

Xenoy* Resin 5230R

Americas: COMMERCIAL

Unreinforced PBT+PC alloy. Excellent impact/chemical resistance and dimensional stability. Internal mold release.

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	110	%	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	85	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	2130	MPa	ASTM D 790
IMPACT			
Izod Impact, notched, 23°C	640	J/m	ASTM D 256
Izod Impact, notched, -30°C	213	J/m	ASTM D 256
Izod Impact, notched, -40°C	170	J/m	ASTM D 256
Instrumented Impact Energy @ peak, 23°C	50	J	ASTM D 3763
Instrumented Impact Energy @ peak, -40°C	56	J	ASTM D 3763
THERMAL			
HDT, 0.45 MPa, 6.4 mm, unannealed	115	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	96	°C	ASTM D 648
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			
Specific Gravity	1.22	-	ASTM D 792
Specific Volume	0.82	cm³/g	ASTM D 792
Water Absorption, 24 hours	0.12	%	ASTM D 570
Mold Shrinkage, flow, 3.2 mm	0.6 - 0.9	%	SABIC Method
ELECTRICAL			
Volume Resistivity	5.3E+16	Ohm-cm	ASTM D 257
Dielectric Strength, in air, 1.6 mm	27.9	kV/mm	ASTM D 149
Dielectric Strength, in air, 3.2 mm	18.3	kV/mm	ASTM D 149



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TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
ELECTRICAL			
Relative Permittivity, 100 Hz	3.04	-	ASTM D 150
Relative Permittivity, 1 MHz	3.14	-	ASTM D 150
Dissipation Factor, 100 Hz	0.002	-	ASTM D 150
Dissipation Factor, 1 MHz	0.03	-	ASTM D 150
FLAME CHARACTERISTICS			
UL Recognized, 94HB Flame Class Rating (3)	1.49	mm	UL 94



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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

