



XENOY™ Resin X5300WX

Americas: COMMERCIAL

Unreinforced, opaque PBT+PC alloy. Chemical resistance and good mechanical performance. UV-stabilized. Excellent weatherability.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	630	kgf/cm ²	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	520	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	110	%	ASTM D 638
Tensile Modulus, 50 mm/min	26000	kgf/cm ²	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	970	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	25200	kgf/cm ²	ASTM D 790
Tensile Stress, yield, 50 mm/min	62	MPa	ISO 527
Tensile Stress, break, 50 mm/min	51	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	5	%	ISO 527
Tensile Strain, break, 50 mm/min	110	%	ISO 527
Tensile Modulus, 1 mm/min	2250	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	87	MPa	ISO 178
Flexural Modulus, 2 mm/min	2180	MPa	ISO 178
IMPACT			
Izod Impact, notched, 23°C	76	cm-kgf/cm	ASTM D 256
Izod Impact, notched, -30°C	18	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	50	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	15	kJ/m ²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	45	kJ/m ²	ISO 179/1eA
THERMAL			
Vicat Softening Temp, Rate B/50	135	°C	ASTM D 1525

(1) Typical values only. Variations within normal tolerances are possible for various colors. All values are measured after at least 48 hours storage at 23°C/50% relative humidity. All properties, except the melt volume and melt flow rates, are measured on injection molded samples. All samples tested under ISO test standards are prepared according to ISO 294.

(2) Only typical data for selection purposes. Not to be used for part or tool design.

(3) This rating is not intended to reflect hazards presented by this or any other material under actual fire conditions.

(4) Internal measurements according to UL standards.

(5) Measurements made from laboratory test coupon. Actual shrinkage may vary outside of range due to differences in processing conditions, equipment, part geometry and tool design. It is recommended that mold shrinkage studies be performed with surrogate or legacy tooling prior to cutting tools for new molded article.

(6) Needs hard coat to consistently pass 60 sec Vertical Burn.

Source GMD, last updated:

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TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	101	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	87	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	88	°C	ASTM D 648
CTE, -40°C to 40°C, flow	7.02E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	7.56E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, flow	7.E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	7.5E-05	1/°C	ISO 11359-2
Vicat Softening Temp, Rate B/50	120	°C	ISO 306
Vicat Softening Temp, Rate B/120	124	°C	ISO 306
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	89	°C	ISO 75/Af
PHYSICAL			
Specific Gravity	1.23	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm (5)	0.7 - 0.9	%	SABIC Method
Melt Flow Rate, 266°C/5.0 kgf	26	g/10 min	ASTM D 1238
Density	1.23	g/cm ³	ISO 1183
Water Absorption, (23°C/sat)	0.5	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.15	%	ISO 62
Melt Volume Rate, MVR at 265°C/5.0 kg	25	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

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