

XENOY™ RESIN 1102

REGION AMERICAS

DESCRIPTION

Unreinforced PC/polyester alloy. Excellent low temperature impact/chemical resistance to automotive fluids.

TYPICAL PROPERTY VALUES

Revision 20190815

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	54	MPa	ASTM D638
Tensile Strain, brk, Type I, 50 mm/min	150	%	ASTM D638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	82	MPa	ASTM D790
Flexural Modulus, 1.3 mm/min, 50 mm span	1960	MPa	ASTM D790
IMPACT			
Izod Impact, notched, 23°C	800	J/m	ASTM D256
Izod Impact, notched, 0°C	690	J/m	ASTM D256
Izod Impact, notched, -30°C	640	J/m	ASTM D256
THERMAL			
HDT, 0.45 MPa, 6.4 mm, unannealed	110	°C	ASTM D648
HDT, 1.82 MPa, 6.4 mm, unannealed	90	°C	ASTM D648
PHYSICAL			
Specific Gravity	1.19	-	ASTM D792
Specific Volume	0.83	cm ³ /g	ASTM D792
Mold Shrinkage, flow, 3.2 mm	0.8 – 1	%	SABIC method
Mold Shrinkage, xflow, 3.2 mm	0.8 – 1	%	SABIC method
INJECTION MOLDING			
Drying Temperature	110	°C	
Drying Time	4 – 6	Hrs	
Drying Time (Cumulative)	8	Hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	260 – 275	°C	
Nozzle Temperature	255 – 270	°C	
Front - Zone 3 Temperature	255 – 275	°C	
Middle - Zone 2 Temperature	250 – 270	°C	
Rear - Zone 1 Temperature	245 – 265	°C	
Mold Temperature	65 – 90	°C	
Back Pressure	0.3 – 0.7	MPa	
Screw Speed	50 – 80	rpm	
Shot to Cylinder Size	50 – 80	%	
Vent Depth	0.013 – 0.02	mm	



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