

**XILOY 04 85 F**

(PC+ABS)

MAIP SRL

<b>Processing/Physical Characteristics</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
Melt flow index, MFI	<b>25</b>	g/10min	ISO 1133
Temperature	<b>260</b>	°C	-
Load	<b>5</b>	kg	-
Molding shrinkage, parallel	<b>0.7</b>	%	ISO 294-4, 2577
Molding shrinkage, normal	<b>0.7</b>	%	ISO 294-4, 2577

<b>Mechanical properties</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
Yield stress	<b>50</b>	MPa	ISO 527
Strain at break	<b>45</b>	%	ISO 527
Flexural modulus, 23°C	<b>2300</b>	MPa	ISO 178
Flexural strength	<b>80</b>	MPa	ISO 178
Izod notched impact strength, +23°C	<b>45</b>	kJ/m <sup>2</sup>	ISO 180/1A

<b>Thermal properties</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
Burning behav. at thickness h	<b>HB</b>	class	IEC 60695-11-10
Burning rate, FMVSS, Thickness 1 mm	<b>100</b>	mm/min	ISO 3795 (FMVSS 302)

<b>Other properties</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
Density	<b>1140</b>	kg/m <sup>3</sup>	ISO 1183

<b>Processing Recommendation Injection Molding</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
Pre-drying - Temperature	<b>80</b>	°C	-
Pre-drying - Time	<b>2 - 4</b>	h	-
Processing humidity	<b>≤0.05</b>	%	-
Melt temperature	<b>250 - 270</b>	°C	-
Mold temperature	<b>70 - 80</b>	°C	-

**Characteristics****Processing**

Injection Molding

**Regional Availability**

Europe