

Xenoy* Resin 1102

Americas: COMMERCIAL

Unreinforced PC/polyester alloy. Excellent low temperature impact/chemical resistance to automotive fluids.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	54	MPa	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	150	%	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	82	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	1960	MPa	ASTM D 790
IMPACT			
Izod Impact, notched, 23°C	801	J/m	ASTM D 256
Izod Impact, notched, 0°C	694	J/m	ASTM D 256
Izod Impact, notched, -30°C	640	J/m	ASTM D 256
THERMAL			
HDT, 0.45 MPa, 6.4 mm, unannealed	110	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	90	°C	ASTM D 648
PHYSICAL			
Specific Gravity	1.2	-	ASTM D 792
Specific Volume	0.83	cm³/g	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	0.8 - 1	%	SABIC Method
Mold Shrinkage, xflow, 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

