

Xenoy* Resin IQ1103R

Americas: COMMERCIAL

Xenoy* Resin IQ1103R - Environmentally responsible, sustainable, and low carbon footprint resin. Xenoy IQ1103R is an unreinforced, impact modified PC + iQ-PBT alloy with excellent low temperature impact, chemical resistance, and a special mold release. Range gray, black colors, limited colors.

Property

TYPICAL PROPERTIES ⁽¹⁾			
MECHANICAL	Value	Unit	Standard
Tensile Stress, yld, Type I, 50 mm/min	45	MPa	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	46	MPa	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	4	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	140	%	ASTM D 638
Tensile Modulus, 50 mm/min	2050	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	74	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	2000	MPa	ASTM D 790
Tensile Stress, yield, 50 mm/min	49	MPa	ISO 527
Tensile Stress, break, 50 mm/min	47	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	4	%	ISO 527
Tensile Strain, break, 50 mm/min	150	%	ISO 527
Tensile Modulus, 1 mm/min	1950	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	70	MPa	ISO 178
Flexural Modulus, 2 mm/min	1920	MPa	ISO 178
IMPACT	Value	Unit	Standard
Izod Impact, notched, 23°C	650	J/m	ASTM D 256
Izod Impact, notched, -30°C	600	J/m	ASTM D 256
Instrumented Impact Total Energy, 23°C	50	J	ASTM D 3763
Izod Impact, notched 80*10*4 +23°C	55	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	47	kJ/m ²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	55	kJ/m ²	ISO 179/1eA
THERMAL	Value	Unit	Standard
Vicat Softening Temp, Rate B/50	117	°C	ASTM D 1525
HDT, 0.45 MPa, 3.2 mm, unannealed	99	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	75	°C	ASTM D 648
CTE, -40°C to 150°C, flow	9.E-05	1/°C	ASTM E 831
CTE, -40°C to 150°C, xflow	9.5E-05	1/°C	ASTM E 831
CTE, -30°C to 80°C, flow	9.E-05	1/°C	ISO 11359-2
CTE, -30°C to 80°C, xflow	9.5E-05	1/°C	ISO 11359-2
Vicat Softening Temp, Rate B/50	115	°C	ISO 306
Vicat Softening Temp, Rate B/120	117	°C	ISO 306
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	76	°C	ISO 75/Af
PHYSICAL	Value	Unit	Standard
Specific Gravity	1.19	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	0.8 - 1.2	%	SABIC Method
Melt Flow Rate, 250°C/5.0 kgf	13	g/10 min	ASTM D 1238
Density	1.2	g/cm ³	ISO 1183

Water Absorption, (23°C/sat)	0.3	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.08	%	ISO 62
Melt Volume Rate, MVR at 250°C/5.0 kg	12	cm ³ /10 min	ISO 1133

Source GMD, last updated:08/08/2008

Processing

Parameter	Value	Unit
Injection Molding		
Drying Temperature	110	°C
Drying Time	4 - 6	hrs
Drying Time (Cumulative)	8	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	255 - 275	°C
Nozzle Temperature	250 - 265	°C
Front - Zone 3 Temperature	250 - 270	°C
Middle - Zone 2 Temperature	245 - 265	°C
Rear - Zone 1 Temperature	240 - 260	°C
Mold Temperature	40 - 90	°C
Back Pressure	0.3 - 0.7	MPa
Screw Speed	40 - 80	rpm
Shot to Cylinder Size	50 - 80	%
Vent Depth	0.013 - 0.02	mm

Source GMD, last updated:08/08/2008

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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