

Xylex* Resin X7503

Asia Pacific: COMMERCIAL

Clear PC-Siloxane copolymer + Polyester alloy

TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	580	kgf/cm ²	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	560	kgf/cm ²	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	5	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	100	%	ASTM D 638
Tensile Modulus, 5 mm/min	21400	kgf/cm ²	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	870	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	19300	kgf/cm ²	ASTM D 790
Tensile Stress, yield, 50 mm/min	58	MPa	ISO 527
Tensile Stress, break, 50 mm/min	54	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	6	%	ISO 527
Tensile Strain, break, 50 mm/min	100	%	ISO 527
Tensile Modulus, 1 mm/min	2100	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	84	MPa	ISO 178
Flexural Modulus, 2 mm/min	2100	MPa	ISO 178
IMPACT			
Izod Impact, notched, 23°C	93	cm-kgf/cm	ASTM D 256
Izod Impact, notched, -30°C	76	cm-kgf/cm	ASTM D 256
Instrumented Impact Total Energy, 23°C	723	cm-kgf	ASTM D 3763
Izod Impact, notched 80*10*4 +23°C	68	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	17	kJ/m ²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	70	kJ/m ²	ISO 179/1eA
THERMAL			
Vicat Softening Temp, Rate B/50	132	°C	ASTM D 1525



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THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	124	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	110	°C	ASTM D 648
CTE, -40°C to 40°C, flow	7.E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	7.E-05	1/°C	ASTM E 831
CTE, 23°C to 60°C, flow	7.7E-05	1/°C	ISO 11359-2
CTE, 23°C to 60°C, xflow	7.8E-05	1/°C	ISO 11359-2
Vicat Softening Temp, Rate B/50	130	°C	ISO 306
Vicat Softening Temp, Rate B/120	132	°C	ISO 306
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	124	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	110	°C	ISO 75/Af
PHYSICAL			
Specific Gravity	1.2	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	0.6 - 0.8	%	SABIC Method
Melt Flow Rate, 265°C/2.16kg	8	g/10 min	ASTM D 1238
Density	1.2	g/cm ³	ISO 1183
Water Absorption, (23°C/sat)	0.5	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.2	%	ISO 62
Melt Volume Rate, MVR at 265°C/2.16 kg	8	cm ³ /10 min	ISO 1133
OPTICAL			
Light Transmission	86	%	ASTM D 1003
Haze	2	%	ASTM D 1003
FLAME CHARACTERISTICS			
UL Recognized, 94V-2 Flame Class Rating (3)	3	mm	UL 94



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PROCESSING PARAMETERS	TYPICAL VALUE	UNIT
Injection Molding		
Drying Temperature	65 - 80	°C
Drying Time	3 - 5	hrs
Drying Time (Cumulative)	8	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	250 - 290	°C
Nozzle Temperature	250 - 290	°C
Front - Zone 3 Temperature	250 - 290	°C
Middle - Zone 2 Temperature	245 - 280	°C
Rear - Zone 1 Temperature	245 - 255	°C
Mold Temperature	45 - 60	°C
Back Pressure	0.2 - 0.5	MPa
Screw Speed	20 - 100	rpm
Shot to Cylinder Size	40 - 80	%
Vent Depth	0.013 - 0.02	mm

