

LEXAN™ COPOLYMER EXL1112

REGION AMERICAS

DESCRIPTION

LEXAN EXL1112 polycarbonate (PC) siloxane copolymer resin is a high flow opaque injection molding (IM) grade. This resin offers good low temperature (-20 C) ductility in combination with excellent processability and release with opportunities for shorter IM cycle times compared to standard PC. LEXAN EXL1112 resin is a product available in wide range of opaque colors and may be an excellent candidate for a wide variety of applications.

TYPICAL PROPERTY VALUES

Revision 20230607

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL ⁽¹⁾			
Tensile Stress, yld, Type I, 50 mm/min	58	MPa	ASTM D638
Tensile Stress, brk, Type I, 50 mm/min	58	MPa	ASTM D638
Tensile Strain, yld, Type I, 50 mm/min	5.8	%	ASTM D638
Tensile Strain, brk, Type I, 50 mm/min	109	%	ASTM D638
Tensile Modulus, 50 mm/min	2280	MPa	ASTM D638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	95	MPa	ASTM D790
Flexural Modulus, 1.3 mm/min, 50 mm span	2320	MPa	ASTM D790
Tensile Stress, yield, 50 mm/min	57	MPa	ISO 527
Tensile Stress, break, 50 mm/min	55	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	5	%	ISO 527
Tensile Strain, break, 50 mm/min	100	%	ISO 527
Tensile Modulus, 1 mm/min	2150	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	85	MPa	ISO 178
Flexural Modulus, 2 mm/min	2240	MPa	ISO 178
Ball Indentation Hardness, H358/30	95	MPa	ISO 2039-1
IMPACT ⁽¹⁾			
Izod Impact, notched, 23°C	747	J/m	ASTM D256
Izod Impact, notched, -30°C	667	J/m	ASTM D256
Instrumented Dart Impact Total Energy, 23°C	69	J	ASTM D3763
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	55	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*3 -30°C	20	kJ/m ²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*3 sp=62mm	60	kJ/m ²	ISO 179/1eA
Charpy -30°C, V-notch Edgew 80*10*3 sp=62mm	25	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 ⁽¹⁾			
Vicat Softening Temp, Rate B/50	144	°C	ASTM D1525
HDT, 0.45 MPa, 3.2 mm, unannealed	136	°C	ASTM D648
HDT, 1.82 MPa, 3.2mm, unannealed	123	°C	ASTM D648
CTE, -40°C to 40°C, flow	7.2E-05	1/°C	ASTM E831
CTE, -40°C to 40°C, xflow	7.56E-05	1/°C	ASTM E831
CTE, 23°C to 80°C, flow	7.5E-05	1/°C	ISO 11359-2

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CTE, 23°C to 80°C, xflow	7.5E-05	1/°C	ISO 11359-2
Ball Pressure Test, 125°C +/- 2°C	PASSES	-	IEC 60695-10-2
Vicat Softening Temp, Rate B/50	144	°C	ISO 306
Vicat Softening Temp, Rate B/120	145	°C	ISO 306
HDT/Ae, 1.8 MPa Edgew. 120*10*4 sp=100mm	125	°C	ISO 75/Ae
HDT/Be, 0.45 MPa edgew. Annealed 80°C, 4 hrs	136	°C	ISO 75/Be
Relative Temp Index, Elec ⁽²⁾	130	°C	UL 746B
Relative Temp Index, Mech w/impact ⁽²⁾	120	°C	UL 746B
Relative Temp Index, Mech w/o impact ⁽²⁾	130	°C	UL 746B
PHYSICAL ⁽¹⁾			
Specific Gravity	1.18	-	ASTM D792
Mold Shrinkage, flow, 3.2 mm ⁽³⁾	0.4 – 0.8	%	SABIC method
Mold Shrinkage, xflow, 3.2 mm ⁽³⁾	0.4 – 0.8	%	SABIC method
Melt Flow Rate, 300°C/1.2 kgf	17	g/10 min	ASTM D1238
Density	1.19	g/cm ³	ISO 1183
Water Absorption, (23°C/saturated)	0.35	%	ISO 62-1
Moisture Absorption (23°C / 50% RH)	0.15	%	ISO 62
Melt Volume Rate, MVR at 300°C/1.2 kg	16	cm ³ /10 min	ISO 1133
FLAME CHARACTERISTICS ⁽²⁾			
UL Yellow Card Link	E121562-100079872	-	-
UL Yellow Card Link 2	E121562-575793	-	-
UL Recognized, 94HB Flame Class Rating	≥0.5	mm	UL 94
Glow Wire Ignitability Temperature, 3.0 mm	875	°C	IEC 60695-2-13
Glow Wire Ignitability Temperature, 1.5 mm	875	°C	IEC 60695-2-13
Glow Wire Ignitability Temperature, 1.0 mm	875	°C	IEC 60695-2-13
Glow Wire Ignitability Temperature, 0.8 mm	875	°C	IEC 60695-2-13
Glow Wire Flammability Index, 3.0 mm	960	°C	IEC 60695-2-12
Glow Wire Flammability Index, 1.5 mm	960	°C	IEC 60695-2-12
Glow Wire Flammability Index, 1.0 mm	960	°C	IEC 60695-2-12
Glow Wire Flammability Index, 0.8 mm	850	°C	IEC 60695-2-12
UV-light, water exposure/immersion	F1	-	UL 746C
Oxygen Index (LOI)	32	%	ISO 4589
INJECTION MOLDING ⁽⁴⁾			
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	270 – 295	°C	
Mold Temperature	70 – 95	°C	
Back Pressure	0.3 – 0.7	MPa	
Screw Speed	40 – 70	rpm	

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Shot to Cylinder Size	40 – 60	%	
Vent Depth	0.025 – 0.076	mm	

- (1) The information stated on Technical Datasheets should be used as indicative only for material selection purposes and not be utilized as specification or used for part or tool design.
- (2) UL Ratings shown on the technical datasheet might not cover the full range of thicknesses and colors. For details, please see the UL Yellow Card.
- (3) 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. The information stated on Technical Datasheets should be used as indicative only for material selection purposes and not be utilized as specification or used for part or tool design.
- (4) Injection Molding parameters are only mentioned as general guidelines. These may not apply or may need adjustment in specific situations such as low shot sizes, large part molding, thin wall molding and gas-assist molding.

MORE INFORMATION

For curve data and CAE cards, please visit and register at <https://materialfinder.sabic-specialties.com>

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