XENOY™ Resin X5500EX
Asia Pacific: COMMERCIAL

Non-FR, non-UV PC/PBT blend for film extrusion application

TYPICAL PROPERTIES[1]	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	660	kgf/cm²	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	630	kgf/cm²	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	5.5	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	95	%	ASTM D 638
Tensile Modulus, 50 mm/min	25000	kgf/cm²	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	990	kgf/cm²	ASTM D 790
Flexural Stress, brk, 1.3 mm/min, 50 mm span	960	kgf/cm²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	23200	kgf/cm²	ASTM D 790
IMPACT			
Izod Impact, unnotched, 23°C	220	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	10	cm-kgf/cm	ASTM D 256
Instrumented Impact Total Energy, 23°C	713	cm-kgf	ASTM D 3763
THERMAL			
Vicat Softening Temp, Rate B/50	132	°C	ASTM D 1525
HDT, 0.45 MPa, 6.4 mm, unannealed	123	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	108	°C	ASTM D 648
PHYSICAL			
Specific Gravity	1.24	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm (5)	0.5 - 0.7	%	SABIC Method
Mold Shrinkage, xflow, 3.2 mm (5)	0.6 - 0.8	%	SABIC Method
Melt Flow Rate, 250°C/5.0 kgf	6.5	g/10 min	ASTM D 1238
Water Absorption, (23°C/sat)	0.04	%	ISO 62

(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.
(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 updated:

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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	120	°C
Drying Time	3 - 4	hrs
Drying Time (Cumulative)	12	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	250 - 265	°C
Nozzle Temperature	245 - 260	°C
Front - Zone 3 Temperature	250 - 265	°C
Middle - Zone 2 Temperature	245 - 260	°C
Rear - Zone 1 Temperature	240 - 255	°C
Mold Temperature	50 - 75	°C
Back Pressure	0.3 - 0.7	MPa
Screw Speed	50 - 100	rpm
Shot to Cylinder Size	40 - 80	%
Vent Depth	0.025 - 0.038	mm

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