

# LEXAN<sup>TM</sup> COPOLYMER EXL1413T

REGION ASIA

## DESCRIPTION

LEXAN EXL1413T polycarbonate (PC) siloxane copolymer resin is a transparent injection molding grade. This resin offers excellent low temperature (-30 °C) ductility in combination with medium flow characteristics and excellent processability with opportunities for shorter IM cycle times compared to standard PC. LEXAN EXL1413T resin is a general purpose product available in transparent and opaque colors and is an excellent candidate for a broad range of applications.

## TYPICAL PROPERTY VALUES

Revision 20191031

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
<b>MECHANICAL</b>			
Tensile Stress, yld, Type I, 50 mm/min	58	MPa	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	64	MPa	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	5.8	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	131.4	%	ASTM D 638
Tensile Modulus, 50 mm/min	2210	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	94	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	2210	MPa	ASTM D 790
Tensile Stress, yield, 50 mm/min	57	MPa	ISO 527
Tensile Stress, break, 50 mm/min	61	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	5.5	%	ISO 527
Tensile Strain, break, 50 mm/min	124.9	%	ISO 527
Tensile Modulus, 1 mm/min	2350	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	90	MPa	ISO 178
Flexural Modulus, 2 mm/min	2150	MPa	ISO 178
Hardness, Rockwell L	89	-	ISO 2039-2
<b>IMPACT</b>			
Izod Impact, notched, 23°C	890	J/m	ASTM D 256
Izod Impact, notched, -30°C	795	J/m	ASTM D 256
Instrumented Impact Total Energy, 23°C	82	J	ASTM D 3763
Instrumented Impact Total Energy, -30°C	85	J	ASTM D 3763
Izod Impact, unnotched 80*10*3 +23°C	NB	kJ/m <sup>2</sup>	ISO 180/1U
Izod Impact, unnotched 80*10*3 -30°C	NB	kJ/m <sup>2</sup>	ISO 180/1U
Izod Impact, notched 80*10*3 +23°C	65	kJ/m <sup>2</sup>	ISO 180/1A
Izod Impact, notched 80*10*3 -30°C	55	kJ/m <sup>2</sup>	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*3 sp=62mm	70	kJ/m <sup>2</sup>	ISO 179/1eA
Charpy -30°C, V-notch Edgew 80*10*3 sp=62mm	60	kJ/m <sup>2</sup>	ISO 179/1eA
Charpy 23°C, Unnotch Edgew 80*10*3 sp=62mm	NB	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy -30°C, Unnotch Edgew 80*10*3 sp=62mm	NB	kJ/m <sup>2</sup>	ISO 179/1eU
<b>THERMAL</b>			
Vicat Softening Temp, Rate A/50	141	°C	ASTM D 1525
HDT, 1.82 MPa, 3.2mm, unannealed	124	°C	ASTM D 648
CTE, -40°C to 95°C, flow	7.15E-05	1/°C	ASTM E 831

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
CTE, -40°C to 95°C, xflow	7.93E-05	1/°C	ASTM E 831
CTE, 23°C to 80°C, flow	7.15E-05	1/°C	ISO 11359-2
CTE, 23°C to 80°C, xflow	7.93E-05	1/°C	ISO 11359-2
Ball Pressure Test, 125°C +/- 2°C	pass	-	IEC 60695-10-2
Vicat Softening Temp, Rate B/50	141	°C	ISO 306
Vicat Softening Temp, Rate B/120	142	°C	ISO 306
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	118	°C	ISO 75/Af
Relative Temp Index, Elec <sup>(1)</sup>	130	°C	UL 746B
Relative Temp Index, Mech w/impact <sup>(1)</sup>	120	°C	UL 746B
Relative Temp Index, Mech w/o impact <sup>(1)</sup>	130	°C	UL 746B
<b>PHYSICAL</b>			
Specific Gravity	1.19	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	0.4 – 0.8	%	SABIC method
Mold Shrinkage, xflow, 3.2 mm	0.4 – 0.8	%	SABIC method
Melt Flow Rate, 300°C/1.2 kgf	10	g/10 min	ASTM D 1238
Density	1.19	g/cm <sup>3</sup>	ISO 1183
Water Absorption, (23°C/sat)	0.12	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.09	%	ISO 62
Melt Volume Rate, MVR at 300°C/1.2 kg	9	cm <sup>3</sup> /10 min	ISO 1133
<b>OPTICAL</b>			
Light Transmission, 2.54 mm	82	%	ASTM D 1003
Haze, 2.54 mm	3	%	ASTM D 1003
<b>ELECTRICAL</b>			
Volume Resistivity	>1.E+15	Ohm-cm	ASTM D 257
Surface Resistivity	>1.E+15	Ohm	ASTM D 257
Comparative Tracking Index (UL) {PLC}	3	PLC Code	UL 746A
Hot-Wire Ignition (HWI), PLC 2	≥3	mm	UL 746A
Hot-Wire Ignition (HWI), PLC 3	≥1.5	mm	UL 746A
High Amp Arc Ignition (HAI), PLC 1	≥1.5	mm	UL 746A
<b>FLAME CHARACTERISTICS <sup>(1)</sup></b>			
UL Yellow Card Link	<a href="#">E207780-633035</a>	-	-
UL Recognized, 94HB Flame Class Rating	≥0.8	mm	UL 94
UL Recognized, 94V-2 Flame Class Rating	≥2.5	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, 1.5 mm	825	°C	IEC 60695-2-13
Glow Wire Ignitability Temperature, 1.0 mm	825	°C	IEC 60695-2-13
Glow Wire Ignitability Temperature, 0.8 mm	825	°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	825	°C	IEC 60695-2-12
Glow Wire Flammability Index, 1.0 mm	825	°C	IEC 60695-2-12
Glow Wire Flammability Index, 2.5 mm	825	°C	IEC 60695-2-12
Glow Wire Flammability Index, 0.8 mm	825	°C	IEC 60695-2-12
<b>INJECTION MOLDING</b>			
Drying Temperature	120	°C	

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
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	

(1) 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.

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