



XENOY® CL100

Europe-Africa-Middle East: **COMMERCIAL**

PBT+PC Thermoplastic Alloy

XENOY CL100 has been specifically developed to obtain good low temperature impact strength, excellent UV stability and resistance to occasional solvent and gasoline contact. XENOY CL100 is particularly suited for unpainted exterior automotive body components.

Features

Heat Stabilized

High Impact

Light stabilized

TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
MECHANICAL			
Taber Abrasion, CS-17, 1 kg	30	mg/1000cy	GE Method
Tensile Stress, yield, 50 mm/min	55	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	5	%	ISO 527
Tensile Strain, break, 50 mm/min	75	%	ISO 527
Tensile Modulus, 1 mm/min	2200	MPa	ISO 527
Flexural Strength, yield, 2 mm/min	85	MPa	ISO 178
Flexural Modulus, 2 mm/min	2200	MPa	ISO 178
Hardness, H358/30	96	MPa	ISO 2039-1
Hardness, Rockwell L	94	-	ISO 2039-2
IMPACT			
Izod Impact, unnotched 80*10*4 +23°C	NB	kJ/m ²	ISO 180/1U
Izod Impact, unnotched 80*10*4 -30°C	NB	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	46	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	21	kJ/m ²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	50	kJ/m ²	ISO 179/1eA
Charpy Impact, notched, 23°C	30	kJ/m ²	ISO 179/2C
Charpy -30°C, V-notch Edgew 80*10*4 sp=62mm	35	kJ/m ²	ISO 179/1eA
Charpy Impact, notched, -20°C	10	kJ/m ²	ISO 179/2C
Charpy Impact, notched, -30°C	10	kJ/m ²	ISO 179/2C
Charpy 23°C, Unnotch Edgew 80*10*4 sp=62mm	NB	kJ/m ²	ISO 179/1eU
Charpy -30°C, Unnotch Edgew 80*10*4 sp=62mm	NB	kJ/m ²	ISO 179/1eU
THERMAL			



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TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
Thermal Conductivity	0.18	W/m-°C	ISO 8302
CTE, 23°C to 80°C, flow	9.E-05	1/°C	ISO 11359-2
CTE, 23°C to 80°C, xflow	9.E-05	1/°C	ISO 11359-2
Ball Pressure Test, 75°C +/- 2°C	PASSES	-	IEC 60695-10-2
Vicat A/50	150	°C	ISO 306
Vicat B/50	125	°C	ISO 306
Vicat B/120	127	°C	ISO 306
HDT/Be, 0.45MPa Edgew 120*10*4 sp=100mm	110	°C	ISO 75/Be
HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm	90	°C	ISO 75/Ae
Relative Temp Index, Elec	75	°C	UL 746B
Relative Temp Index, Mech w/impact	75	°C	UL 746B
Relative Temp Index, Mech w/o impact	75	°C	UL 746B
PHYSICAL			
Mold Shrinkage on Tensile Bar, flow (2)	0.7 - 1	%	ASTM D 955
Mold Shrinkage on Tensile Bar, xflow (2)	0.7 - 1	%	ASTM D 955
Density	1.22	g/cm ³	ISO 1183
Water Absorption, (23°C/sat) 1L	0.5	%	ISO 62
Moisture Absorption (23°C / 50% RH) 1L	0.15	%	ISO 62
Melt Volume Rate, MVR at 250°C/5.0 kg	13	cm ³ /10 min	ISO 1133
ELECTRICAL			
Volume Resistivity	>1.E+14	Ohm-cm	IEC 60093
Surface Resistivity, ROA	>1.E+15	Ohm	IEC 60093
Dielectric Strength, shorttime, 1.0mm	18	kV/mm	IEC 60243-1
Dielectric Strength, in oil, 3.2 mm	17	kV/mm	IEC 60243-1
Relative Permittivity, 50/60 Hz	3.3	-	IEC 60250
Relative Permittivity, 1 MHz	3.3	-	IEC 60250
Dissipation Factor, 50/60 Hz	0.002	-	IEC 60250
Dissipation Factor, 1 MHz	0.02	-	IEC 60250
FLAME CHARACTERISTICS			
UL Recognized, 94HB Flame Class Rating (3)	1.5	mm	UL 94
UL Recognized, 94HB Flame Class Rating 2nd value (3)	3	mm	UL 94
FMVSS Burning Speed, thickness 1 mm	45	mm/min	FMVSS 302





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PROCESSING PARAMETERS	TYPICAL VALUE	UNIT
Injection Molding		
Drying Temperature	90 - 100	°C
Drying Time	2 - 4	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	255 - 270	°C
Nozzle Temperature	250 - 265	°C
Front - Zone 3 Temperature	250 - 270	°C
Middle - Zone 2 Temperature	240 - 265	°C
Rear - Zone 1 Temperature	230 - 250	°C
Hopper Temperature	40 - 60	°C
Mold Temperature	60 - 80	°C





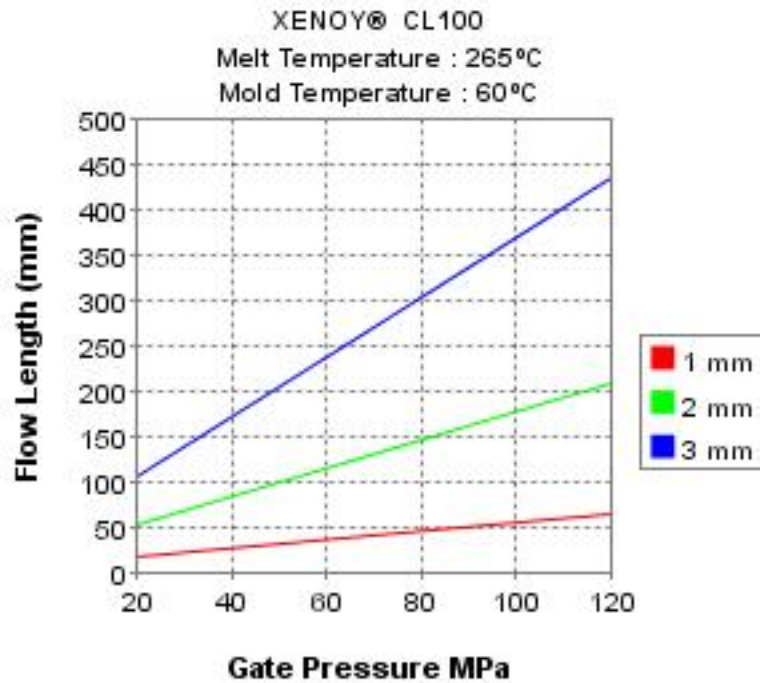
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CALCULATED FLOW LENGTH INDICATION

Moldflow® Radial Flow Analysis



Note: Technical support is recommended if Gate Pressure is greater than 80 MPa. Contact your local representative.

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