

LEXAN™ COPOLYMER EXL1413T

REGION EUROPE

DESCRIPTION

LEXAN EXL1413T polycarbonate (PC) siloxane copolymer resin is a transparent injection molding grade. This resin offers excellent low temperature (-30 °C) ductility in combination with medium flow characteristics and excellent processability with opportunities for shorter IM cycle times compared to standard PC. LEXAN EXL1413T resin is a general purpose product available in transparent and opaque colors and is an excellent candidate for a broad range of applications.

TYPICAL PROPERTY VALUES

Revision 20170816

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	58	MPa	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	64	MPa	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	5.8	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	131.4	%	ASTM D 638
Tensile Modulus, 50 mm/min	2210	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	94	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	2210	MPa	ASTM D 790
Tensile Stress, yield, 50 mm/min	57	MPa	ISO 527
Tensile Stress, break, 50 mm/min	61	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	5.5	%	ISO 527
Tensile Strain, break, 50 mm/min	124.9	%	ISO 527
Tensile Modulus, 1 mm/min	2350	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	90	MPa	ISO 178
Flexural Modulus, 2 mm/min	2150	MPa	ISO 178
Hardness, Rockwell L	89	-	ISO 2039-2
IMPACT			
Izod Impact, notched, 23°C	890	J/m	ASTM D 256
Izod Impact, notched, -30°C	795	J/m	ASTM D 256
Instrumented Impact Total Energy, 23°C	82	J	ASTM D 3763
Instrumented Impact Total Energy, -30°C	85	J	ASTM D 3763
Izod Impact, unnotched 80*10*3 +23°C	NB	kJ/m ²	ISO 180/1U
Izod Impact, unnotched 80*10*3 -30°C	NB	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*3 +23°C	65	kJ/m ²	ISO 180/1A

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Izod Impact, notched 80*10*3 -30°C	55	kJ/m ²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*3 sp=62mm	70	kJ/m ²	ISO 179/1eA
Charpy -30°C, V-notch Edgew 80*10*3 sp=62mm	60	kJ/m ²	ISO 179/1eA
Charpy 23°C, Unnotch Edgew 80*10*3 sp=62mm	NB	kJ/m ²	ISO 179/1eU
Charpy -30°C, Unnotch Edgew 80*10*3 sp=62mm	NB	kJ/m ²	ISO 179/1eU
THERMAL			
Vicat Softening Temp, Rate A/50	141	°C	ASTM D 1525
HDT, 1.82 MPa, 3.2mm, unannealed	124	°C	ASTM D 648
CTE, -40°C to 95°C, flow	7.15E-05	1/°C	ASTM E 831
CTE, -40°C to 95°C, xflow	7.93E-05	1/°C	ASTM E 831
CTE, 23°C to 80°C, flow	7.15E-05	1/°C	ISO 11359-2
CTE, 23°C to 80°C, xflow	7.93E-05	1/°C	ISO 11359-2
Ball Pressure Test, 125°C +/- 2°C	pass	-	IEC 60695-10-2
Vicat Softening Temp, Rate B/50	141	°C	ISO 306
Vicat Softening Temp, Rate B/120	142	°C	ISO 306
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	118	°C	ISO 75/Af
Relative Temp Index, Elec	130	°C	UL 746B
Relative Temp Index, Mech w/o impact	130	°C	UL 746B
PHYSICAL			
Specific Gravity	1.19	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm (5)	0.4 – 0.8	%	SABIC method
Mold Shrinkage, xflow, 3.2 mm (5)	0.4 – 0.8	%	SABIC method
Melt Flow Rate, 300°C/1.2 kgf	10	g/10 min	ASTM D 1238
Density	1.19	g/cm ³	ISO 1183
Water Absorption, (23°C/sat)	0.12	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.09	%	ISO 62
Melt Volume Rate, MVR at 300°C/1.2 kg	9	cm ³ /10 min	ISO 1133
OPTICAL			
Light Transmission, 2.54 mm	82	%	ASTM D 1003
Haze, 2.54 mm	3	%	ASTM D 1003
ELECTRICAL			
Volume Resistivity	> 1.E+15	Ohm-cm	ASTM D 257
Surface Resistivity	> 1.E+15	Ohm	ASTM D 257
FLAME CHARACTERISTICS			
UL Recognized, 94V-2 Flame Class Rating (3)	2.5	mm	UL 94
Glow Wire Flammability Index 960°C, passes at	3	mm	IEC 60695-2-12
Glow Wire Ignitability Temperature, 0.8 mm	825	°C	IEC 60695-2-13
Glow Wire Ignitability Temperature, 3.0 mm	825	°C	IEC 60695-2-13

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
INJECTION MOLDING			
Drying Temperature	120	°C	
Drying Time	3 – 4	hrs	
Drying Time (Cumulative)	48	hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	295 – 315	°C	
Nozzle Temperature	290 – 310	°C	
Front - Zone 3 Temperature	295 – 315	°C	
Middle - Zone 2 Temperature	280 – 305	°C	
Rear - Zone 1 Temperature	215 – 295	°C	
Mold Temperature	70 – 95	°C	
Back Pressure	0.3 – 0.7	MPa	
Screw Speed	40 – 70	rpm	
Shot to Cylinder Size	40 – 60	%	
Vent Depth	0.025 – 0.076	mm	

DISCLAIMER

The information contained herein may include typical properties of our products or their typical performances when used in certain typical applications. Actual properties of our products, in particular when used in conjunction with any third party material(s) or for any non-typical applications, may differ from typical properties.

It is the customer's responsibility to inspect and test our product(s) in order to satisfy itself as to the suitability of the product(s) for its and its customers particular purposes. The customer is responsible for the appropriate, safe and legal use, processing and handling of all product(s) purchased from us.

Nothing herein is intended to be nor shall it constitute a warranty whatsoever, in particular, warranty of merchantability or fitness for a particular purpose.

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