

**XENYO® CL404**Europe-Africa-Middle East: **COMMERCIAL****PBT+PC Thermoplastic Alloy**

XENYO CL404 has been specially developed for extrusion and blow moulding applications, where higher melt strength is desired. XENYO CL404 is a high impact material combined with good UV weathering performance and chemical resistance.

Features

Heat Stabilized

High Impact

Light stabilized

TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
MECHANICAL			
Tensile Stress, yield, 50 mm/min	45	MPa	ISO 527
Tensile Stress, break, 50 mm/min	40	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	4.5	%	ISO 527
Tensile Strain, break, 50 mm/min	90	%	ISO 527
Tensile Modulus, 1 mm/min	2000	MPa	ISO 527
Flexural Modulus, 2 mm/min	1900	MPa	ISO 178
IMPACT			
Izod Impact, unnotched 80*10*4 +23°C	NB	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	50	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*4 -20°C	45	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 23°C, Unnotch Edgew 80*10*4 sp=62mm	NB	kJ/m ²	ISO 179/1eU
THERMAL			
CTE, 23°C to 80°C, flow	1.1E-04	1/°C	ISO 11359-2
Ball Pressure Test, 75°C +/- 2°C	PASSES	-	IEC 60695-10-2
Vicat B/50	123	°C	ISO 306
Vicat B/120	125	°C	ISO 306
HDT/Be, 0.45MPa Edgew 120*10*4 sp=100mm	105	°C	ISO 75/Be
HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm	87	°C	ISO 75/Ae
PHYSICAL			
Mold Shrinkage on Tensile Bar, flow (2)	0.7 - 1.1	%	ASTM D 955
Density	1.2	g/cm ³	ISO 1183





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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	5	cm ³ /10 min	ISO 1133
ELECTRICAL			
Volume Resistivity	1.E+15	Ohm-cm	IEC 60093
Surface Resistivity, ROA	>1.E+15	Ohm	IEC 60093
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	3.1	-	IEC 60250
Dissipation Factor, 50/60 Hz	0.002	-	IEC 60250
Dissipation Factor, 1 MHz	0.02	-	IEC 60250
FLAME CHARACTERISTICS			
UL Compliant, 94HB Flame Class Rating (3)(4)	1.6	mm	UL 94 by GE





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PROCESSING PARAMETERS	TYPICAL VALUE	UNIT
Profile Extrusion		
Drying Temperature	110	°C
Drying Time	2 - 4	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	235 - 270	°C
Barrel - Zone 1 Temperature	220 - 250	°C
Barrel - Zone 2 Temperature	230 - 260	°C
Barrel - Zone 3 Temperature	230 - 270	°C
Barrel - Zone 4 Temperature	230 - 270	°C
Hopper Temperature	40 - 60	°C
Adapter Temperature	240 - 260	°C
Die Temperature	240 - 260	°C
Calibrator Temperature	70 - 90	°C

