

XENOY™ 1731 resin

Polycarbonate + PBT

SABIC Innovative Plastics

Message:

Impact/chemical resistant. UV-Stabilized. Excellent physical property retention in automotive exteriors and OVAD.

General Information			
UL YellowCard	E45587-236856	E207780-643578	
Additive	UV stabilizer		
Features	Impact resistance, good		
	Good chemical resistance		
Uses	Automotive exterior parts		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.22	g/cm³	ASTM D792
Specific Volume	0.820	cm³/g	ASTM D792
Molding Shrinkage			Internal method
Flow: 3.20mm	0.50 - 0.70	%	Internal method
Transverse flow: 3.20mm	0.60 - 0.80	%	Internal method
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield)	61.4	MPa	ASTM D638
Tensile Elongation ² (Break)	120	%	ASTM D638
Flexural Modulus ³ (50.0 mm Span)	2340	MPa	ASTM D790
Flexural Strength ⁴ (Yield, 50.0 mm Span)	93.1	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-30°C	110	J/m	ASTM D256
23°C	670	J/m	ASTM D256
23°C, 6.40 mm	160	J/m	ASTM D256
Instrumented Dart Impact			ASTM D3763
-30°C, Total Energy	61.5	J	ASTM D3763
23°C, Total Energy	61.1	J	ASTM D3763
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, unannealed, 6.40mm	116	°C	ASTM D648
1.8 MPa, unannealed, 6.40mm	107	°C	ASTM D648
CLTE - Flow (-40 to 95°C)	8.3E-5	cm/cm/°C	ASTM E831
RTI Elec	75.0	°C	UL 746
RTI Imp	75.0	°C	UL 746

RTI	75.0	°C	UL 746
Electrical	Nominal Value		Test Method
Arc Resistance ⁵	PLC 5		ASTM D495
Comparative Tracking Index (CTI)	PLC 2		UL 746
High Amp Arc Ignition (HAI)	PLC 0		UL 746
High Voltage Arc Tracking Rate (HVTR)	PLC 2		UL 746
Hot-wire Ignition (HWI)	PLC 2		UL 746
Flammability	Nominal Value		Test Method
Flame Rating (1.50 mm)	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	110	°C	
Drying Time	4.0 - 6.0	hr	
Drying Time, Maximum	8.0	hr	
Suggested Max Moisture	0.020	%	
Suggested Shot Size	50 - 80	%	
Rear Temperature	243 - 266	°C	
Middle Temperature	249 - 271	°C	
Front Temperature	254 - 277	°C	
Nozzle Temperature	254 - 271	°C	
Processing (Melt) Temp	260 - 277	°C	
Mold Temperature	65.6 - 87.8	°C	
Back Pressure	0.345 - 0.689	MPa	
Screw Speed	50 - 80	rpm	
Vent Depth	0.013 - 0.020	mm	
NOTE			
1.	Type 1, 50mm/min		
2.	Type 1, 50mm/min		
3.	1.3 mm/min		
4.	1.3 mm/min		
5.	Tungsten electrode		

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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China



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