LNP™ ELCRIN™ EXL7414B

DESCRIPTION

ELCRIN EXL7414B polycarbonate (PC) siloxane copolymer resin is a medium flow, non-chlorinated, non-brominated flame retardant opaque grade with major component synthesized from Bio source. This resin offers excellent low temperature ductility (-40ºC), extremely thin wall flame retardant capability with UL94 V0 at 0.6mm, and in combination with excellent processability and release with opportunities for shorter cycle times compared to standard PC. ELCRIN EXL7414B resin is a product available in wide range of opaque colors and excellent candidate for a wide variety of applications, such as the battery cover of fast-charging mobile phones that need to be compliant with IEC 62368-1.

GENERAL INFORMATION	
Features	Flame Retardant, Chemical Resistance, High Flow, Bio-Renewable, Non Cl/Br flame retardant, Impact resistant, Low temperature impact
Fillers	Unreinforced
Polymer Types	Polycarbonate (PC)
Processing Techniques	Injection Molding

INDUSTRY	SUB INDUSTRY
Electrical and Electronics	Mobile Phone - Computer - Tablets

TYPICAL PROPERTY VALUES

Revision 20260409

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL [1]			
Tensile Stress, yld, Type I, 50 mm/min	53	MPa	ASTM D638
Tensile Stress, brk, Type I, 50 mm/min	61	MPa	ASTM D638
Tensile Strain, yld, Type I, 50 mm/min	5.3	%	ASTM D638
Tensile Strain, brk, Type I, 50 mm/min	120	%	ASTM D638
Tensile Modulus, 50 mm/min	2100	MPa	ASTM D638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	88	MPa	ASTM D790
Flexural Modulus, 1.3 mm/min, 50 mm span	2100	MPa	ASTM D790
Tensile Stress, yield, 50 mm/min	54	MPa	ISO 527
Tensile Stress, break, 50 mm/min	61	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	5.2	%	ISO 527
Tensile Strain, break, 50 mm/min	120	%	ISO 527
Tensile Modulus, 1 mm/min	2100	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	84	MPa	ISO 178
Flexural Modulus, 2 mm/min	2100	MPa	ISO 178
Hardness, Rockwell L	84	-	ASTM D785
Hardness, Rockwell R	117	-	ASTM D785
IMPACT [1]			
Izod Impact, notched, 23°C	900	J/m	ASTM D256
Izod Impact, notched, 0°C	850	J/m	ASTM D256
Izod Impact, notched, -30°C	770	J/m	ASTM D256
Izod Impact, notched, -40°C	700	J/m	ASTM D256

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Instrumented Dart Impact Total Energy, 23°C	69	J	ASTM D3763
Instrumented Dart Impact Total Energy, -30°C	66	J	ASTM D3763
Izod Impact, notched 80*10*3 +23°C	73	kJ/m²	ISO 180/1A
Izod Impact, notched 80*10*3 -30°C	65	kJ/m²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*3 sp=62mm	78	kJ/m²	ISO 179/1eA
Charpy -30°C, V-notch Edgew 80*10*3 sp=62mm	69	kJ/m²	ISO 179/1eA
THERMAL [1]			
HDT, 0.45 MPa, 3.2 mm, unannealed	118	°C	ASTM D648
HDT, 1.82 MPa, 3.2mm, unannealed	105	°C	ASTM D648
CTE, -40°C to 40°C, flow	7.7E-05	1/°C	ASTM E831
CTE, -40°C to 40°C, xflow	8.7E-05	1/°C	ASTM E831
CTE, 23°C to 80°C, flow	8.8E-05	1/°C	ISO 11359-2
CTE, 23°C to 80°C, xflow	9.8E-05	1/°C	ISO 11359-2
Vicat Softening Temp, Rate B/50	123	°C	ISO 306
Vicat Softening Temp, Rate B/120	124	°C	ISO 306
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	119	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	108	°C	ISO 75/Af
Relative Temp Index, Elec [2]	80	°C	UL 746B
Relative Temp Index, Mech w/impact [2]	80	°C	UL 746B
Relative Temp Index, Mech w/o impact [2]	80	°C	UL 746B
PHYSICAL [1]			
Specific Gravity	1.2	-	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	12	g/10 min	ASTM D1238
Density	1.2	g/cm³	ISO 1183
Melt Volume Rate			
300°C/1.2 kg	11	cm³/10 min	ISO 1133
ELECTRICAL [1]			
Volume Resistivity	>1E+16	Ω.cm	ASTM D257
Surface Resistivity	>1E+16	Ω	ASTM D257
Dielectric Constant			
1.1 GHz	2.87	-	SABIC method
1.9 GHz	2.81	-	SABIC method
5 GHz	2.81	-	SABIC method
10 GHz	2.84	-	SABIC method
Dissipation Factor			
1.1 GHz	0.0064	-	SABIC method
1.9 GHz	0.006	-	SABIC method
5 GHz	0.006	-	SABIC method
10 GHz	0.0061	-	SABIC method
FLAME CHARACTERISTICS [2]			
Oxygen Index (LOI)	38	%	ISO 4589
UL Yellow Card Link	E207780-104524793	-	-

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
UL Recognized, 94V-0 Flame Class Rating	≥0.6	mm	UL 94
UL Recognized, 94-5VB Flame Class Rating	≥3	mm	UL 94
INJECTION MOLDING [4]			
Drying Temperature	110	°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	
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.

(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.

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