

LEXANTM COPOLYMER EXL9132

REGION ASIA

DESCRIPTION

Opaque PC-Siloxane copolymer with excellent processability. Improved flow, low temperature ductility, UV stabilized. Non-chlorinated, non-brominated flame retardant product. UL rated VO/5VA.

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	103	%	ASTM D638
Tensile Modulus, 50 mm/min	2260	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	2330	MPa	ASTM D790
Tensile Stress, yield, 50 mm/min	59	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	2200	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	88	MPa	ISO 178
Flexural Modulus, 2 mm/min	2300	MPa	ISO 178
Ball Indentation Hardness, H358/30	95	MPa	ISO 2039-1
IMPACT (1)			
Izod Impact, notched, 23°C	731	J/m	ASTM D256
Izod Impact, notched, -30°C	560	J/m	ASTM D256
Instrumented Dart Impact Total Energy, 23°C	67	J	ASTM D3763
Izod Impact, unnotched 80*10*3 +23°C	NB	kJ/m²	ISO 180/1U
Izod Impact, unnotched 80*10*3 -30°C	NB	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*3 +23°C	55	kJ/m²	ISO 180/1A
Izod Impact, notched 80*10*3 -30°C	20	kJ/m²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*3 sp=62mm	60	kJ/m²	ISO 179/1eA
Charpy -30°C, V-notch Edgew 80*10*3 sp=62mm	25	kJ/m²	ISO 179/1eA
Charpy 23°C, Unnotch Edgew 80*10*3 sp=62mm	NB	kJ/m²	ISO 179/1eU
Charpy -30°C, Unnotch Edgew 80*10*3 sp=62mm	NB	kJ/m²	ISO 179/1eU
THERMAL (1)			
Vicat Softening Temp, Rate B/50	143	°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	7.2E-05	1/°C	ASTM E831
CTE, 23°C to 80°C, flow	7.5E-05	1/°C	ISO 11359-2



CT. 23°C to 80°C, xilow 75-61-00 17°C 801 1989 (2) Ball ressure Test. 125°C-12°C MSMS - 60 00 50 Vicat Softening Temp, Rate 8/120 144 *C 00 30 Vicat Softening Temp, Rate 8/120 144 *C 00 57/5e HOTT/Re, 1-8 Mira Edgew 120°10°4 sp-100mm 136 *C 00 75/5e Relative Temp Index, Mech wijnpact ⁽²⁾ 130 *C 00 75/6e Relative Temp Index, Mech wijnpact ⁽²⁾ 130 *C 00 75/6e Relative Temp Index, Mech wijnpact ⁽²⁾ 130 *C 00 75/6e Relative Temp Index, Mech wijnpact ⁽²⁾ 130 *C 00 75/6e Relative Temp Index, Mech wijnpact ⁽²⁾ 180 *C 00 75/6e Molity Mirakage and Mirakage (100, 32 mm²) 180 *C 00 75/6e Molity Mirakage (100, 32 mm²) 19 90 mm² No 1013 Molity Anixage (100, 32 mm²) 19 19 10 mm² 10 mm² Molity Anixage (100, 32 mm²) 19 10 mm² 10 mm² 10 mm² Relative Premitativity, Mik	PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Vicat Softening Temp, Rate 8/30 143 C SO 306 Vicat Softening Temp, Rate 8/120 143 C 500 (1) HDT/Be, O.438M a Edgew 120*10*4 sp=100mm 124 C 50.75/Ac HDT/Jee, 1.8.MPa Edgew 120*10*4 sp=100mm 124 C 0 10.748 Relative Temp Index, Beef ^O 30 C 0 17.488 Relative Temp Index, Mech w/l impact (**) 30 C 0 17.488 Relative Temp Index, Mech w/l impact (**) 30 C 0 17.488 Relative Temp Index, Mech w/l impact (**) 30 C 0 17.488 Relative Temp Index, Mech w/l impact (**) 30 C 0 17.488 Relative Temp Index, Mech w/l impact (**) 40 0 <td< td=""><td>CTE, 23°C to 80°C, xflow</td><td>7.5E-05</td><td>1/°C</td><td>ISO 11359-2</td></td<>	CTE, 23°C to 80°C, xflow	7.5E-05	1/°C	ISO 11359-2
Vict Softening Temp, Rate B/120 144 C SO 366 HDY Jee, 0.45MPa Edgewt 120*10*4 p=100mm 136 C 150 75/e Relative Temp Index, Beet Pilo 130 C U746 Relative Temp Index, Mech Wilmpact Pilo 120 C U746 Relative Temp Index, Mech Wilmpact Pilo 120 C U746 Relative Temp Index, Mech Wilmpact Pilo 120 C U746 Relative Temp Index, Mech Wilmpact Pilo 120 C U746 Relative Temp Index, Mech Wilmpact Pilo 120 C U746 Relative Temp Index, Mech Wilmpact Pilo 120 W M Mol Shrinkage, flow 3.2 mm (Pilo 4.0 2 W M Mold Shrinkage, flow 3.2 mm (Pilo 1.0 4.0 M </td <td>Ball Pressure Test, 125°C +/- 2°C</td> <td>PASSES</td> <td>-</td> <td>IEC 60695-10-2</td>	Ball Pressure Test, 125°C +/- 2°C	PASSES	-	IEC 60695-10-2
HDT/Be, 0.45 MrB Edgew 120104 sp=100mm 124	Vicat Softening Temp, Rate B/50	143	°C	ISO 306
HOT/A, 1.8 MPa Edgev 120*10*4.sp = 100mm 124 °C 105 76/Ac Relative Temp Index, Elect ⁽¹⁾ 130 °C U.7 468 Relative Temp Index, Mech Wijmpact ⁽²⁾ 130 °C U.7 468 Relative Temp Index, Mech Wijmpact ⁽²⁾ 130 °C U.7 468 PWISTCAL*** Specific Gravity 1 A A A51 M792 Mold Shrinkage, flow, 3.2 mm ⁽³⁾ 4 4 8 A51 M792 Mold Shrinkage, flow, 3.2 mm ⁽³⁾ 4 4 9 M61 Clear M102 Melt Volume Rate, MS at 300°C/1.2 kgf 15 5 10 10 Melt Volume Rate, MS at 300°C/1.2 kg 15 6 </td <td>Vicat Softening Temp, Rate B/120</td> <td>144</td> <td>°C</td> <td>ISO 306</td>	Vicat Softening Temp, Rate B/120	144	°C	ISO 306
Relative Temp Index, Metch Vilmpact (°) 130 "Calon Wilmpact (°) 12 / 48 / 48 / 48 / 48 / 48 / 48 / 48 / 4	HDT/Be, 0.45MPa Edgew 120*10*4 sp=100mm	136	°C	ISO 75/Be
Relative Temp Index, Mich Wijmpact (1) 120 "Cell (1) Un/48 PRIVISCAL (1) 130 "Cell (2) U.746 PRIVISCAL (1) "Security (2004) 1.81 2.00 ASM (10) Mold Shrinkage, flow, 3.2 mm (1) 4.4-0.8 \$ ASM (10) Mold Shrinkage, flow, 3.2 mm (1) 1.4-0.8 \$ ASM (10) Melt Flow Rate, 300°C/12 kg 1.9 (10) \$ Mill (10) Melt Flow Rate, 300°C/12 kg 1.9 (10) \$ \$ 10 Melt Flow Rate, 300°C/12 kg 1.6 20 \$ 10 2 10 2 10 2 10 2 10 2 10 2 10 2 10 2 10 2 10 2 10 2 10 2 10 2 10 2 10 2 10 10 10 10 10 10 10 10 10 10 10 10 10 10 10 10	HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm	124	°C	ISO 75/Ae
Relative Tempindex, Merchangen (**) 1975 (17) PHYSICAL (**) ************************************	Relative Temp Index, Elec (2)	130	°C	UL 746B
Physical (Figure 1) Specific Gravity 1.80 4.00 AIM D792 Mold Shrinkage, flow, 3.2 mm (P) 0.4–0.8 8.00 AIM CREATION Mold Shrinkage, flow, 3.2 mm (P) 1.7 9/10 min AIM D123 Melt Flow Rate, 300°C/1.2 kg1 1.9 9/10 min AIM D123 Bestly 1.9 9/10 min 50 62-1 Water Absorption (23°C/ saturated) 1.5 8 50 62-1 Moltsture Absorption (23°C/ saturated) 1.5 8 50 62-1 Melt Volume Rate, MVR at 300°C/1.2 kg 1.5 8 10 62-1 Melt Volume Rate, MVR at 300°C/1.2 kg 1.0 1.0 10 3 Better Pemittivin (1,2 mm 1.2 1.0 1.0 1.0 Better Pemittivin (1,2 mm 1.0	Relative Temp Index, Mech w/impact (2)	120	°C	UL 746B
Specific Gravity 1.88 -1.08 ASIA D799 Mold Shrinkage, flow, 3.2 mm (1) 04-0.8 3.68 Centrol Mold Shrinkage, flow, 3.2 mm (1) 4-0.8 3.10 mill ASIA D128 Melt Flow Rate, 300°C/12 kg1 1-7 (1) mill 3.11 mill 2.81 mill 2.81 mill Melt Flow Rate, 900°C/12 kg1 1-9 (1) mill 3.11 mill 2.81 mill 2.8	Relative Temp Index, Mech w/o impact (2)	130	°C	UL 746B
Specific Gravity 1.88 -1.08 ASIA D799 Mold Shrinkage, flow, 3.2 mm (1) 04-0.8 3.68 Centrol Mold Shrinkage, flow, 3.2 mm (1) 4-0.8 3.10 mill ASIA D128 Melt Flow Rate, 300°C/12 kg1 1-7 (1) mill 3.11 mill 2.81 mill 2.81 mill Melt Flow Rate, 900°C/12 kg1 1-9 (1) mill 3.11 mill 2.81 mill 2.8	PHYSICAL (1)			
Mold Shrinkage, flow, 3.2 mm ⁽¹⁾ 0.4 - 0.8 \$810 method Mold Shrinkage, xflow, 3.2 mm ⁽¹⁾ 0.4 - 0.8 \$10 min ASM D1283 Melt Flow Rate, 300°C/1.2 kgf 179 g/m² ASM D1283 Water Absorption, (23°C/saturated) 0.35 6.0 100 min 100 min 100 min 100 min Melt Volume Rate, MVR at 300°C/1.2 kg 1.5 4.0 100 min 100 min <t< td=""><td></td><td>1.18</td><td>-</td><td>ASTM D792</td></t<>		1.18	-	ASTM D792
Mold Shrinkage, xilow, 3.2 mm² 9.4 – 9.8 9.1 mm² AST DE138 Melt Flow Rate, 300°C/1.2 kgf 179 9.1 mm² AST DE138 Density 0.35 3.2 mm² 50 62-1 Mole Tubroption (23°C) for Reth) 0.15 2 m² 50 62-1 Molt Volume Rate, MVR at 300°C/1.2 kg 16 2 m² 10 m² 50 133 ELECTICAL 1° V V/m 15 60 231 ELECTICAL 1° 3 m² 16 60 250 18 m² 18 60 243 Relative Permithivity, 1 MHz 2 m² 10 60 250 18 60 250		0.4 – 0.8	%	
Melt Flow Rate, 30°C/1.2 kgf 17 1910 <t< td=""><td></td><td></td><td></td><td></td></t<>				
Density 1.99 g/m² 10183 Water Absorption (23°C/saturated) 0.35 % 50 62-1 Michtre Absorption (23°C/ 50% RH) 0.15 % 50 62-1 Melt Volume Rate, MVR at 30°C/ 1.2 kg 16 m²/10 min 10 62-2 ELECTRICAL.** W/m IEC 60243-1 1 Pollectric Strength, in oil, 3.2 mm 9 M/m IEC 60243-1 Relative Permittivity, 1 Mt² 2.7 4 10 60250 Dissipation Factor, 50/60 Hz 0.004 - IEC 60250 Comparative Tracking Index 1.75 V IEC 60250 Comparative Tracking Index (Ut) {PC) 3 PC Code U.746A Bridgitive Permittivity, 50/60 Hz 2.7 W IC Code U.746A Comparative Tracking Index (Ut) {PC) 3 PC Code U.746A Bridgitive Permittivity, 50/60 Hz 2 2 PC Code U.746A Use (Ut) {PC) 3 2 Code U.746A Use (Ut) {PC) 2 2 Code U.746A				
Water Absorption, (23°C/saturated) 0.35 % 50-62-1 Moisture Absorption (23°C / 50% RH) 0.15 % 50-62 Melt Volume Rate, MVR at 300°C / 1.2 kg 16 cm / 10 min 50-13 ELECTRICAL (19) Use Electric Strength, in oil, 3.2 mm 19 W// Mm EC 60243-1 Relative Permittivity, 1 MHz 2.7 W// Mm EC 60250 Dissipation Factor, 50/60 Hz 0.004 - 10-60250 Subjection Factor, 1 MHz 7.5 V EC 60250 Comparative Tracking Index 175 V EC 60250 Relative Permittivity, 50/60 Hz 3 PLC Code IL 7660 Comparative Tracking Index (UL) (PLC) 3 9 PLC Code IL 7660 Hot-Wire Ignition (HWI), PLC 3 5 PLC Code IL 746A PLC Code IL 746A Use Vellow Card Link E027780-100079878 - - - - Use Recognized, 94-50 Flame Class Rating 21.5 mm IL 99-9 - - Glow Wire Ignita				
Moisture Absorption (23°C / 50% RH) 0.15 % 10 50 c 20 Melt Volume Rate, MVR at 300°C / 1.2 kg 16 moint on moint of the control of t	•			
Melt Volume Rate, MVR at 300°C/1.2 kg 16 m²/l 0 m² lo IS133 ELECTRICAL (¹) W/m ISC 60243-1 Pole lectric Strength, in oil, 3.2 mm 99 W/m ISC 60250 Relative Permittivity, 1 MHz 2.7 - IEC 60250 Dissipation Factor, 50/60 Hz 0.0004 - IEC 60250 Dissipation Factor, 1 MHz 0.75 V IEC 60212 Relative Permittivity, 50/60 Hz 2.7 - IEC 60250 Relative Permittivity, 50/60 Hz 3 IEC 60250 IEC 60250 Comparative Tracking Index (UI) (PLC) 3 PLC Code U.746A Bot Wire Ignition (HWI), PLC 3 5 PLC Code U.746A Hot Wellow Card Link 5 207780-100079878 - - - U. Yellow Card Link 2 5 207780-465637 mm U.94 - U. Recognized, 94-95 Flame Class Rating 2.5 mm U.94 - U. Recognized, 94-97 Flame Class Rating 2.5 - - IEC 60695-2-13 Glow Wire Ignitabil	. , , ,			
BLECTRICAL ¹¹ Dielectric Strength, in oil, 3.2 mm 19 kV/mm IC 60243-1 Relative Permittivity, 1 MHz 2.7 - EC 60250 Dissipation Factor, 50/60 Hz 0.004 - IC 60250 Dissipation Factor, 1 MHz 0.01 - IC 60250 Comparative Tracking Index 175 V IC 60112 Relative Permittivity, 50/60 Hz 2.7 IC 2006 U.7 46A Comparative Tracking Index (UL) (PLC) 3 IC 2006 U.7 46A Brown Fill (HWI), PLC 3 1.5 mm U.7 46A Brown Card Link 2 20.7780-100079878 - - - U. Yellow Card Link 2 20.7780-456327 mm U.9 4 - U. Yellow Card Link 2 20.7780-456327 mm U.9 4 - U. Recognized, 94-5VA Flame Class Rating 2.5 mm U.9 4 - Glow Wire Ignitability Temperature, 3.0 mm 82 C IC 60695-2-13 - Glow Wire Flammability Index, 1.5 mm 60 C IC 60695-2-12<	. , , ,			
Dielectric Strength, in oil, 3.2 mm19W/mmIC 6043-1Relative Permittivity, 1 MHz2.7100410061006Dissipation Factor, 50/60 Hz0.0042.010 60250Dissipation Factor, 1 MHz1.75V10 60250Comparative Tracking Index1.75V10 60250Relative Permittivity, 50/60 Hz2.710 6025010 60250Comparative Tracking Index (UL) (PLC)310 6025010 746ABrowner Liver Individual (MW), PLC31.510 740610 7406Browner Liver Individual (MW), PLC32.010 740610 7406BLY Melow Card Link207880-1000798782.010 7406UL Yellow Card Link 2207780-1000798782.010 94UL Recognized, 94.94 Plame Class Rating2.010 94UL Recognized, 94.94 Plame Class Rating2.110 94Glow Wire Ignitability Temperature, 1.5 mm2510 9410 94Glow Wire Ignitability Temperature, 1.5 mm2510 9410 94Glow Wire Ignimability Index, 3.0 mm9610 9410 94Glow Wire Ignimability Index, 1.5 mm9610 9410 94Urlight, water exposure/immersion10 9410 9410 94Disconsidered (LOI)10 9410 9410 94Instruction MolDink (MI)10 94 <td>, -</td> <td></td> <td>GIII / TO IIIIII</td> <td>150 1 155</td>	, -		GIII / TO IIIIII	150 1 155
Relative Permittivity, 1 MHz2.71.61		10	14//	IFC C0242 1
Dissipation Factor, 50/60 Hz 0.0004 - 0.0004 EC 60250 Dissipation Factor, 1 MHz 0.01 - 0.000 EC 60250 Comparative Tracking Index 175 V IEC 60112 Relative Permittivity, 50/60 Hz 2.7 - 0.000 IEC 60250 Comparative Tracking Index (UL) {PLC} 3 PLC Code U.746A Hot-Wire Ignition (HWI), PLC 3 1.5 mm U.746A FLAME CHARACTERISTICS (*) U. Yellow Card Link 207780-100079878 - 0 - 0 U. Yellow Card Link 2 207780-465637 mm U.94 U. Recognized, 94-5VA Flame Class Rating 23 mm U.94 U. Recognized, 94-VO Flame Class Rating 21.5 mm U.94 Glow Wire Ignitability Temperature, 3.0 mm 825 C IEC 60695-213 Glow Wire Flammability Index, 3.0 mm 90 C IEC 60695-212 Glow Wire Flammability Index, 1.5 mm 96 C IEC 60695-212 U.Vilight, water exposure/immersion 1 4 1 1 Oyley Index (IOI)			KV/mm	
Dissipation Factor, 1 MHz 0.01 c.00 EC 60250 Comparative Tracking Index 175 V EC 60112 Relative Permittivity, 50/60 Hz 2.7 PLC Code U.746A Comparative Tracking Index (UL) {PLC} 3 mm U.746A Hot-Wire Ignition (HWI), PLC 3 1.5 mm U.746A EMBECHARACTERISTICS (2) V V V U.Yellow Card Link £027780-100079878 - - - U.Yellow Card Link 2 £207780-465637 mm U.94 - U. Recognized, 94-5VA Flame Class Rating 2 2 -			-	
Comparative Tracking Index75VEC 6012Relative Permittivity, 50/60 Hz2.7Comparative Tracking Index (UL) (PLC)3EC CodeU. 746AComparative Tracking Index (UL) (PLC)1.5mmU. 746ABit William (HWI), PLC 31.5mmU. 746ABIAME CHARACTERISTIG.**U. Vellow Card LinkE207780-100079878U. Vellow Card Link 2£207780-100079878U. Recognized, 94-94 Plame Class Rating2U. Beach Stating82Glow Wire Iglantability Temperature, 1.5 mm96Glow Wire Flammability Index, 1.5 mm96Urbilly, water exposure/ Immersion96 <th< td=""><td></td><td></td><td>-</td><td></td></th<>			-	
Relative Permittivity, 50/60 Hz Comparative Tracking Index (UL) {PLC} 3 3 PLC Code UL 746A Hot-Wrie Ignition (HWI), PLC 3 IS FLAME CHARACTERISTICS ** UL Yellow Card Link E207780-100079878 IS UL Yellow Card Link E207780-100079878 IS UL Recognized, 94-5VA Flame Class Rating IS UL Recognized, 94-9-V Flame Class Rating IS UL Recognized, 94-Y-0 Flame Class Rating IS UL Sellow Wire Ignitability Temperature, 3.0 mm IS UL Sellow Wire Ignitability Temperature, 1.5 mm IS UL Willight, water exposure/immersion IS UL Yellow Card Link IS UL Recognized (10) IS UL Sellow Wire Ignitability Index, 1.5 mm IS UL Sellow Wire Ignitability Index, 1.5 mm IS UL Sellow Wire Ignitability Index, 1.5 mm IS UL Sellow Wire Ignimability Index, 1.5 mm IS UL Sellow	•		-	
Comparative Tracking Index (UL) (PLC) 3 3 9 PLC Ode UL 746A Hot-Wire Ignition (HWI), PLC 3 15 mm m	<u> </u>			
Hot-Wire Ignition (HWI), PLC 31.5mmU. 746AFLAME CHARACTERISTICS (2)UL Yellow Card LinkE207780-100079878UL Yellow Card Link 2E207780-465637UL Recognized, 94-5VA Flame Class Rating23mmU. 94UL Recognized, 94-0 Flame Class Rating21.5mmU. 94Glow Wire Ignitability Temperature, 3.0 mm825CIEC 60695-2·13Glow Wire Ignitability Temperature, 1.5 mm825CIEC 60695-2·13Glow Wire Flammability Index, 3.0 mm960CIEC 60695-2·12Glow Wire Flammability Index, 1.5 mm960CIEC 60695-2·12UV-light, water exposure/immersionF1IU. 746COxygen Index (LOI)40\$>>>INJECTION MOLDING (4)T-IU. 746CTyring Temperature120C-IU. 746CTyring Temperature3-4Hrs				
FLAME CHARACTERISTICS (2) UL Yellow Card Link 2				
UL Yellow Card LinkE207780-100079878UL Yellow Card Link 2E207780-465637UL Recognized, 94-5VA Flame Class Rating≥3mmUL 94UL Recognized, 94V-0 Flame Class Rating≥1.5mmUL 94Glow Wire Ignitability Temperature, 3.0 mm825°CIEC 60695-2-13Glow Wire Ignitability Index, 3.0 mm825°CIEC 60695-2-13Glow Wire Flammability Index, 3.0 mm960°CIEC 60695-2-12Glow Wire Flammability Index, 1.5 mm960°CIEC 60695-2-12UV-light, water exposure/immersionF1U. 746COxygen Index (LOI)40%150 4589INECTION MOLDING (4)**Drying Temperature1203-4HrsTyring Time3-4Hrs		1.5	IIIIII	UL 746A
UL Yellow Card Link 2 UL Recognized, 94-5VA Flame Class Rating 23 31 31 31 31 31 31 31 31 31				
UL Recognized, 94-5VA Flame Class Rating □ 1.5	UL Yellow Card Link	E207780-100079878	-	•
UL Recognized, 94V-0 Flame Class Rating ≥1.5 mm mm UL 94 Glow Wire Ignitability Temperature, 3.0 mm 825 °C IEC 60695-2-13 Glow Wire Ignitability Index, 1.5 mm 825 °C IEC 60695-2-13 Glow Wire Flammability Index, 1.5 mm 960 °C IEC 60695-2-12 UV-light, water exposure/immersion F1 °C IEC 60695-2-12 UV-light, water exposure/immersion F1 °C IEC 60695-2-12 INJECTION MOLDING (4) Drying Temperature 120 °C IEC 60695-2-12 Brying Time 120 °C IEC 60695-2-12 Brying Time 130 °C IEC 60695-2-12 Brying Time 140 °C IEC 60695-2-12 Brying Time 150 °C IEC 60695-2-13 Brying Time 150 °C	UL Yellow Card Link 2	<u>E207780-465637</u>	-	-
Glow Wire Ignitability Temperature, 3.0 mm 825 °C IEC 60695-2-13 Glow Wire Ignitability Temperature, 1.5 mm 825 °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 UV-light, water exposure/immersion F1 - UL 746C Oxygen Index (LOI) 40 % ISO 4589 INJECTION MOLDING ⁽⁴⁾ Drying Temperature 120 °C L Drying Time 3 - 4 Hrs L	UL Recognized, 94-5VA Flame Class Rating	≥3	mm	UL 94
Glow Wire Ignitability Temperature, 1.5 mm 825 °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 UV-light, water exposure/immersion F1 - UL 746C Oxygen Index (LOI) 40 % ISO 4589 INJECTION MOLDING ⁽⁴⁾ Drying Temperature 120 °C L Drying Time 3 - 4 Hrs L	UL Recognized, 94V-0 Flame Class Rating	≥1.5	mm	UL 94
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 UV-light, water exposure/immersion F1 - UL 746C Oxygen Index (LOI) 40 % ISO 4589 INJECTION MOLDING ⁽⁴⁾ ** ** ** Drying Temperature 120 °C ** ** Drying Time 3 - 4 Hrs ** **	Glow Wire Ignitability Temperature, 3.0 mm	825	°C	IEC 60695-2-13
Glow Wire Flammability Index, 1.5 mm 960 °C IEC 60695-2-12 UV-light, water exposure/immersion F1 - UV 746C Oxygen Index (LOI) 40 % ISO 4589 INJECTION MOLDING ⁽⁴⁾ V C L C Drying Temperature 120 C Hrs L C L L C D C C C C C C D C<	Glow Wire Ignitability Temperature, 1.5 mm	825	°C	IEC 60695-2-13
UV-light, water exposure/immersion F1 - UL 746C Oxygen Index (LOI) 40 % ISO 4589 INJECTION MOLDING ⁽⁴⁾ Drying Temperature 120 °C C Drying Time 3 - 4 Hrs L<	Glow Wire Flammability Index, 3.0 mm	960	°C	IEC 60695-2-12
Oxygen Index (LOI) 40 % ISO 4589 INJECTION MOLDING ⁽⁴⁾ Drying Temperature 120 °C Drying Time 13 - 4 Hrs	Glow Wire Flammability Index, 1.5 mm	960	°C	IEC 60695-2-12
INJECTION MOLDING ⁽⁴⁾ Drying Temperature 120 °C Drying Time 3-4 Hrs	UV-light, water exposure/immersion	F1	-	UL 746C
Drying Temperature 120 °C Drying Time 3 - 4 Hrs	Oxygen Index (LOI)	40	%	ISO 4589
Drying Time 3 – 4 Hrs	INJECTION MOLDING (4)			
, ,	Drying Temperature	120	°C	
Drving Time (Cumulative) 48 Hrs	Drying Time	3 – 4	Hrs	
7 3 - 1-1-1-1-1	Drying Time (Cumulative)	48	Hrs	
Maximum Moisture Content 0.02 %	Maximum Moisture Content	0.02	%	
Melt Temperature 295 – 315 °C	Melt Temperature	295 – 315	°C	
Nozzle Temperature 290 – 310 °C	Nozzle Temperature	290 – 310	°C	



PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
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	
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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