LEXAN™ COPOLYMER EXL9330

REGION ASIA

DESCRIPTION

EXL9330 is an opaque (PC)- siloxane copolymer resin that offers extreme low temperature (-60 C) ductility in combination with excellent processability. This UV stabilized, medium flow resin features UL f1/V-0/5VA rating with non-chlorinated, non-brominated flame retardant agents for wide range of colors. EXL9330 is an excellent candidate for a broad range of applications such as mobile phones, tablets, industrial housings, electric circuit protection, personal safety helmets, electric vehicle supply equipment (EVSE) housings and connectors.

TYPICAL PROPERTY VALUES

Revision 20260804

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	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	60	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	6	%	ISO 527
Tensile Strain, break, 50 mm/min	125	%	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	2200	MPa	ISO 178
Ball Indentation Hardness, H358/30	90	MPa	ISO 2039-1
IMPACT [1]			
Izod impact, notched			
23°C	801	J/m	ASTM D256
-30°C	678	J/m	ASTM D256
-50°C	587	J/m	ASTM D256
23°C, 6.4mm	640	J/m	ASTM D256
80*10*3 +23°C	70	kJ/m²	ISO 180/1A
80*10*3 -30°C	55	kJ/m²	ISO 180/1A
63.5*12.7*3.2, 23°C	80	kJ/m²	ISO 180/4A
63.5*12.7*3.2, -30°C	65	kJ/m²	ISO 180/4A
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/m²	ISO 180/1U
80*10*3 -30°C	NB	kJ/m²	ISO 180/1U
Charpy 23°C, V-notch Edgew 80*10*3 sp=62mm	75	kJ/m²	ISO 179/1eA
Charpy -30°C, V-notch Edgew 80*10*3 sp=62mm	60	kJ/m²	ISO 179/1eA
Charpy 23°C, Unnotch Edgew 80*10*3 sp=62mm	NB	kJ/m²	ISO 179/1eU

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Charpy -30°C, Unnotch Edgew 80*10*3 sp=62mm	NB	kJ/m²	ISO 179/1eU
THERMAL [1]			
Vicat Softening Temp, Rate B/50	142	°C	ASTM D1525
HDT, 0.45 MPa, 3.2 mm, unannealed	134	°C	ASTM D648
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	7.7E-05	1/°C	ISO 11359-2
Ball Pressure Test, 125°C +/- 2°C	PASSES	-	IEC 60695-10-2
Vicat Softening Temp, Rate B/50	140	°C	ISO 306
Vicat Softening Temp, Rate B/120	142	°C	ISO 306
HDT/Be, 0.45MPa Edgew 120*10*4 sp=100mm	135	°C	ISO 75/Be
HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm	124	°C	ISO 75/Ae
Relative Temp Index, Elec [2]	125	°C	UL 746B
Relative Temp Index, Mech w/impact [2]	115	°C	UL 746B
Relative Temp Index, Mech w/o impact [2]	125	°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	10	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			
300°C/1.2 kg	9	cm³/10 min	ISO 1133
ELECTRICAL [1]			
Dielectric Strength, in oil, 3.2 mm	17	kV/mm	ASTM D149
Relative Permittivity, 50/60 Hz	2.95	-	ASTM D150
Relative Permittivity, 1 MHz	2.9	-	ASTM D150
Dissipation Factor			
50/60 Hz	0.0024	-	ASTM D150
1 MHz	0.0085	-	ASTM D150
50/60 Hz	0.001	-	IEC 60250
1 MHz	0.0085	-	IEC 60250
Volume Resistivity	>1.E+15	Ω.cm	IEC 60093
Surface Resistivity, ROA	>1.E+15	Ω	IEC 60093
Dielectric Strength, in oil, 3.2 mm	16	kV/mm	IEC 60243-1
Relative Permittivity, 1 MHz	2.7	-	IEC 60250
Comparative Tracking Index	225	V	IEC 60112
Relative Permittivity, 50/60 Hz	2.6	-	IEC 60250
Comparative Tracking Index (UL) {PLC}	3	PLC Code	UL 746A

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Hot-Wire Ignition (HWI), PLC 1	≥3	mm	UL 746A
Hot-Wire Ignition (HWI), PLC 2	≥1.5	mm	UL 746A
Hot-Wire Ignition (HWI), PLC 3	≥0.6	mm	UL 746A
High Amp Arc Ignition (HAI), PLC 0	≥2.3	mm	UL 746A
High Amp Arc Ignition (HAI), PLC 1	≥0.6	mm	UL 746A
FLAME CHARACTERISTICS [2]			
UL Yellow Card Link	E207780-102516601	-	-
UL Yellow Card Link 2	E207780-228378	-	-
UL Recognized, 94-5VA Flame Class Rating	≥3	mm	UL 94
UL Recognized, 94-5VB Flame Class Rating	≥2.5	mm	UL 94
UL Recognized, 94V-0 Flame Class Rating	≥1.5	mm	UL 94
UL Recognized, 94V-1 Flame Class Rating	≥0.8	mm	UL 94
UL Recognized, 94HB Flame Class Rating	≥0.6	mm	UL 94
Glow Wire Ignitability Temperature, 3.0 mm	825	°C	IEC 60695-2-13
Glow Wire Ignitability Temperature, 2.5 mm	825	°C	IEC 60695-2-13
Glow Wire Ignitability Temperature, 2.3 mm	825	°C	IEC 60695-2-13
Glow Wire Ignitability Temperature, 2.0 mm	825	°C	IEC 60695-2-13
Glow Wire Ignitability Temperature, 1.5 mm	825	°C	IEC 60695-2-13
Glow Wire Ignitability Temperature, 1.0 mm	825	°C	IEC 60695-2-13
Glow Wire Flammability Index, 3.0 mm	960	°C	IEC 60695-2-12
Glow Wire Flammability Index, 2.5 mm	960	°C	IEC 60695-2-12
Glow Wire Flammability Index, 2.3 mm	960	°C	IEC 60695-2-12
Glow Wire Flammability Index, 2.0 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
Oxygen Index (LOI)	35	%	ISO 4589
UV-light, water exposure/immersion	F1	-	UL 746C
INJECTION MOLDING [4]			
Drying Temperature	120	°C	
Drying Time	3 – 4	Hrs	
Drying Time (Cumulative)	48	Hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	255 – 315	°C	
Nozzle Temperature	250 – 310	°C	
Front - Zone 3 Temperature	255 – 315	°C	
Middle - Zone 2 Temperature	245 – 305	°C	
Rear - Zone 1 Temperature	235 – 295	°C	
Mold Temperature	70 – 120	°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	

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(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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