

XYLEX™ X7507 resin

Polycarbonate + Polyester

SABIC Innovative Plastics

Message:

F-1 weathering certified in natural color, specially designed for Pool & Spa applications. Currently available in natural color only.

General Information			
Uses	Mineral spring recuperation supplies		
Appearance	Natural color		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.20	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (265°C/2.16 kg)	8.0	g/10 min	ASTM D1238
Melt Volume-Flow Rate (MVR) (265°C/2.16 kg)	5.00	cm ³ /10min	ISO 1133
Molding Shrinkage - Flow (3.20 mm)	0.50 - 0.80	%	Internal method
Water Absorption			ISO 62
Saturated, 23°C	0.32	%	ISO 62
Equilibrium, 23°C, 50% RH	0.12	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	2300	MPa	ASTM D638
--	2660	MPa	ISO 527-2/1
Tensile Strength			
Yield ²	61.0	MPa	ASTM D638
Yield	62.0	MPa	ISO 527-2/50
Fracture ³	65.0	MPa	ASTM D638
Fracture	59.0	MPa	ISO 527-2/50
Tensile Elongation			
Yield ⁴	6.0	%	ASTM D638
Yield	5.4	%	ISO 527-2/50
Fracture ⁵	130	%	ASTM D638
Fracture	110	%	ISO 527-2/50
Flexural Modulus			
50.0mm span ⁶	2320	MPa	ASTM D790
-- ⁷	2190	MPa	ISO 178
Flexural Stress			
--	92.0	MPa	ISO 178
Yield, 50.0mm span ⁸	96.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method

Charpy Notched Impact Strength ⁹ (23°C)	20	kJ/m ²	ISO 179/1eA
Notched Izod Impact			
-30°C	200	J/m	ASTM D256
23°C	990	J/m	ASTM D256
-30°C ¹⁰	6.0	kJ/m ²	ISO 180/1A
23°C ¹¹	9.0	kJ/m ²	ISO 180/1A
Instrumented Dart Impact (23°C, Total Energy)	79.0	J	ASTM D3763
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
1.8 MPa, unannealed, 3.20mm	104	°C	ASTM D648
1.8 MPa, unannealed, 64.0mm span ¹²	105	°C	ISO 75-2/Af
Vicat Softening Temperature			
--	125	°C	ASTM D1525, ISO 306/B50 ¹³
--	127	°C	ISO 306/B120
Linear thermal expansion coefficient			
Flow: -40 to 40°C	6.0E-5	cm/cm/°C	ASTM E831, ISO 11359-2
Lateral: -40 to 40°C	7.0E-5	cm/cm/°C	ASTM E831
Lateral: -40 to 40°C	6.3E-5	cm/cm/°C	ISO 11359-2
Optical	Nominal Value	Unit	Test Method
Transmittance (2540 µm)	> 85.0	%	ASTM D1003
Haze (2540 µm)	1.6	%	ASTM D1003
Injection	Nominal Value	Unit	
Drying Temperature	82.2 - 93.3	°C	
Drying Time	3.0 - 5.0	hr	
Drying Time, Maximum	8.0	hr	
Suggested Max Moisture	0.020	%	
Suggested Shot Size	40 - 80	%	
Rear Temperature	238 - 249	°C	
Middle Temperature	243 - 266	°C	
Front Temperature	249 - 271	°C	
Nozzle Temperature	249 - 271	°C	
Processing (Melt) Temp	249 - 271	°C	
Mold Temperature	43.3 - 60.0	°C	
Back Pressure	0.172 - 0.517	MPa	
Screw Speed	20 - 100	rpm	
Vent Depth	0.013 - 0.020	mm	
NOTE			
1.	5.0 mm/min		
2.	Type 1, 50mm/min		
3.	Type 1, 50mm/min		
4.	Type 1, 50mm/min		

5.	Type 1, 50mm/min
6.	1.3 mm/min
7.	2.0 mm/min
8.	1.3 mm/min
9.	80*10*4 sp=62mm
10.	80*10*4
11.	80*10*4
12.	80*10*4 mm
13.	标准 B (120°C/h), 载荷2 (50N)

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