XENOY™ RESIN 1103

REGION AMERICAS

DESCRIPTION

AUTOMOTIVE. Unreinforced, impact modified PBT+PC alloy. Excellent low temperature impact and chemical resistance. Range gray, black colors.

TYPICAL PROPERTY VALUES

Revision 20190702

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	51	MPa	ASTM D638
Tensile Stress, brk, Type I, 50 mm/min	50	MPa	ASTM D638
Tensile Strain, yld, Type I, 50 mm/min	5	%	ASTM D638
Tensile Strain, brk, Type I, 50 mm/min	150	%	ASTM D638
Tensile Modulus, 50 mm/min	1890	MPa	ASTM D638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	77	MPa	ASTM D790
Flexural Modulus, 1.3 mm/min, 50 mm span	1930	MPa	ASTM D790
IMPACT			
Izod Impact, notched, 23°C	747	J/m	ASTM D256
Instrumented Dart Impact Total Energy, 23°C	61	J	ASTM D3763
THERMAL			
Vicat Softening Temp, Rate B/50	125	°C	ASTM D1525
HDT, 0.45 MPa, 3.2 mm, unannealed	104	°C	ASTM D648
HDT, 1.82 MPa, 3.2mm, unannealed	87	°C	ASTM D648
CTE, -40°C to 40°C, flow	1.71E-04	1/°C	ASTM E831
CTE, -40°C to 40°C, xflow	2.E-04	1/°C	ASTM E831
PHYSICAL			
Specific Gravity	1.2	-	ASTM D792
Mold Shrinkage, flow, 3.2 mm	0.8 – 1	%	SABIC method
Melt Flow Rate, 250°C/5.0 kgf	13	g/10 min	ASTM D1238
FLAME CHARACTERISTICS			
UL Yellow Card Link	E121562-100149124	-	-
INJECTION MOLDING			
Drying Temperature	110	°C	
Drying Time	4 – 6	Hrs	
Drying Time (Cumulative)	8	Hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	255 – 275	°C	
Nozzle Temperature	250 – 265	°C	
Front - Zone 3 Temperature	250 – 270	°C	
Middle - Zone 2 Temperature	245 – 265	°C	
Rear - Zone 1 Temperature	240 – 260	°C	
Mold Temperature	40 – 90	°C	
Back Pressure	0.3 – 0.7	MPa	
Screw Speed	40 – 80	rpm	

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Shot to Cylinder Size	50 – 80	%	
Vent Depth	0.013 – 0.02	mm	

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