

Xenoy* Resin 1402B

Americas: COMMERCIAL

Blowmoldable, unreinforced PC/polyester alloy. Characterized by high melt viscosity/strength with excellent low temperature impact.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	48	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	68	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	1990	MPa	ASTM D 790
IMPACT			
Izod Impact, notched, 23°C	694	J/m	ASTM D 256
Izod Impact, notched, -30°C	534	J/m	ASTM D 256
Modified Gardner, 23°C	44	J	ASTM D 3029
THERMAL			
HDT, 1.82 MPa, 6.4 mm, unannealed	96	°C	ASTM D 648
PHYSICAL			
Specific Gravity	1.19	-	ASTM D 792
Specific Volume	0.84	cm ³ /g	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	0.9 - 1.1	%	SABIC Method
Mold Shrinkage on Tensile Bar, xflow (2)	0.9 - 1.1	%	SABIC Method



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PROCESSING PARAMETERS	TYPICAL VALUE	UNIT
Extrusion Blow Molding		
Drying Temperature	95 - 100	°C
Drying Time	4 - 6	hrs
Drying Time (Cumulative)	24	hrs
Maximum Moisture Content	0.01 - 0.02	%
Minimum Moisture Content	0.02	%
Melt Temperature (Parison)	240 - 250	°C
Barrel - Zone 1 Temperature	235 - 245	°C
Barrel - Zone 2 Temperature	235 - 245	°C
Barrel - Zone 3 Temperature	235 - 245	°C
Barrel - Zone 4 Temperature	235 - 245	°C
Adapter - Zone 5 Temperature	235 - 245	°C
Head - Zone 6 - Top Temperature	235 - 245	°C
Head - Zone 7 - Bottom Temperature	235 - 245	°C
Mold Temperature	65 - 90	°C
Die Temperature	240 - 250	°C

- Purge with HDPE prior to changing screw, head, or die tooling and/or machine shutdown.
- Use moderate-slow screw speeds to keep melt temperature in suggested range. Suggested screw speed: 15 - 50 rpm. Actual rpm should be adjusted for desired output.
- Processing temperature must be measured with a hand-held probe as opposed to an internal-head probe.
- A reverse barrel profile may increase output while maintaining the melt temperature.

