

LEXAN™ COPOLYMER EXL8454

REGION EUROPE

DESCRIPTION

LEXAN EXL8454 is a PC/siloxane copolymer resin with medium flow, excellent low temperature impact and 50% post consumer recycle content. Limited availability and restricted color only. Higher color variability and contamination risks including black specs needs to be considered before approval for use in applications.

TYPICAL PROPERTY VALUES

Revision 20170913

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	57	MPa	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	55	MPa	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	6	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	100	%	ASTM D 638
Tensile Modulus, 5 mm/min	2200	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	90	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	2100	MPa	ASTM D 790
IMPACT			
Izod Impact, notched, 23°C	800	J/m	ASTM D 256
Izod Impact, notched, -30°C	700	J/m	ASTM D 256
Izod Impact, notched, -40°C	650	J/m	ASTM D 256
Instrumented Impact Total Energy, 23°C	70	J	ASTM D 3763
Charpy 23°C, V-notch Edgew 80*10*3 sp=62mm	67	kJ/m ²	ISO 179/1eA
Charpy -30°C, V-notch Edgew 80*10*3 sp=62mm	58	kJ/m ²	ISO 179/1eA
Charpy -40°C, V-notch Edgew 80*10*3 sp=62mm	54	kJ/m ²	ISO 179/1eA
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	65	kJ/m ²	ISO 179/1eA
Charpy -30°C, V-notch Edgew 80*10*4 sp=62mm	27	kJ/m ²	ISO 179/1eA
THERMAL			
Vicat Softening Temp, Rate B/50	145	°C	ASTM D 1525
HDT, 1.82 MPa, 3.2mm, unannealed	123	°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
PHYSICAL			
Specific Gravity	1.2	-	ASTM D 792

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Mold Shrinkage, flow, 3.2 mm (5)	0.4 – 0.8	%	SABIC method
Melt Flow Rate, 300°C/1.2 kgf	10	g/10 min	ASTM D 1238
Water Absorption, 23°C/24hrs	0.15	%	SABIC method
ELECTRICAL			
Volume Resistivity	>1.E+15	Ohm-cm	ASTM D 257
Surface Resistivity	>1.E+15	Ohm	ASTM D 257
Dielectric Strength, in oil, 0.8 mm	15	kV/mm	ASTM D 149
Relative Permittivity, 1 MHz	3	-	ASTM D 150
Dissipation Factor, 1 MHz	0.0093	-	ASTM D 150
FLAME CHARACTERISTICS			
UL Recognized, 94HB Flame Class Rating (3)	0.75	mm	UL 94
Glow Wire Flammability Index 850°C, passes at	1	mm	IEC 60695-2-12
Glow Wire Flammability Index 960°C, passes at	3	mm	IEC 60695-2-12
Glow Wire Ignitability Temperature, 1.0 mm	875	°C	IEC 60695-2-13
Glow Wire Ignitability Temperature, 3.0 mm	875	°C	IEC 60695-2-13
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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