

# LEXAN™ COPOLYMER EXL1330

REGION EUROPE

## DESCRIPTION

LEXAN EXL1330 polycarbonate (PC) siloxane copolymer resin is a UV stabilized opaque injection molding (IM) and sheet extrusion grade. This resin offers extreme low temperature (-60 C) ductility in combination with medium flow characteristics and excellent processability with opportunities for shorter IM cycle times compared to standard PC. LEXAN EXL1330 resin is a general purpose product available in a wide range of opaque colors and is an excellent candidate for a broad range of applications.

## TYPICAL PROPERTY VALUES

Revision 20230607

| PROPERTIES                                   | TYPICAL VALUES | UNITS             | TEST METHODS |
|--|----------------|-------------------|--------------|
| <b>MECHANICAL <sup>(1)</sup></b>             |                |                   |              |
| Tensile Stress, yld, Type I, 50 mm/min       | 58             | MPa               | ASTM D638    |
| Tensile Stress, brk, Type I, 50 mm/min       | 61             | MPa               | ASTM D638    |
| Tensile Strain, yld, Type I, 50 mm/min       | 6              | %                 | ASTM D638    |
| Tensile Strain, brk, Type I, 50 mm/min       | 130            | %                 | 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     | 2060           | MPa               | ASTM D790    |
| Tensile Stress, yield, 50 mm/min             | 55             | MPa               | ISO 527      |
| Tensile Stress, break, 50 mm/min             | 56             | 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                    | 2100           | MPa               | ISO 527      |
| Flexural Stress, yield, 2 mm/min             | 85             | MPa               | ISO 178      |
| Flexural Modulus, 2 mm/min                   | 2100           | MPa               | ISO 178      |
| Ball Indentation Hardness, H358/30           | 90             | MPa               | ISO 2039-1   |
| <b>IMPACT <sup>(1)</sup></b>                 |                |                   |              |
| Izod Impact, notched, 23°C                   | 801            | J/m               | ASTM D256    |
| Izod Impact, notched, -30°C                  | 680            | J/m               | ASTM D256    |
| Izod Impact, notched, -50°C                  | 587            | J/m               | ASTM D256    |
| Izod Impact, notched, 23°C, 6.4mm            | 640            | J/m               | ASTM D256    |
| Izod Impact, double-gated, 23°C              | 1068           | J/m               | SABIC method |
| Instrumented Dart Impact Total Energy, 23°C  | 52             | J                 | ASTM D3763   |
| Izod Impact, unnotched 80*10*3 +23°C         | NB             | kJ/m <sup>2</sup> | ISO 180/1U   |
| Izod Impact, unnotched 80*10*3 -30°C         | NB             | kJ/m <sup>2</sup> | ISO 180/1U   |
| Izod Impact, notched 80*10*3 +23°C           | 70             | kJ/m <sup>2</sup> | ISO 180/1A   |
| Izod Impact, notched 80*10*3 -30°C           | 55             | kJ/m <sup>2</sup> | ISO 180/1A   |
| Charpy 23°C, V-notch Edgew 80*10*3 sp=62mm   | 75             | kJ/m <sup>2</sup> | ISO 179/1eA  |
| Charpy -30°C, V-notch Edgew 80*10*3 sp=62mm  | 60             | kJ/m <sup>2</sup> | ISO 179/1eA  |
| Charpy 23°C, Unnotch Edgew 80*10*3 sp=62mm   | NB             | kJ/m <sup>2</sup> | ISO 179/1eU  |
| Charpy -30°C, Unnotch Edgew 80*10*3 sp=62mm  | NB             | kJ/m <sup>2</sup> | ISO 179/1eU  |
| <b>THERMAL <sup>(1)</sup></b>                |                |                   |              |
| Vicat Softening Temp, Rate B/50              | 143            | °C                | ASTM D1525   |
| HDT, 0.45 MPa, 3.2 mm, unannealed            | 134            | °C                | ASTM D648    |

| PROPERTIES  | TYPICAL VALUES                   | UNITS                   | TEST METHODS   |
|---|----------------------------------|-------------------------|----------------|
| HDT, 1.82 MPa, 3.2mm, unannealed                    | 120                              | °C                      | ASTM D648      |
| HDT, 1.82 MPa, 6.4 mm, unannealed                   | 124                              | °C                      | ASTM D648      |
| CTE, -40°C to 40°C, flow                            | 6.66E-05                         | 1/°C                    | ASTM E831      |
| CTE, -40°C to 40°C, xflow                           | 6.66E-05                         | 1/°C                    | ASTM E831      |
| CTE, 23°C to 80°C, flow                             | 7.2E-05                          | 1/°C                    | ISO 11359-2    |
| CTE, 23°C to 80°C, xflow                            | 7.2E-05                          | 1/°C                    | ISO 11359-2    |
| Ball Pressure Test, 125°C +/- 2°C                   | PASSES                           | -                       | IEC 60695-10-2 |
| Vicat Softening Temp, Rate B/50                     | 143                              | °C                      | ISO 306        |
| Vicat Softening Temp, Rate B/120                    | 145                              | °C                      | ISO 306        |
| HDT/Be, 0.45MPa Edgew 120*10*4 sp=100mm             | 136                              | °C                      | ISO 75/Be      |
| HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm             | 125                              | °C                      | ISO 75/Ae      |
| Relative Temp Index, Elec <sup>(2)</sup>            | 125                              | °C                      | UL 746B        |
| Relative Temp Index, Mech w/impact <sup>(2)</sup>   | 115                              | °C                      | UL 746B        |
| Relative Temp Index, Mech w/o impact <sup>(2)</sup> | 125                              | °C                      | UL 746B        |
| <b>PHYSICAL <sup>(1)</sup></b>                      |                                  |                         |                |
| Specific Gravity                                    | 1.18                             | -                       | ASTM D792      |
| Mold Shrinkage, flow, 3.2 mm <sup>(3)</sup>         | 0.4 – 0.8                        | %                       | SABIC method   |
| Mold Shrinkage, xflow, 3.2 mm <sup>(3)</sup>        | 0.4 – 0.8                        | %                       | SABIC method   |
| Melt Flow Rate, 300°C/1.2 kgf                       | 10                               | g/10 min                | ASTM D1238     |
| Density   | 1.18                             | g/cm <sup>3</sup>       | 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               | 9                                | cm <sup>3</sup> /10 min | ISO 1133       |
| <b>ELECTRICAL <sup>(1)</sup></b>                    |                                  |                         |                |
| Comparative Tracking Index (UL) {PLC}               | 3                                | PLC Code                | UL 746A        |
| Hot-Wire Ignition (HWI), PLC 0                      | ≥0.8                             | mm                      | UL 746A        |
| High Amp Arc Ignition (HAI), PLC 0                  | ≥0.8                             | mm                      | UL 746A        |
| <b>FLAME CHARACTERISTICS <sup>(2)</sup></b>         |                                  |                         |                |
| UL Yellow Card Link                                 | <a href="#">E45329-100079881</a> | -                       | -              |
| UL Yellow Card Link 2                               | <a href="#">E45329-540671</a>    | -                       | -              |
| UL Recognized, 94HB Flame Class Rating              | ≥0.8                             | 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)                                  | 35                               | %                       | ISO 4589       |
| <b>INJECTION MOLDING <sup>(4)</sup></b>             |                                  |                         |                |
| Drying Temperature                                  | 120                              | °C                      |                |
| Drying Time   | 3 – 4                            | Hrs                     |                |
| Drying Time (Cumulative)                            | 48                               | Hrs                     |                |

| PROPERTIES                            | TYPICAL VALUES | UNITS | TEST METHODS |
|---------------------------------------|----------------|-------|--------------|
| 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    |              |
| <b>SHEET EXTRUSION <sup>(5)</sup></b> |                |       |              |
| Drying Temperature                    | 110 – 120      | °C    |              |
| Drying Time                           | 3 – 4          | Hrs   |              |
| Drying Time (Cumulative)              | 48             | Hrs   |              |
| Maximum Moisture Content              | 0.02           | %     |              |
| Melt Temperature                      | 245 – 260      | °C    |              |
| Barrel - Zone 1 Temperature           | 250 – 290      | °C    |              |
| Barrel - Zone 2 Temperature           | 245 – 270      | °C    |              |
| Barrel - Zone 3 Temperature           | 225 – 255      | °C    |              |
| Adapter Temperature                   | 225 – 255      | °C    |              |
| Die Temperature                       | 240 – 260      | °C    |              |
| Roll Stack Temp - Top                 | 75 – 115       | °C    |              |
| Roll Stack Temp - Middle              | 80 – 125       | °C    |              |
| Roll Stack Temp - Bottom              | 120 – 145      | °C    |              |

- (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.
- (5) Processing parameters are only mentioned as general guidelines. These may not apply or may need adjustment in specific situations.

## MORE INFORMATION

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

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