

Xenoy* Resin 1101

Americas: COMMERCIAL

Unreinforced, opaque polycarbonate/polyester alloy. Excellent low temperature impact plus chemical resistance to automotive fluid.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	52	MPa	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	58	MPa	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	120	%	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	84	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	2040	MPa	ASTM D 790
IMPACT			
Izod Impact, notched, 23°C	710	J/m	ASTM D 256
Izod Impact, notched, 0°C	678	J/m	ASTM D 256
Izod Impact, notched, -20°C	608	J/m	ASTM D 256
Izod Impact, notched, -40°C	299	J/m	ASTM D 256
Gardner, 23°C	54	J	ASTM D 3029
THERMAL			
HDT, 0.45 MPa, 6.4 mm, unannealed	106	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	98	°C	ASTM D 648
CTE, -40°C to 95°C, flow	9.E-05	1/°C	ASTM E 831
PHYSICAL			
Specific Gravity	1.21	-	ASTM D 792
Specific Volume	0.82	cm³/g	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	0.8 - 1	%	SABIC Method



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PROCESSING PARAMETERS	TYPICAL VALUE	UNIT
Injection Molding		
Drying Temperature	110	°C
Drying Time	4 - 6	hrs
Drying Time (Cumulative)	8	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	260 - 275	°C
Nozzle Temperature	255 - 270	°C
Front - Zone 3 Temperature	255 - 275	°C
Middle - Zone 2 Temperature	250 - 270	°C
Rear - Zone 1 Temperature	245 - 265	°C
Mold Temperature	65 - 90	°C
Back Pressure	0.3 - 0.7	MPa
Screw Speed	50 - 80	rpm
Shot to Cylinder Size	50 - 80	%
Vent Depth	0.013 - 0.02	mm

