

LEXANTM COPOLYMER EXL9132

REGION EUROPE

DESCRIPTION

Opaque PC-Siloxane copolymer with excellent processability. Improved flow, low temperature ductility, UV stabilized. Non-chlorinated, non-brominated flame retardant product. UL rated VO/5VA.

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	103	%	ASTM D638
Tensile Modulus, 50 mm/min	2260	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	2330	MPa	ASTM D790
Tensile Stress, yield, 50 mm/min	59	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	2200	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	88	MPa	ISO 178
Flexural Modulus, 2 mm/min	2300	MPa	ISO 178
Ball Indentation Hardness, H358/30	95	MPa	ISO 2039-1
IMPACT (1)			
Izod Impact, notched, 23°C	731	J/m	ASTM D256
Izod Impact, notched, -30°C	560	J/m	ASTM D256
Instrumented Dart Impact Total Energy, 23°C	67	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	143	°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	7.2E-05	1/°C	ASTM E831
CTE, 23°C to 80°C, flow	7.5E-05	1/°C	ISO 11359-2



TYPICAL VALUES TYPICAL VALUES TEST METHODS				
Ball Pressure Test, 125°C+1-2°C PKSSS - IC 60699-10-2 EC 60699-10-2 Vicas Softening Temp, Rate B/50 144 °C 503 306 HDT Jie, 0.45MPa Edgew 120°10⁴4 sp=100mm 136 °C 50 75/Be HDT Jie, 1.8 MPa Edgew 120°10⁴4 sp=100mm 124 °C 50 75/Be HDT Jie, 1.8 MPa Edgew 120°10⁴4 sp=100mm 1.18 - ASTM D792 PHYSICAL T [®] F ASTM D792 ASTM D792 Mold Shrinkage, filow, 3.2 mm ¹⁰ 04-0.8 \$ASIIC method Mold Shrinkage, filow, 3.2 mm ¹⁰ 17 glcm³ SOI 183 Melt Flow Rate, 300°C/1.2 kgf 1.19 glcm³ SOI 183 Water Absorption, (23°C/5 sturated) 0.5 \$ SOG 62 Melt Volume Rate, MVR at 300°C/1.2 kg 16 m/10 min SOI 133 EECTRICAL [®] 27 KC 60250 Beleative Fermithility, 5 ml/se 0.004 - KC 60250 Dissipation Factor, 50/60 Hz 0.004 - KC 60250 Relative Permithility, 50/60 Hz 7 KC 60250 Robying Time (Cum	PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Vicat Softening Temp, Rate B/120 144 °C ISO 306 Vicat Softening Temp, Rate B/120 144 °C ISO 306 HDT/Be, 0.45MPh Edgew 120*10*4 sp=100mm 124 °C ISO 75/Be HDT/Be, 1.8 MPa Edgew 120*10*4 sp=100mm 124 °C ISO 75/Be PHYSICAL.** ************************************	CTE, 23°C to 80°C, xflow	7.5E-05	1/°C	ISO 11359-2
Vicate Softening Temp. Rate 8 120 144 °C ISO 306 HDT [Re, 0.48MPs Edgew 120*10*4 sp=100mm 136 °C ISO 75 [Re HDT [Ae, 1.8 MPs Edgew 120*10*4 sp=100mm 124 °C ISO 75 [Re PHYSICAL ************************************	Ball Pressure Test, 125°C +/- 2°C	PASSES	-	IEC 60695-10-2
HDT/Be. 0.45MPs Edgew 120*10*4 sp=100mm 136 ℃ ISO 75/Be HDT/Be. 0.45MPs Edgew 120*10*4 sp=100mm 124 ℃ SO 75/Be PHYSICAL.** S SO 75/Be PHYSICAL.** S ASTM 0792 Bool of Shrinkage, flow, 3.2 mm ⁽²⁾ 0.4–0.8 % ASIM 0792 Mold Shrinkage, sflow, 3.2 mm ⁽²⁾ 0.4–0.8 % ASIM D1238 Melt Flow Rate, 300*C/1 kgl 1.19 g/cm³ ASTM D1238 Water Absorption, (23°C/ psix Rth) 0.35 % SO 62-1 Melt Volume Rate, Mbr. at 300°C/1.2 kg 0.15 % SO 62-1 Melt Volume Rate, Mbr. at 300°C/1.2 kg 0.15 % SO 62-1 Melt Volume Rate, Mbr. at 300°C/1.2 kg 19 Mc/mm EC 60243-1 Relative Permittivity, TMbr. 2.7 % Mc 60250 Relative Permittivity, TMbr. 2.7 % Mc 60250 Subjection Factor, 1 MHz 0.01 % EC 60250 Relative Permittivity, Solo bit 2 2.7 % Co 5050 Polying Time (cum beliative)	Vicat Softening Temp, Rate B/50	143	°C	ISO 306
HOT/Ae. 1.8 MPa Edgew 120*10*4 sp=100mm 124 °C ISO 75/Ae PHYSICAL. ¹¹ Specific Gravity 1.18 - ASIM D792 Specific Gravity 0.4−0.8 % ASIM D792 Mold Shrinkage, filow, 3.2 mm ¹² 0.4−0.8 % ASIM D792 Mold Shrinkage, xflow, 3.2 mm ¹² 0.4−0.8 % ASIM D1238 Melt Flow Rate, 300°C/1.2 kgf 17 g/cm² ISD 621 Water Absorption (23°C/ 50% Rth) 0.15 % OS 621 SO 621 Molosture Absorption (23°C/ 50% Rth) 0.15 % OS 621 SO 621 Molosture Absorption (23°C/ 50% Rth) 0.15 % OS 621 SO 621 Molosture Absorption (23°C/ 50% Rth) 0.15 % OS 621 SO 621 Molosture Absorption (23°C/ 50% Rth) 0.15 % OS 621 SO 621 Melet Volume Rate, MVR at 300°C/1.2 kg 0.15 % OS 621 SO 621 Beletive Permittivity, 1 MHz 2.7 % OS 625 SO 621 Bispation Factor, 1 Mth2 0.00 % OS 625 SO 621 Comparative Tracking Index 2.7 % OS 625 SO 621	Vicat Softening Temp, Rate B/120	144	°C	ISO 306
PHYSICAL ¹¹ Specific Gravity 1.18 - C ASTM D792 Mold Shrinkage, flow, 3.2 mm ¹² 0.4 − 0.8 3 ASBC method Mold Shrinkage, xflow, 3.2 mm ¹² 0.4 − 0.8 3 ASBC method Met Flow Rate, 300°C/1.2 kgf 1.9 g/10 min ASTM D1238 Density 1.19 3 (50 c²) 150 c² Water Absorption, (23°C/ saturated) 0.35 % 150 c² Molsture Absorption (23°C/ saturated) 0.15 % 150 c² Met Volume Rate, MVR at 300°C/1.2 kg 16 cm²/10 min 150 c² Met Volume Rate, MVR at 300°C/1.2 kg 19 k//mm IEC 60243-1 Relative Permittivity, 1 Mlr2 2,7 1 IEC 60250 Dissipation Factor, 50 (60 ftz 0.0004 9 IEC 60250 Comparative Tracking Index 17 y IEC 60250 Relative Permittivity, 50 (60 ftz 12 y IEC 60250 Objing Time (cumulative) 3-4 Hrs IEC 60250 Drying Time (cumulative) 9 <	HDT/Be, 0.45MPa Edgew 120*10*4 sp=100mm	136	°C	ISO 75/Be
Specific Gravity 1.18 ASTM D792 Mold Shrinkage, flow, 3.2 mm ⁽²⁾ 0.4 – 0.8 % ASMIC method Mold Shrinkage, xflow, 3.2 mm ⁽²⁾ 0.4 – 0.8 % ASMIC method Melk Flow Rate, 300°C 1.2 kgf 17 g/m² ASTM D1238 Bossity 1.99 9/m² SO 62 183 Water Absorption (23°C / 50% RH) 0.35 % 50 62 1 Melt Volume Rate, word 1,2°C / 50% RH) 0.16 2m² of m² 50 62 1 Melt Volume Rate, word 1,2°C / 50% RH) 19 k²/m² 10 62 2 Melt Volume Rate, word 1,2°C / 50% RH) 19 k²/m² 10 62 2 Melt Volume Rate, word 1,2°C / 50% RH 19 k²/m² 10 62 2 Melt Volume Rate, word 1,2°C / 50% RH 19 k²/m² 10 62 2 Melt Volume Rate, word 1,2°C / 50% RH 2 10 62 2 10 62 2 Beleative Permittivity, 1Mt2 2 7 2 10 62 2 10 62 2 Comparative Tracking Index 17 2 10 62 2 10 62 2 10 62 2 Relativ	HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm	124	°C	ISO 75/Ae
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 17 g/m³ STM D128 Density 1.19 g/m³ SO 62-1 Water Absorption (2³°C/50°RH) 0.15 % SO 62-1 Melt Volume Rate, MVR at 300°C/1.2 kg 16 "J min SO 133 ELECTRICAL ⁽¹⁾ W/m EC 60243-1 Electric Strength, in oil, 3.2 mm 9 M/m EC 60243-1 Pelative Permittivity, 1 Mth2 2,7 EC 60250 Dispisation Factor, 50/60 k2 0.004 2 EC 60250 Comparative Tracking Index 175 V EC 60250 Relative Permittivity, 50/60 k2 2 P EC 60250 Relative Permittivity, 50/60 k2 3-4 H EC 60250 Relative Permittivity, 50/60 k2 3-4 H EC 60250 Pring Time (Cumulative) 2 C EC 60250 Pring Time (Cumulative) 3-4 H	PHYSICAL (1)			
Mold Shrinkage, xflow, 3.2 mm ¹⁹ 0.4 – 0.8 % — SAIC memodination Melt Flow Rate, 300°C/1.2 kgf 17 y cm² ASTM D1238 Density 1.99 y cm² 50 1183 Water Absorption (23°C f 50% RH) 0.15 % 60 62-1 Molisture Absorption (23°C f 50% RH) 1.6 x m³/10 min 50 62-1 Melt Volume Rate, MVR at 30°C/1.2 kg 1.6 x m³/10 min 150 62-1 ELECTRICAL (**) x y/mn 1.6 6043-1 1.6 6043-1 Relative Permittivity, 1 MHz 2.7 2.0 1.6 60250 Dissipation Factor, 50 f60 Hz 0.004 2.0 1.6 60250 Subsipation Factor, 1 MHz 2.7 2.0 1.6 60250 Relative Permittivity, 50 f60 Hz 2.7 2.0 1.6 60250 Relative Permittivity, 50 f60 Hz 2.7 2.0 1.6 60250 Turbur Tur	Specific Gravity	1.18	-	ASTM D792
Melt Flow Rate, 300°C/1.2 kgf 17 9/10 min ASTM D1238 Density 1.99 9/cm³ ISO 1183 Water Absorption, (23°C/saturated) 0.35 % 150 62-1 Moisture Absorption, (23°C/s Cy StRH) 150 % 150 62-1 Melt Volume Rate, MWR at 300°C/1.2 kg 16 cm/10 min 150 1133 BLECTRICAL. ⁽¹⁾ W/mm IEC 60243-1 ELECTRICAL (1) W/mm IEC 60243-1 Relative Permittivity, 1 MHz 2.7 4 IEC 60250 Polispation Factor, 50/60 Hz 0.004 2 IEC 60250 Obssipation Factor, 1 MHz 0.01 2 IEC 60250 Comparative Tracking Index 175 2 IEC 6012 Relative Permittivity, 50/60 Hz 2.7 2 IEC 6012 Drying Time 2 2 2 IEC 6012 Drying Time (Lumulative) 3 4 Hrs IEC 4012 Melt Temperature 295-315 C IEC 4012 IEC 4012 Rear Zone 1 Temperature 290-301 <th>Mold Shrinkage, flow, 3.2 mm (2)</th> <td>0.4 - 0.8</td> <td>%</td> <td>SABIC method</td>	Mold Shrinkage, flow, 3.2 mm (2)	0.4 - 0.8	%	SABIC method
Density 1.19 g/cm³ ISO 1183 Water Absorption (23°C/saturated) 0.35 % ISO 62-1 Melt Volume Rate, MVR at 300°C/1.2 kg 0.15 cm³/10 min ISO 62- Melt Volume Rate, MVR at 300°C/1.2 kg 16 cm³/10 min ISO 1133 ELECTRICAL II W//m IEC 60243-1 IEC 60243-1 Pielectric Strength, in oil, 3.2 mm 19 W//m IEC 60250 Dissipation Factor, 50/60 Hz 0.0004 - IEC 60250 Dissipation Factor, 1 MHz 0.01 - IEC 60250 Comparative Tracking Index 7.75 V IEC 60250 Comparative Tracking Index 2.7 V IEC 60250 INJECTION MOLDING ⁽¹⁾ 2.7 V IEC 60250 Polying Temperature 2.0 C IEC 60250 Drying Time (Cumulative) 48 Hrs IEC 60250 Maximum Moisture Content 2.9 3.1 C IEC 60250 Nozzle Temperature 29.5 - 315 C IEC 60250 Rear Zone 1 Tempera	Mold Shrinkage, xflow, 3.2 mm (2)	0.4 - 0.8	%	SABIC method
Water Absorption (23°C / 50% RH) 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 ELECTRICAL. (1) ELECTRICAL (1) Pole circ is Strength, in oil, 3.2 mm 19 K// mm IEC 60243-1 Relative Permittivity, 1 MHz 0.0004 - IEC 60250 Dissipation Factor, 50/60 Hz 0.0004 - IEC 60250 Comparative Tracking Index 175 V IEC 60250 Relative Permittivity, 50/60 Hz 120 ° C Relative Permittivity, 50/60 Hz 120 ° C Toling Time (Cumulative) 48 Hrs Drying Time (Cumulative) 48 Hrs Melt Temperature 295-315 °C Nozzle Temperature 290-310 °C Front - Zone 3 Temperature 295-315 °C Moid Temperature 200-25 C Moid Temperature	Melt Flow Rate, 300°C/1.2 kgf	17	g/10 min	ASTM D1238
Moisture Absorption (23°C / 50% RH) 0.15 % ISO 62 Meit Volume Rate, MVR at 300°C / 1.2 kg 16 cm²/10 min ISO 1133 ELECTRICAL ⁽¹⁾ W/mm IEC 60243-1 Dielectric Strength, in oil, 3.2 mm 19 W/mm IEC 60250 Relative Permittivity, 1 MHz 2.7 - IEC 60250 Dissipation Factor, 50/60 Hz 0.01 - IEC 60250 Comparative Tracking Index 2.7 y IEC 60250 Relative Permittivity, 50/60 Hz 2.7 y IEC 60250 Comparative Tracking Index 2.7 y IEC 60250 INJECTION MOLDING ⁽³⁾ Y IEC 60250 IEC 60250 Pring Temperature 120 ° C P Drying Time (Cumulative) 48 Hrs P	Density	1.19	g/cm³	ISO 1183
Melt Volume Rate, MNR at 300°C/1.2 kg 16 cm³/10 min ISO 1133 ELECTRICAL ⁽¹⁾ W/mm IEC 60243-1 Dielectric Strength, in oil, 3.2 mm 19 W/mm IEC 60243-1 Relative Permittivity, 1 MHz 2.7 - - - 60250 Dissipation Factor, 50 f60 Hz 0.004 - - EC 60250 Comparative Tracking Index 17 2 -	Water Absorption, (23°C/saturated)	0.35	%	ISO 62-1
ELECTRICAL (**) Dielectric Strength, in oil, 3.2 mm 19 kV/mm IEC 60243-1 Relative Permittivity, 1 MHz 2.7 - IEC 60250 Dissipation Factor, 50/60 Hz 0.0004 - IEC 60250 Comparative Tracking Index 175 V IEC 60112 Relative Permittivity, 50/60 Hz 2.7 - IEC 60250 INJECTION MOLDING (**) Tyring Temperature 120 **C Drying Time (Cumulative) 48 Hris Melt Temperature 295 - 315 **C Mozzle Temperature 290 - 310 **C Front - Zone 3 Temperature 290 - 310 **C Mozzle Temperature 295 - 315 **C Mozzle Temperature 290 - 300 **C Mozzle Temperature 280 - 305 **C Mold Temperature 270 - 295 **C Mold Temperature 70 - 95 **C Mold Temperature 70 - 95 **C Mold Temperature 70 - 95 **C <th>Moisture Absorption (23°C / 50% RH)</th> <td>0.15</td> <td>%</td> <td>ISO 62</td>	Moisture Absorption (23°C / 50% RH)	0.15	%	ISO 62
Dielectric Strength, in oil, 3.2 mm 19 W/mm IC 60243-1 Relative Permittivity, 1 MHz 2.7 - IC 60250 Dissipation Factor, 50/60 Hz 0.0004 - IC 60250 Comparative Tracking Index 175 V IC 60112 Relative Permittivity, 50/60 Hz 27 - IC 60250 INJECTION MOLDING ⁽⁸⁾ Trying Temperature 120 *C *C Drying Time (Cumulative) 3 - 4 Hrs *C Maximum Moisture Content 295 - 315 *C *C Mozzle Temperature 295 - 315 *C *C Front - Zone 3 Temperature 295 - 315 *C *C Moiddle - Zone 2 Temperature 290 - 300 *C *C Rear - Zone 1 Temperature 290 - 295 *C *C Mold Temperature 0.3 - 0.7 *C *C Back Pressure 0.3 - 0.7 *C *C Back Pressure 40 - 60 *C *C	Melt Volume Rate, MVR at 300°C/1.2 kg	16	cm³/10 min	ISO 1133
Relative Permittivity, 1 MHz 2.7 IEC 60250 Dissipation Factor, 50/60 Hz 0.0004 - IEC 60250 Dissipation Factor, 1 MHz 0.01 - IEC 60250 Comparative Tracking Index 175 V IEC 60112 Relative Permittivity, 50/60 Hz 2.7 - IEC 60250 INJECTION MOLDING (3) Tyring Temperature Drying Time 3-4 Hrs Instrumental Content 48 Hrs Instrumental Content 48	ELECTRICAL (1)			
Dissipation Factor, 50/60 Hz 0.0004 - IEC 60250 Dissipation Factor, 1 MHz 0.01 - IEC 60250 Comparative Tracking Index 175 V IEC 60112 Relative Permittivity, 50/60 Hz 2.7 - IEC 60250 INJECTION MOLDING (³) - IEC 60250 Drying Temperature 120 °C Drying Time (Cumulative) 48 Hris Maximum Moisture Content 0.02 % Melt Temperature 295-315 °C Nozzle Temperature 295-315 °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 30-07 MPa Screw Speed 40-70 rpm Shot to Cylinder Size 40-60 %	Dielectric Strength, in oil, 3.2 mm	19	kV/mm	IEC 60243-1
Dissipation Factor, 1 MHz 0.01 - IEC 60250 Comparative Tracking Index 175 V IEC 6012 Relative Permittivity, 50/60 Hz 2.7 - - IEC 60250 INJECTION MOLDING ⁽³⁾ - -	Relative Permittivity, 1 MHz	2.7	-	IEC 60250
Comparative Tracking Index 175 V IEC 60112 Relative Permittivity, 50/60 Hz 2.7 - IEC 60250 INJECTION MOLDING ⁽³⁾ Drying Temperature 120 °C - - - C Drying Time (Cumulative) 48 Hrs -	Dissipation Factor, 50/60 Hz	0.0004	-	IEC 60250
Relative Permittivity, 50/60 Hz INJECTION MOLDING (3) Drying Temperature 120 3 - 4 Hrs Drying Time (Cumulative) 48 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 290 - 310 C Rear - Zone 1 Temperature 70 - 95 Mold Temperature 70 - 95 Mold Temperature 80 - 30 - 70 MPa Screw Speed 40 - 70 pm 120 120 120 120 120 120 120 12	Dissipation Factor, 1 MHz	0.01	-	IEC 60250
INJECTION MOLDING ⁽³⁾ Drying Temperature 120 °C 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 290 - 305 °C Rear - Zone 1 Temperature 270 - 295 °C Mold Temperature 70 - 95 °C Back Pressure 70 - 95 °C Back Pressure 70 - 95 °C Screw Speed 40 - 70	Comparative Tracking Index	175	V	IEC 60112
Drying Temperature 120 ℃ Drying Time 3 - 4 Hrs Drying Time (Cumulative) 48 Hrs Maximum Moisture Content 0.02 % Melt Temperature 295 - 315 ℃ Nozzle Temperature 290 - 310 ℃ Front - Zone 3 Temperature 295 - 315 ℃ Middle - Zone 2 Temperature 280 - 305 ℃ Rear - Zone 1 Temperature 270 - 295 ℃ Mold Temperature 70 - 95 ℃ Back Pressure 0.3 - 0.7 MPa Screw Speed 40 - 70 rpm Shot to Cylinder Size 40 - 60 %	Relative Permittivity, 50/60 Hz	2.7	-	IEC 60250
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 %	INJECTION MOLDING (3)			
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 %	Drying Temperature	120	°C	
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 %	Drying Time	3 – 4	Hrs	
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 %	Drying Time (Cumulative)	48	Hrs	
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 %	Maximum Moisture Content	0.02	%	
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 %	Melt 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 %	Nozzle Temperature	290 – 310	°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 %	Front - Zone 3 Temperature	295 – 315	°C	
Mold Temperature 70 – 95 °C Back Pressure 0.3 – 0.7 MPa Screw Speed 40 – 70 rpm Shot to Cylinder Size 40 – 60 %	Middle - Zone 2 Temperature	280 – 305	°C	
Back Pressure 0.3 – 0.7 MPa Screw Speed 40 – 70 rpm Shot to Cylinder Size 40 – 60 %	Rear - Zone 1 Temperature	270 – 295	°C	
Screw Speed 40 – 70 rpm Shot to Cylinder Size 40 – 60 %	Mold Temperature	70 – 95	°C	
Shot to Cylinder Size 40 – 60 %	Back Pressure	0.3 - 0.7	MPa	
·	Screw Speed	40 – 70	rpm	
Vent Depth 0.025 – 0.076 mm	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

DISCLAIMER

Any sale by SABIC, its subsidiaries and affiliates (each a "seller"), is made exclusively under seller's standard conditions of sale (available upon request) unless agreed otherwise in writing and signed on behalf of the seller. While the information contained herein is given in good faith, SELLER MAKES NO WARRANTY, EXPRESS OR IMPLIED, INCLUDING MERCHANTABILITY AND NONINFRINGEMENT OF INTELLECTUAL PROPERTY, NOR ASSUMES ANY LIABILITY, DIRECT OR INDIRECT, WITH RESPECT TO THE PERFORMANCE, SUITABILITY OR FITNESS FOR INTENDED USE OR PURPOSE OF THESE PRODUCTS IN ANY APPLICATION. Each customer must determine the suitability of seller materials for the customer's particular use through appropriate testing and analysis. No statement by seller concerning a possible use of any product, service or design is intended, or should be construed, to grant any license under any patent or other intellectual property right.