

XENOY™ X5630Q resin

Polycarbonate + PET

SABIC Innovative Plastics Europe

Message:

Mineral filled PC/PET blend with high heat dimensional stability, low shrinkage and low CTE, especially for painted applications

General Information			
Filler / Reinforcement	Mineral		
Features	Good Dimensional Stability		
	Low CLTE		
	Low Shrinkage		
RoHS Compliance	RoHS Compliant		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.35	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (265°C/5.0 kg)	18	g/10 min	ASTM D1238
Melt Volume-Flow Rate (MVR) (265°C/5.0 kg)	15.0	cm ³ /10min	ISO 1133
Molding Shrinkage - Flow ¹	0.50 to 0.70	%	Internal Method
Water Absorption			ISO 62
Saturation, 23°C	0.42	%	
Equilibrium, 23°C, 50% RH	0.14	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	4150	MPa	ISO 527-2/1
Tensile Stress			ISO 527-2/5
Yield	56.0	MPa	
Break	50.0	MPa	
Tensile Strain			ISO 527-2/5
Yield	3.2	%	
Break	8.0	%	
Flexural Modulus ²	4050	MPa	ISO 178
Flexural Stress	90.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ³ (23°C)	8.0	kJ/m ²	ISO 179/1eA
Notched Izod Impact Strength ⁴			ISO 180/1A
-30°C	6.0	kJ/m ²	
23°C	8.0	kJ/m ²	
Unnotched Izod Impact Strength ⁵			ISO 180/1U
-30°C	80	kJ/m ²	

23°C	100	kJ/m ²	
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature ⁶ (1.8 MPa, Unannealed, 64.0 mm Span)	110	°C	ISO 75-2/Af
Vicat Softening Temperature			
--	137	°C	ISO 306/B50
--	140	°C	ISO 306/B120
CLTE			ISO 11359-2
Flow : -30 to 80°C	5.2E-5	cm/cm/°C	
Transverse : -30 to 80°C	7.2E-5	cm/cm/°C	
Injection	Nominal Value	Unit	
Drying Temperature	110 to 120	°C	
Drying Time	4.0 to 6.0	hr	
Suggested Max Moisture	0.020	%	
Hopper Temperature	60.0 to 80.0	°C	
Rear Temperature	240 to 270	°C	
Middle Temperature	250 to 275	°C	
Front Temperature	260 to 280	°C	
Nozzle Temperature	260 to 275	°C	
Processing (Melt) Temp	265 to 275	°C	
Mold Temperature	60.0 to 100	°C	
NOTE			
1.	Tensile Bar		
2.	2.0 mm/min		
3.	80*10*4 sp=62mm		
4.	80*10*4		
5.	80*10*4		
6.	80*10*4 mm		

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