

XYLEX™ X7200MR resin

Polycarbonate + Polyester
SABIC Innovative Plastics Asia Pacific

Message:
Mold Release version of X7200

General Information			
Additive	Mold Release		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
--	1.20	g/cm ³	ASTM D792
--	1.18	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (265°C/2.16 kg)	12	g/10 min	ASTM D1238
Melt Volume-Flow Rate (MVR) (265°C/2.16 kg)	12.0	cm ³ /10min	ISO 1133
Molding Shrinkage			Internal Method
Flow : 3.20 mm	0.50 to 0.70	%	
Across Flow : 3.20 mm	0.50 to 0.70	%	
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore D, 10 sec)	76		ASTM D2240
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	1880	MPa	ASTM D638
--	2000	MPa	ISO 527-2/1
Tensile Strength			
Yield ²	55.0	MPa	ASTM D638
Yield	55.0	MPa	ISO 527-2/50
Break ³	56.0	MPa	ASTM D638
Break	56.0	MPa	ISO 527-2/50
Tensile Elongation			
Yield ⁴	5.0	%	ASTM D638
Yield	5.0	%	ISO 527-2/5
Break ⁵	140	%	ASTM D638
Break	> 150	%	ISO 527-2/50
Flexural Modulus			
50.0 mm Span ⁶	1960	MPa	ASTM D790
-- ⁷	2000	MPa	ISO 178
Flexural Stress			
--	75.0	MPa	ISO 178

Yield, 50.0 mm Span ⁸	84.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	900	J/m	ASTM D256
-10°C ⁹	5.0	kJ/m ²	ISO 180/1A
23°C ¹⁰	8.0	kJ/m ²	ISO 180/1A
Instrumented Dart Impact (23°C, Total Energy)	95.0	J	ASTM D3763
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed, 3.20 mm	96.0	°C	ASTM D648
1.8 MPa, Unannealed, 3.20 mm	90.0	°C	ASTM D648
1.8 MPa, Unannealed, 100 mm Span ¹¹	99.0	°C	ISO 75-2/Ae
Vicat Softening Temperature	115	°C	ISO 306/B120, ASTM D1525 ¹²
Ball Pressure Test ¹³ (105°C)	Pass		IEC 60695-10-2
CLTE			
Flow : -40 to 40°C	1.1E-4	cm/cm/°C	ASTM E831
Flow : 23 to 60°C	8.0E-5	cm/cm/°C	ISO 11359-2
Transverse : -40 to 40°C	1.1E-4	cm/cm/°C	ASTM E831
Transverse : 23 to 60°C	8.0E-5	cm/cm/°C	ISO 11359-2
Thermal Conductivity	0.23	W/m/K	ISO 8302
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	> 1.0E+15	ohms	ASTM D257
Volume Resistivity	> 1.0E+15	ohms · cm	ASTM D257
Flammability	Nominal Value	Unit	Test Method
Flame Rating (3.00 mm)	V-2		UL 94
Glow Wire Flammability Index (1.00 mm)	750	°C	IEC 60695-2-12
Optical	Nominal Value	Unit	Test Method
Refractive Index	1.557		ISO 489
Transmittance (2540 µm)	88.0	%	ASTM D1003
Haze (2540 µm)	1.1	%	ASTM D1003
Injection	Nominal Value	Unit	
Drying Temperature	82.2 to 93.3	°C	
Drying Time	3.0 to 5.0	hr	
Drying Time, Maximum	8.0	hr	
Suggested Max Moisture	0.020	%	
Suggested Shot Size	40 to 80	%	
Rear Temperature	238 to 249	°C	
Middle Temperature	243 to 266	°C	
Front Temperature	249 to 271	°C	
Nozzle Temperature	249 to 271	°C	
Processing (Melt) Temp	249 to 271	°C	

Mold Temperature	43.3 to 60.0	°C
Back Pressure	0.172 to 0.517	MPa
Screw Speed	20 to 100	rpm
Vent Depth	0.013 to 0.020	mm

NOTE

1.	50 mm/min
2.	Type I, 50 mm/min
3.	Type I, 50 mm/min
4.	Type I, 50 mm/min
5.	Type I, 50 mm/min
6.	1.3 mm/min
7.	2.0 mm/min
8.	1.3 mm/min
9.	80*10*4
10.	80*10*4
11.	120*10*4 mm
12.	Rate B (120°C/h), Loading 2 (50 N)
13.	Approximate maximum

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