LEXAN™ Copolymer EXL9330S

REGION AMERICAS

DESCRIPTION

Opaque PC-Siloxane copolymer with excellent processability. UV stabilized. UL rated V-0/5VA/CTI-PLC-2. Available in limited colors; please contact your SABIC IP representative

TYPICAL PROPERTY VALUES

Revision 20260901

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL [1]			
Tensile Stress, yld, Type I, 50 mm/min	59	MPa	ASTM D638
Tensile Stress, brk, Type I, 50 mm/min	58	MPa	ASTM D638
Tensile Strain, yld, Type I, 50 mm/min	6	%	ASTM D638
Tensile Strain, brk, Type I, 50 mm/min	100	%	ASTM D638
Tensile Modulus, 50 mm/min	2150	MPa	ASTM D638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	86	MPa	ASTM D790
Flexural Modulus, 1.3 mm/min, 50 mm span	2150	MPa	ASTM D790
Tensile Stress, yield, 50 mm/min	59	MPa	ISO 527
Tensile Stress, break, 50 mm/min	58	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	6	%	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	86	MPa	ISO 178
Flexural Modulus, 2 mm/min	2150	MPa	ISO 178
IMPACT [1]			
Izod impact, notched			
23°C	700	J/m	ASTM D256
-30°C	550	J/m	ASTM D256
-50°C	450	J/m	ASTM D256
80*10*3 +23°C	75	kJ/m²	ISO 180/1A
80*10*3 -30°C	50	kJ/m²	ISO 180/1A
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	70	kJ/m²	ISO 179/1eA
Charpy -30°C, V-notch Edgew 80*10*3 sp=62mm	50	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	147	°C	ASTM D1525
HDT, 0.45 MPa, 3.2 mm, unannealed	139	°C	ASTM D648
HDT, 1.82 MPa, 3.2mm, unannealed	126	°C	ASTM D648
Ball Pressure Test, 125°C +/- 2°C	PASSES	-	IEC 60695-10-2
Vicat Softening Temp, Rate B/50	145	°C	ISO 306

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Vicat Softening Temp, Rate B/120	147	°C	ISO 306
HDT/Be, 0.45MPa Edgew 120*10*4 sp=100mm	139	°C	ISO 75/Be
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	126	°C	ISO 75/Af
PHYSICAL (1)			
Specific Gravity	1.24	-	ASTM D792
Mold Shrinkage, flow, 3.2 mm (2)	0.4 – 0.8	%	SABIC method
Mold Shrinkage, xflow, 3.2 mm (2)	0.4 – 0.8	%	SABIC method
Melt Flow Rate, 300°C/1.2 kgf	8	g/10 min	ASTM D1238
Density	1.24	g/cm³	ISO 1183
Water Absorption, (23°C/saturated)	0.12	%	ISO 62-1
Moisture Absorption (23°C / 50% RH)	0.05	%	ISO 62
Melt Volume Rate, MVR at 300°C/1.2 kg	7	cm³/10 min	ISO 1133
ELECTRICAL (1)			
Comparative Tracking Index	250	V	IEC 60112
INJECTION MOLDING (3)			
Drying Temperature	120	°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	275 – 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) 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.

(3) 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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