



XENOY® 2230EU
Americas: **COMMERCIAL**

Unreinforced, opaque PC+PET alloy. Chemical resistance, dimensional stability and mechanical performance.
UV stabilized/easy flow version of 2230.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	55	MPa	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	120	%	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	86	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	2240	MPa	ASTM D 790
Hardness, Rockwell R	115	-	ASTM D 785
IMPACT			
Izod Impact, notched, 23°C	801	J/m	ASTM D 256
Gardner, 23°C	54	J	ASTM D 3029
THERMAL			
HDT, 0.45 MPa, 6.4 mm, unannealed	129	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	121	°C	ASTM D 648
CTE, -40°C to 40°C, flow	5.4E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	6.12E-05	1/°C	ASTM E 831
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	cm ³ /g	ASTM D 792
Water Absorption, 24 hours	0.14	%	ASTM D 570
Water Absorption, equilibrium, 23C	0.6	%	ASTM D 570
Mold Shrinkage, flow, 3.2 mm	0.6 - 0.9	%	GE Method
Mold Shrinkage on Tensile Bar, xflow (2)	0.6 - 0.9	%	GE Method
ELECTRICAL			
Volume Resistivity	2.1E+16	Ohm-cm	ASTM D 257
Dielectric Strength, in air, 3.2 mm	21.3	kV/mm	ASTM D 149
Relative Permittivity, 100 Hz	3.6	-	ASTM D 150
Relative Permittivity, 1 MHz	3.2	-	ASTM D 150
Dissipation Factor, 100 Hz	0.002	-	ASTM D 150
Dissipation Factor, 1 MHz	0.005	-	ASTM D 150





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FLAME CHARACTERISTICS			
UL Recognized, 94HB Flame Class Rating (3)	0.8	mm	UL 94
UV-light, water exposure/immersion	F1	-	UL 746C





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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 - 280	°C
Nozzle Temperature	255 - 275	°C
Front - Zone 3 Temperature	260 - 280	°C
Middle - Zone 2 Temperature	255 - 275	°C
Rear - Zone 1 Temperature	250 - 270	°C
Mold Temperature	65 - 95	°C
Back Pressure	0.3 - 0.6	MPa
Screw Speed	50 - 80	rpm
Shot to Cylinder Size	50 - 80	%
Vent Depth	0.013 - 0.02	mm

