

LEXANTM COPOLYMER EXL1132

REGION ASIA

DESCRIPTION

LEXAN EXL1132 polycarbonate (PC) siloxane copolymer resin is a high flow, UV stabilized injection molding grade. This resin offers good low temperature (-20 C) ductility in combination with high flow characteristics and excellent processability with opportunities for shorter IM cycle times compared to standard PC. LEXAN EXL1132 resin is a general purpose product available in a wide range of opaque colors and may be an excellent candidate for a broad range 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/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	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 CTE, 23°C to 80°C, xflow 7.5E-05 1/°C ISO 11359-2 Ball Pressure Test, 125°C+/-2°C PASSIS - IEC 60699-10-2 Vicat Softening Temp, Rate B J20 144 °C ISO 306 Vicat Softening Temp, Rate B J120 145 °C ISO 306 HDT J6, 0.45 MPa Edgew 120*10°4 sp=100mm 125 °C ISO 75/Ae HDT J6, 0.45 MPa Edgew. Annealed 80°C, 4 hrs 136 °C U. 746B Relative Temp Index, Mech w/impact ⁽¹⁾ 120 °C U. 746B Relative Temp Index, Mech w/o impact ⁽²⁾ 130 °C U. 746B Relative Temp Index, Mech w/o impact ⁽²⁾ 130 °C U. 746B Relative Temp Index, Mech w/o impact ⁽²⁾ 130 °C U. 746B Relative Temp Index, Mech w/o impact ⁽²⁾ 130 °C U. 746B Relative Temp Index, Mech w/o impact ⁽²⁾ 130 °C U. 746B Relative Temp Index, Mech w/o impact ⁽²⁾ 130 °C U. 746B Relative Temp Index, Mech w/o		TYPICAL VALUES	UNITS	TEST METHODS
CTE, 23°C to 80°C, xflow	80°C. flow	7.5E-05	1/°C	ISO 11359-2
Vicat Softening Temp, Rate B/50 144 °C ISO 306 Vicat Softening Temp, Rate B/120 145 °C ISO 306 HDT/Re, 1.8 MPa Edgew 120°10°4 sp=100mm 125 °C ISO 75/Re HDT/Be, 0.45 MPa Edgew Annealed 80°C,4 hrs 136 °C ISO 75/Re 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/Impact (²) 130 °C UL 746B Relative Temp Index, Mech w/Impact (²) 130 °C UL 746B Relative Temp Index, Mech w/Impact (²) 130 °C UL 746B Relative Temp Index, Mech w/Impact (²) 130 °C UL 746B Relative Temp Index, Mech w/Impact (²) 130 °C UL 746B Relative Temp Index, Mech w/Impact (²) 130 °C UL 746B Relative Temp Index, Mech w/Impact (²) 1.18 SAIM (?) SAIM (?) Mode Shrinkage, flow, 3.2 mm (²) 0.4 – 0.8 \$AIM (?) SAIM (?) Molf Shrinkage, flow, 3.2 mm (²)		7.5E-05	,	
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 Ae, 1.8 MPa Edgew. Annealed 80°C, 4 hrs 136 °C ISO 75 Ae HDT Ae, 0.45 MPa edgew. Annealed 80°C, 4 hrs 130 °C UI. 746B Relative Temp Index, Elec UI. 746B 120 °C UI. 746B Relative Temp Index, Mech w / impact UI. 746B 120 °C UI. 746B Relative Temp Index, Mech w / impact UI. 746B 120 °C UI. 746B Relative Temp Index, Mech w / impact UI. 746B 130 °C UI. 746B Relative Temp Index, Mech w / impact UI. 746B 130 °C UI. 746B Relative Temp Index, Mech w / impact UI. 746B 130 °C UI. 746B 140 14		PASSES	,	
HDT Ae, 1.8 MPa Edgew 120°10°4 sp=100mm	ing Temp, Rate B/50	144	°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 Relative Temp Index, Mech w/o impact ^[2] 130 °C UL 746B Relative Temp Index, Mech w/o impact ^[2] 130 °C UL 746B PHYSICAL UR 75 Specific Gravity 1.18 °C ASTM D792 Mold Shrinkage, riflow, 3.2 mm ^[3] 0.4 − 0.8 % SABIC method Molf How Rate, 300°C/1.2 kg 17 g/Cm³ ISO 1183 Water Absorption (23°C/sturated) 0.35 % ISO 62 Melt Volume Rate, MVR at 300°C/1.2 kg 10.15 % ISO 62 Melt Volume Rate, MVR at 300°C/1.2 kg 20.75 mm UL 94 875<	- '	145	°C	ISO 306
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) Feefit Gravity 1.18 - ASTM D792 Mold Shrinkage, flow, 3.2 mm (3) 0.4 - 0.8 % SABIC method Mold Shrinkage, flow, 3.2 mm (3) 0.4 - 0.8 % SABIC method Melt Flow Rate, 300°C/1.2 kgf 17 g/cm³ SSD 1183 Density 1.19 g/cm³ ISO 62-1 Water Absorption (23°C/saturated) 0.35 % ISO 62-1 Molisture Absorption (23°C/saturated) 0.15 % ISO 62-1 Melt Volume Rate, MVR at 300°C/1.2 kg 16 m²/10 min ISO 1133 FLAME CHARACTERISTICS (2) E E E E E E E E E E E E E E E E E E E C E E	MPa Edgew 120*10*4 sp=100mm	125	°C	ISO 75/Ae
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 % ASIC method Mold Shrinkage, flow, 3.2 mm (³) 0.4-0.8 % ASIC method Mold Shrinkage, sflow, 3.2 mm (³) 0.4-0.8 % ASIC method Mold Shrinkage, sflow, 3.2 mm (³) 0.4-0.8 % ASIC method Mold Shrinkage, flow, 3.2 mm (³) 0.4-0.8 % ASIC method Mold Shrinkage, flow, 3.2 mm (³) 0.4-0.8 % ASIC method Mold Shrinkage, flow, 3.2 mm (³) 0.4-0.8 % ASIC method Melt Flow Rate, MSR at 300°C/1.2 kg 1.19 g/cm² ISO 1133 Make Chas Rating 0.15 % 150 62 UL NECOSORIZAGA 94HB Flame Class Rating 85 C IEC 60695-2:13 Clow Wire Ighitability Temperature, 1.5 mm 875 °C IEC 60695-2:13 <td>5 MPa edgew. Annealed 80°C, 4 hrs</td> <td>136</td> <td>°C</td> <td>ISO 75/Be</td>	5 MPa edgew. Annealed 80°C, 4 hrs	136	°C	ISO 75/Be
Relative Temp Index, Mech w/o inspact (2) 130 °C U.746B PHYSICAL (1) Specific Gravity 1.18 - ASTM D792 Mold Shrinkage, flow, 3.2 mm (3) 0.4 – 0.8 \$ ASIC method Melt Flow Rate, 300°C/1.2 kgf 17 g/main ASTM D1238 Density 1.19 g/cm³ ISO 123 Water Absorption, (23°C/50% RH) 0.15 % S06 2 Melt Volume Rate, MVR at 300°C/1.2 kg 16 m²/10 min ISO 1133 FLAME CHARACTERISTICS (2) U.Yellow Card Link £207780-565163 - - U.Yellow Card Link £207780-565163 - - Glow Wire Ignitability Temperature, 3.0 mm 875 - - EC 60695-2·13 Glow Wire Ignitability Temperature, 1.5 mm 875 - - EC 60695-2·13 Glow Wire Ignitability Temperature, 0.75 mm 875 - - EC 60695-2·13 Glow Wire Flammability Index, 3.0 mm 96 - - EC 60695-2·12 Glow Wire Flammability Index,	ıp Index, Elec ⁽²⁾	130	°C	UL 746B
Relative Temp Index, Mech w/o inspact (2) 130 °C U.746B PHYSICAL (1) Specific Gravity 1.18 - ASTM D792 Mold Shrinkage, flow, 3.2 mm (3) 0.4 – 0.8 \$ ASIC method Melt Flow Rate, 300°C/1.2 kgf 17 g/main ASTM D1238 Density 1.19 g/cm³ ISO 123 Water Absorption, (23°C/50% RH) 0.15 % S06 2 Melt Volume Rate, MVR at 300°C/1.2 kg 16 m²/10 min ISO 1133 FLAME CHARACTERISTICS (2) U.Yellow Card Link £207780-565163 - - U.Yellow Card Link £207780-565163 - - Glow Wire Ignitability Temperature, 3.0 mm 875 - - EC 60695-2·13 Glow Wire Ignitability Temperature, 1.5 mm 875 - - EC 60695-2·13 Glow Wire Ignitability Temperature, 0.75 mm 875 - - EC 60695-2·13 Glow Wire Flammability Index, 3.0 mm 96 - - EC 60695-2·12 Glow Wire Flammability Index,	np Index, Mech w/impact (2)	120	°C	UL 746B
Specific Gravity 1.18 - O. A STM 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/cm³ ISO 1183 Water Absorption, (23°C/saturated) 0.35 % ISO 62-1 Moisture Absorption (23°C / 50% RH) 0.15 % ISO 62-1 Melt Volume Rate, MVR at 300°C/1.2 kg 16 cm³/10 min ISO 1133 FLAME CHARACTERITICS (²) * * ISO 62-1 UL Yellow Card Link 207780-565163 * * * UL Recognized, 94HB Flame Class Rating 20.75 mm UL 506095-2-13 * Glow Wire Ignitability Temperature, 3.0 mm 875 * * * * Glow Wire Ignitability Temperature, 0.75 mm 875 * * * * Glow Wire Ignitability Temperature, 0.75 mm 875 * * * *	np Index, Mech w/o impact ⁽²⁾	130	°C	UL 746B
Specific Gravity 1.18 - C ASTM D792 Mold Shrinkage, flow, 3.2 mm (3) 0.4 − 0.8 % ABIC method Mold Shrinkage, xflow, 3.2 mm (3) 0.4 − 0.8 % ASIM C method Melt Flow Rate, 300°C/1.2 kgf 17 g/10 min ASTM D1238 Density 1.19 g/cm³ ISO 1183 Water Absorption, (23°C/saturated) 0.35 % 150 G2-1 Moist Volume Rate, MVR at 300°C/1.2 kg 10.15 % 150 G2-1 Melt Volume Rate, MVR at 300°C/1.2 kg 16 cm³/l om in 50 G2-1 Mill Volume Rate, MVR at 300°C/1.2 kg 20.75 mm 0.91 min 50 G2-1 MIL Volume Rate, MVR at 300°C/1.2 kg 20.75 mm 0.94 1.94 UL Yellow Card Link 20.75 mm 0.94 1.94 UL Recognized, 94HB Flame Class Rating 875 °C 1.05 1.94 Glow Wire Ignitability Temperature, 3.0 mm 875 °C 1.05 1.05 1.05 1.05 1.05 1.05 1.05 1.05 1.05				
Mold Shrinkage, flow, 3.2 mm ⁽¹⁾ 0.4 - 0.8 % ABIC method Mold Shrinkage, xflow, 3.2 mm ⁽¹⁾ 0.4 - 0.8 % ABIC method Melt Flow Rate, 300°C/1.2 kgf 17 g/10 min ASTM D1238 Density 1.19 g/cm³ ISO 1183 Water Absorption, (23°C / 50% RH) 0.15 % 50 62-1 Melt Volume Rate, MVR at 300°C/1.2 kg 16 cm³/l 0 min ISO 133 FLAME CHARACTERISTICS ⁽²⁾ U.1 Yellow Card Link £207780-565163 ~ ~ U.1 Recognized, 94HB Flame Class Rating 20.75 mm U.9 4 Glow Wire Ignitability Temperature, 3.0 mm 875 ~ C IEC 60695-213 Glow Wire Ignitability Temperature, 1.0 mm 875 ~ C IEC 60695-213 Glow Wire Flammability Index, 3.0 mm 960 ~ C IEC 60695-212 Glow Wire Flammability Index, 1.5 mm 960 ~ C IEC 60695-212 Glow Wire Flammability Index, 1.0 mm 960 ~ C IEC 60695-212 Glow Wire Flammability Index, 0.75 mm 850 ~	vity	1.18		ASTM D792
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/cm³ 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 cm³/10 min ISO 133 FLAME CHARACTERISTICS (2) UL Yellow Card Link £207780-565163 √ . UL Recognized, 94HB Flame Class Rating ≥0.75 mm UL 94 Glow Wire Ignitability Temperature, 3.0 mm 875 √ IEC 60695-2·13 Glow Wire Ignitability Temperature, 1.5 mm 875 √ IEC 60695-2·13 Glow Wire Flammability Index, 3.0 mm 960 √ IEC 60695-2·12 Glow Wire Flammability Index, 1.5 mm 960 √ IEC 60695-2·12 Glow Wire Flammability Index, 1.0 mm 960 √ IEC 60695-2·12 Glow Wire Flammability Index, 0.75 mm 850 ∼ IEC 60695-2·12 </td <td></td> <td>0.4 – 0.8</td> <td>%</td> <td>SABIC method</td>		0.4 – 0.8	%	SABIC method
Melt Flow Rate, 300°C/1.2 kgf 17 g/10 min ASTM D1238 Density 1.19 g/cm³ ISO 1183 Water Absorption, (23°C / 50% RH) 0.35 % ISO 62-1 Melt Volume Rate, MVR at 300°C/1.2 kg 16 cm³/10 min ISO 133 FLAME CHARACTERISTICS (2) UL Yellow Card Link £207780-565163 - - UL Recognized, 94HB Flame Class Rating 20.75 mm UL 94 Glow Wire Ignitability Temperature, 3.0 mm 875 ° C IEC 60695-2·13 Glow Wire Ignitability Temperature, 1.5 mm 875 ° ° IEC 60695-2·13 Glow Wire Ignitability Temperature, 0.75 mm 875 ° ° IEC 60695-2·13 Glow Wire Flammability Index, 3.0 mm 960 ° ° IEC 60695-2·12 Glow Wire Flammability Index, 1.5 mm 960 ° ° IEC 60695-2·12 Glow Wire Flammability Index, 0.75 mm 850 ° ° IEC 60695-2·12 Glow Wire Flammability Index, 0.75 mm 850 ° ° IEC 60695-2·12				
Density J.19 g/cm³ 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 cm³/10 min ISO 1133 FLAME CHARACTERISTICS (2) UL Yellow Card Link £207780-565163 - - UL Recognized, 94HB Flame Class Rating 20.75 mm UL 94 Glow Wire Ignitability Temperature, 3.0 mm 875 °C IEC 60695-2·13 Glow Wire Ignitability Temperature, 1.0 mm 875 °C IEC 60695-2·13 Glow Wire Ignitability Temperature, 0.75 mm 960 °C IEC 60695-2·12 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, 0.75 mm 850 °C IEC 60695-2·12 Glow Wire Flammability Index, 0.75 mm 850 °C IEC 60695-2·12 Glow Wire Flammability Index, 0.75 mm 850 °C IEC		17	g/10 min	ASTM D1238
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 cm³/10 min ISO 1133 FLAME CHARACTERISTICS (2) UL Yellow Card Link E207780-565163 - - UL Recognized, 94HB Flame Class Rating 20.75 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, 0.75 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, 0.75 mm 850 °C IEC 60695-2·12 Oxygen Index (LOI) 32 % 150 (20695-2·12 150 (20695-2·12 150 (20695-2·12 150 (20695-2·12 150 (20695-2·12 150 (20695-2·12 150 (20695-2·12 150 (20695-2·12				
Moisture Absorption (23°C / 50% RH) 0.15 % ISO 62 Melt Volume Rate, MVR at 300°C / 1.2 kg 16 cm³/10 min ISO 1133 FLAME CHARACTERISTICS (2) UL Yellow Card Link E207780-565163 - - UL Recognized, 94HB Flame Class Rating ≥0.75 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, 0.75 mm 875 °C IEC 60695-2-13 Glow Wire Ignitability 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, 0.75 mm 850 °C IEC 60695-2-12 Oxygen Index (LOI) \$2 IEC 60695-2-12 X Wire Flammability Index, 0.75 mm 850 °C IEC 60695-2-12 Oxygen Index (LOI) \$2 IEC	ption, (23°C/saturated)	0.35		
Melt Volume Rate, MVR at 300°C/1.2 kg 16 cm³/10 min ISO 1133 FLAME CHARACTERISTICS (²) UL Yellow Card Link E207780-565163 - - UL Recognized, 94HB Flame Class Rating ≥0.75 mm UL 94 Glow Wire Ignitability Temperature, 3.0 mm 875 °C IEC 60695-2-13 Glow Wire Ignitability Temperature, 1.0 mm 875 °C IEC 60695-2-13 Glow Wire Ignitability Temperature, 0.75 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, 0.75 mm 850 °C IEC 60695-2-12 Glow Wire Flammability Index, 0.75 mm 850 °C IEC 60695-2-12 Oxygen Index (LOI) 32 % ISO 4589		0.15	%	ISO 62
UL Yellow Card Link E207780-565163 - <		16	cm³/10 min	ISO 1133
UL Yellow Card Link E207780-565163 - - UL Recognized, 94HB Flame Class Rating 20.75 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, 0.0 mm 875 °C IEC 60695-2·13 Glow Wire Ignitability Temperature, 0.75 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, 0.75 mm 850 °C IEC 60695-2·12 Oxygen Index (LOI) 32 % ISO 4589	ACTERISTICS (2)		·	
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Glow Wire Ignitability Temperature, 3.0 mm 875 670 670 670 670 670 670 670 6			mm	III 94
Glow Wire Ignitability Temperature, 1.5 mm 875 670 670 670 670 670 670 670 6				
Glow Wire Ignitability Temperature, 1.0 mm 875 670 670 670 670 670 670 670 6				
Glow Wire Ignitability Temperature, 0.75 mm 875 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, 0.75 mm 850 °C IEC 60695-2-12 Oxygen Index (LOI) 32 NJECTION MOLDING (4)				
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, 0.75 mm 850 °C IEC 60695-2-12 Oxygen Index (LOI) 32 % ISO 4589 INJECTION MOLDING (4)			°C	IEC 60695-2-13
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, 0.75 mm 850 °C IEC 60695-2-12 Oxygen Index (LOI) 32 % ISO 4589 INJECTION MOLDING (4)		960	°C	IEC 60695-2-12
Glow Wire Flammability Index, 0.75 mm 850 °C IEC 60695-2-12 Oxygen Index (LOI) 32 % ISO 4589 INJECTION MOLDING (4) ** ** **	lammability Index, 1.5 mm	960	°C	IEC 60695-2-12
Oxygen Index (LOI) 32 % ISO 4589 INJECTION MOLDING ⁽⁴⁾	lammability Index, 1.0 mm	960	°C	IEC 60695-2-12
INJECTION MOLDING ⁽⁴⁾	lammability Index, 0.75 mm	850	°C	IEC 60695-2-12
	ex (LOI)	32	%	ISO 4589
P. 1. T.	IOLDING ⁽⁴⁾			
Drying Temperature 120 °C	perature	120	°C	
Drying Time 3 – 4 Hrs		3 – 4	Hrs	
Drying Time (Cumulative) 48 Hrs	(Cumulative)	48	Hrs	
Maximum Moisture Content 0.02 %	oisture Content	0.02	%	
Melt Temperature 295 – 315 °C	rature	295 – 315	°C	
Nozzle Temperature 290 – 310 °C	perature	290 – 310	°C	
Front - Zone 3 Temperature 295 – 315 °C	3 Temperature	295 – 315	°C	
Middle - Zone 2 Temperature 280 – 305 °C	e 2 Temperature	280 – 305	°C	
Rear - Zone 1 Temperature 270 – 295 °C	Temperature	270 – 295	°C	
Mold Temperature 70 – 95 °C	rature	70 – 95	°C	
Back Pressure 0.3 – 0.7 MPa	re	0.3 – 0.7	MPa	
Screw Speed 40 – 70 rpm	I	40 – 70	rpm	
Shot to Cylinder Size 40 – 60 %		40 – 60	%	



PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
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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