

LEXAN™ RESIN EX1632T

REGION EUROPE

DESCRIPTION

LEXAN EX1632T polycarbonate resin is designed for use in multi-wall sheet or profile extrusion applications. It contains branched polycarbonate resin, release, and UV stabilizer. It is available in a limited number of colors.

TYPICAL PROPERTY VALUES

Revision 20180905

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yield, 50 mm/min	65	MPa	ISO 527
Tensile Stress, break, 50 mm/min	70	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	7	%	ISO 527
Tensile Strain, break, 50 mm/min	>70	%	ISO 527
Tensile Modulus, 1 mm/min	2350	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	95	MPa	ISO 178
Flexural Modulus, 2 mm/min	2300	MPa	ISO 178
IMPACT			
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	75	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*3 -30°C	55	kJ/m ²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*3 sp=62mm	70	kJ/m ²	ISO 179/1eA
Charpy -30°C, V-notch Edgew 80*10*3 sp=62mm	50	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			
Thermal Conductivity	0.2	W/m·°C	ISO 8302
CTE, -40°C to 40°C, xflow	7.E-05	1/°C	ISO 11359-2
CTE, 23°C to 80°C, flow	7.E-05	1/°C	ISO 11359-2
Ball Pressure Test, 125°C +/- 2°C	PASSES	-	IEC 60695-10-2
Vicat Softening Temp, Rate B/50	149	°C	ISO 306
Vicat Softening Temp, Rate B/120	150	°C	ISO 306
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	130	°C	ISO 75/Af
PHYSICAL			
Mold Shrinkage, flow, 3.2 mm	0.5 – 0.7	%	SABIC method
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
Melt Volume Rate, MVR at 300°C/1.2 kg	6	cm ³ /10 min	ISO 1133
Melt Volume Rate, MVR at 300°C/2.16 kg	11	cm ³ /10 min	ISO 1133
FLAME CHARACTERISTICS			
UL Recognized, 94HB Flame Class Rating	0.8	mm	UL 94
UL Recognized, 94HB Flame Class Rating 2nd value	3	mm	UL 94

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Glow Wire Flammability Index 850°C, passes at	1	mm	IEC 60695-2-12
MULTIWALL SHEET EXTRUSION			
Drying Temperature	120	°C	
Drying Time	2 – 4	hrs	
Barrel - Zone 1 Temperature	240 – 270	°C	
Barrel - Zone 2 Temperature	240 – 270	°C	
Barrel - Zone 3 Temperature	240 – 270	°C	
Hopper Temperature	100 – 120	°C	
Adapter Temperature	220 – 260	°C	
Die Temperature	220 – 280	°C	
Melt Temperature	220 – 280	°C	
Calibrator Temperature	50 – 100	°C	

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