	140	%	ASTM D 638
Tensile Modulus, 5 mm/min	17100	kgf/cm ²	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	730	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	16500	kgf/cm ²	ASTM D 790
Tensile Stress, yield, 50 mm/min	48	MPa	ISO 527
Tensile Stress, break, 50 mm/min	43	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	6	%	ISO 527
Tensile Strain, break, 50 mm/min	140	%	ISO 527
Tensile Modulus, 1 mm/min	1690	MPa	ISO 527
Flexural Stress, break, 2 mm/min	72	MPa	ISO 178
Flexural Modulus, 2 mm/min	1720	MPa	ISO 178
IMPACT			
Izod Impact, notched, 23°C	101	cm-kgf/cm	ASTM D 256
Instrumented Impact Total Energy, 23°C	662	cm-kgf	ASTM D 3763
Izod Impact, notched 80*10*4 +23°C	20	kJ/m ²	ISO 180/1A
THERMAL			
Vicat Softening Temp, Rate B/50	98	°C	ASTM D 1525
HDT, 0.45 MPa, 3.2 mm, unannealed	92	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	80	°C	ASTM D 648
CTE, -40°C to 40°C, flow	9.E-05	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 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:12/04/2006

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TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
THERMAL			
CTE, -40°C to 40°C, xflow	9.E-05	1/°C	ASTM E 831
CTE, 23°C to 60°C, flow	9.2E-05	1/°C	ISO 11359-2
CTE, 23°C to 60°C, xflow	9.8E-05	1/°C	ISO 11359-2
Vicat Softening Temp, Rate B/50	100	°C	ISO 306
Vicat Softening Temp, Rate B/120	100	°C	ISO 306
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	90	°C	ISO 75/Af
PHYSICAL			
Specific Gravity	1.2	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	0.4 - 0.8	%	SABIC Method
Melt Flow Rate, 265°C/2.16kg	32	g/10 min	ASTM D 1238
Density	1.2	g/cm ³	ISO 1183
Melt Volume Rate, MVR at 265°C/2.16 kg	30	cm ³ /10 min	ISO 1133
OPTICAL			
Light Transmission	88	%	ASTM D 1003
Haze	2	%	ASTM D 1003

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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.

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PROCESSING PARAMETERS	TYPICAL VALUE	UNIT
Injection Molding		
Drying Temperature	70 - 80	°C
Drying Time	3 - 5	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	240 - 270	°C
Nozzle Temperature	240 - 270	°C
Front - Zone 3 Temperature	240 - 270	°C
Middle - Zone 2 Temperature	235 - 265	°C
Rear - Zone 1 Temperature	235 - 255	°C
Mold Temperature	50 - 70	°C
Screw Speed	20 - 100	rpm

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