

XYLEX™ RESIN X8409AC

REGION ASIA

DESCRIPTION

PC + Polyester, Injection (Blow) Molding, or Extrusion Blow molding grade, Chemical Resistance and Transparency

TYPICAL PROPERTY VALUES

Revision 20170913

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	57	MPa	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	55	MPa	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	6	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	92	%	ASTM D 638
Tensile Modulus, 50 mm/min	2370	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	94	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	2220	MPa	ASTM D 790
Tensile Stress, yield, 50 mm/min	60	MPa	ISO 527
Tensile Stress, break, 50 mm/min	60	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	5.8	%	ISO 527
Tensile Strain, break, 50 mm/min	117	%	ISO 527
Tensile Modulus, 1 mm/min	2180	MPa	ISO 527
Flexural Stress, break, 2 mm/min	89	MPa	ISO 178
Flexural Modulus, 2 mm/min	2000	MPa	ISO 178
IMPACT			
Izod Impact, notched, 23°C	854	J/m	ASTM D 256
Izod Impact, notched, -30°C	200	J/m	ASTM D 256
Instrumented Impact Total Energy, 23°C	70	J	ASTM D 3763
Izod Impact, notched 80*10*4 +23°C	10	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*4 -10°C	8	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	8	kJ/m ²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	8	kJ/m ²	ISO 179/1eA
THERMAL			
Vicat Softening Temp, Rate B/50	123	°C	ASTM D 1525
HDT, 0.45 MPa, 3.2 mm, unannealed	116	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	104	°C	ASTM D 648
CTE, -40°C to 40°C, flow	1.04E-04	1/°C	ASTM E 831

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
CTE, -40°C to 40°C, xflow	1.04E-04	1/°C	ASTME 831
Thermal Conductivity	0.23	W/m-°C	ISO 8302
CTE, -40°C to 40°C, flow	1.04E-04	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	1.04E-04	1/°C	ISO 11359-2
CTE, 23°C to 60°C, flow	6.E-05	1/°C	ISO 11359-2
CTE, 23°C to 60°C, xflow	7.E-05	1/°C	ISO 11359-2
Vicat Softening Temp, Rate B/50	121	°C	ISO 306
Vicat Softening Temp, Rate B/120	123	°C	ISO 306
HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm	102	°C	ISO 75/Ae
PHYSICAL			
Specific Gravity	1.2	-	ASTMD 792
Mold Shrinkage, flow, 3.2 mm (5)	0.5 – 0.8	%	SABIC method
Mold Shrinkage, xflow, 3.2 mm (5)	0.5 – 0.8	%	SABIC method
Melt Flow Rate, 265°C/2.16kgf	4	g/10 min	ASTMD 1238
Density	1.2	g/cm ³	ISO 1183
Water Absorption, (23°C/sat)	0.37	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.13	%	ISO 62
Melt Volume Rate, MVR at 265°C/2.16 kg	3	cm ³ /10 min	ISO 1133
OPTICAL			
Light Transmission, 2.54 mm	88	%	ASTMD 1003
Haze, 2.54 mm	1.5	%	ASTMD 1003
Refractive Index	1.576	-	ASTMD 542
EXTRUSION BLOW MOLDING			
Drying Temperature	75 – 90	°C	
Drying Time	4 – 6	hrs	
Drying Time (Cumulative)	24	hrs	
Maximum Moisture Content	0.01 – 0.02	%	
Melt Temperature (Parison)	250 – 270	°C	
Barrel - Zone 1 Temperature	235 – 260	°C	
Barrel - Zone 2 Temperature	235 – 260	°C	
Barrel - Zone 3 Temperature	235 – 260	°C	
Barrel - Zone 4 Temperature	235 – 260	°C	
Adapter - Zone 5 Temperature	235 – 260	°C	
Head - Zone 6 - Top Temperature	240 – 270	°C	
Head - Zone 7 - Middle Temperature	240 – 270	°C	
Head - Zone 7 - Bottom Temperature	240 – 270	°C	
Mold Temperature	30 – 75	°C	



DISCLAIMER

Any sale by SABIC, its subsidiaries and affiliates (each a "seller"), is made exclusively under seller's standard conditions of sale (available upon request) unless agreed otherwise in writing and signed on behalf of the seller. While the information contained herein is given in good faith, SELLER MAKES NO WARRANTY, EXPRESS OR IMPLIED, INCLUDING MERCHANTABILITY AND NONINFRINGEMENT OF INTELLECTUAL PROPERTY, NOR ASSUMES ANY LIABILITY, DIRECT OR INDIRECT, WITH RESPECT TO THE PERFORMANCE, SUITABILITY OR FITNESS FOR INTENDED USE OR PURPOSE OF THESE PRODUCTS IN ANY APPLICATION. Each customer must determine the suitability of seller materials for the customer's particular use through appropriate testing and analysis. No statement by seller concerning a possible use of any product, service or design is intended, or should be construed, to grant any license under any patent or other intellectual property right.