

LEXAN™ COPOLYMER 143X

REGION ASIA

DESCRIPTION

Improved flow PC with excellent processability and mold release.

TYPICAL PROPERTY VALUES

Revision 20190102

| PROPERTIES | TYPICAL VALUES | UNITS | TEST METHODS |
|--|----------------|-------------------|--------------|
| MECHANICAL | | | |
| Tensile Stress, yld, Type I, 50 mm/min | 60 | MPa | ASTM D 638 |
| Tensile Stress, brk, Type I, 50 mm/min | 60 | MPa | ASTM D 638 |
| Tensile Strain, yld, Type I, 50 mm/min | 6 | % | ASTM D 638 |
| Tensile Strain, brk, Type I, 50 mm/min | 117 | % | ASTM D 638 |
| Tensile Modulus, 50 mm/min | 2320 | MPa | ASTM D 638 |
| Flexural Stress, yld, 1.3 mm/min, 50 mm span | 86 | MPa | ASTM D 790 |
| Flexural Modulus, 1.3 mm/min, 50 mm span | 2360 | MPa | ASTM D 790 |
| Tensile Stress, yield, 50 mm/min | 60 | MPa | ISO 527 |
| Tensile Stress, break, 50 mm/min | 59 | MPa | ISO 527 |
| Tensile Strain, yield, 50 mm/min | 6 | % | ISO 527 |
| Tensile Strain, break, 50 mm/min | 115 | % | ISO 527 |
| Tensile Modulus, 1 mm/min | 2450 | MPa | ISO 527 |
| Flexural Stress, yield, 2 mm/min | 90 | MPa | ISO 178 |
| Flexural Modulus, 2 mm/min | 2310 | MPa | ISO 178 |
| IMPACT | | | |
| Izod Impact, notched, 23°C | 828 | J/m | ASTM D 256 |
| Izod Impact, notched, -30°C | 242 | J/m | ASTM D 256 |
| Instrumented Impact Total Energy, 23°C | 72 | J | ASTM D 3763 |
| Izod Impact, unnotched 80*10*3 +23°C | NB | kJ/m ² | ISO 180/1U |
| Izod Impact, unnotched 80*10*3 -30°C | NB | kJ/m ² | ISO 180/1U |
| Izod Impact, notched 80*10*3 +23°C | 65 | kJ/m ² | ISO 180/1A |
| Izod Impact, notched 80*10*3 -30°C | 11 | kJ/m ² | ISO 180/1A |
| Charpy 23°C, V-notch Edgew 80*10*3 sp=62mm | 65 | kJ/m ² | ISO 179/1eA |
| Charpy -30°C, V-notch Edgew 80*10*3 sp=62mm | 12 | kJ/m ² | ISO 179/1eA |
| Charpy 23°C, Unnotch Edgew 80*10*3 sp=62mm | NB | kJ/m ² | ISO 179/1eU |
| Charpy -30°C, Unnotch Edgew 80*10*3 sp=62mm | NB | kJ/m ² | ISO 179/1eU |
| THERMAL | | | |
| Vicat Softening Temp, Rate B/50 | 141 | °C | ASTM D 1525 |
| HDT, 1.82 MPa, 3.2mm, unannealed | 128 | °C | ASTM D 648 |
| HDT, 1.82 MPa, 6.4 mm, unannealed | 129 | °C | ASTM D 648 |
| CTE, -40°C to 40°C, flow | 6.E-05 | 1/°C | ASTM E 831 |
| CTE, -40°C to 40°C, xflow | 6.E-05 | 1/°C | ASTM E 831 |
| CTE, -40°C to 40°C, flow | 6.E-05 | 1/°C | ISO 11359-2 |
| CTE, -40°C to 40°C, xflow | 6.E-05 | 1/°C | ISO 11359-2 |
| Vicat Softening Temp, Rate B/50 | 141 | °C | ISO 306 |

| PROPERTIES | TYPICAL VALUES | UNITS | TEST METHODS |
|---------------------------------------|----------------|-------------------|--------------|
| Vicat Softening Temp, Rate B/120 | 143 | °C | ISO 306 |
| HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm | 122 | °C | ISO 75/Af |
| PHYSICAL | | | |
| Specific Gravity | 1.2 | - | ASTM D 792 |
| Mold Shrinkage, flow, 3.2 mm | 0.4 – 0.8 | % | SABIC method |
| Melt Flow Rate, 300°C/1.2 kgf | 12 | g/10 min | ASTM D 1238 |
| Density | 1.2 | g/cm ³ | ISO 1183 |
| Water Absorption, (23°C/sat) | 0.35 | % | ISO 62 |
| Moisture Absorption (23°C / 50% RH) | 0.15 | % | ISO 62 |
| INJECTION MOLDING | | | |
| 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 | 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 | |

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