

Xenoy* Resin X1200UV
Americas: COMMERCIAL

PBT+PC, Low temperture impact resistance, UV Stabilized

TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	56	MPa	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	56	MPa	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	4.5	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	147	%	ASTM D 638
Tensile Modulus, 50 mm/min	2300	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	87	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	2290	MPa	ASTM D 790
Tensile Stress, yield, 50 mm/min	54	MPa	ISO 527
Tensile Stress, break, 50 mm/min	55	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	4.6	%	ISO 527
Tensile Strain, break, 50 mm/min	157	%	ISO 527
Flexural Stress, yield, 2 mm/min	82	MPa	ISO 178
Flexural Modulus, 2 mm/min	1630	MPa	ISO 178
IMPACT			
Izod Impact, notched, 23°C	828	J/m	ASTM D 256
Izod Impact, notched, -30°C	668	J/m	ASTM D 256
Instrumented Impact Total Energy, 23°C	145	J	ASTM D 3763
Izod Impact, notched 80*10*4 +23°C	56	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	35	kJ/m ²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	69	kJ/m ²	ISO 179/1eA
THERMAL			
Vicat Softening Temp, Rate B/50	119	°C	ASTM D 1525
HDT, 1.82 MPa, 3.2mm, unannealed	88	°C	ASTM D 648



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TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
THERMAL			
CTE, -40°C to 40°C, flow	7.55E+01	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	8.E+01	1/°C	ISO 11359-2
Vicat Softening Temp, Rate B/50	123	°C	ISO 306
Vicat Softening Temp, Rate B/120	124	°C	ISO 306
PHYSICAL			
Specific Gravity	1.21	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	0.9 - 1	%	SABIC Method
Mold Shrinkage, xflow, 3.2 mm	0.9 - 1	%	SABIC Method
Melt Flow Rate, 250°C/5.0 kgf	15.3	g/10 min	ASTM D 1238
Density	1.21	g/cm ³	ISO 1183
Melt Volume Rate, MVR at 250°C/5.0 kg	15	cm ³ /10 min	ISO 1133



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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

