

LEXAN™ COPOLYMER MPX1

REGION ASIA

DESCRIPTION

Lexan* MPX1 polycarbonate (PC) siloxane copolymer resin is a UV stabilized injection molding (IM) grade with release properties. This resin offers good low temperature ductility in combination with high flow characteristics and excellent processability with opportunities for shorter IM cycle times compared to standard IM PC resins. Lexan MPX1 resin is a general purpose product available in limited colors and may be an excellent candidate for a broad range of 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	56	MPa	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	4.8	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	90	%	ASTM D 638
Tensile Modulus, 50 mm/min	2100	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	2100	MPa	ASTM D 790
IMPACT			
Izod Impact, notched, 23°C	750	J/m	ASTM D 256
Izod Impact, notched, -30°C	250	J/m	ASTM D 256
Instrumented Impact Total Energy, 23°C	70	J	ASTM D 3763
THERMAL			
HDT, 1.82 MPa, 3.2mm, unannealed	116	°C	ASTM D 648
Ball Pressure Test, 125°C +/- 2°C	pass	-	IEC 60695-10-2
Vicat Softening Temp, Rate B/120	139	°C	ISO 306
PHYSICAL			
Specific Gravity	1.18	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm (5)	0.4 – 0.8	%	SABIC method
Mold Shrinkage, xflow, 3.2 mm (5)	0.4 – 0.8	%	SABIC method
Melt Flow Rate, 300°C/1.2 kgf	18	g/10 min	ASTM D 1238
Density	1.19	g/cm ³	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	17	cm ³ /10 min	ISO 1133
FLAME CHARACTERISTICS			

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
UL Recognized, 94HB Flame Class Rating 2nd value (3)	0.5	mm	UL 94
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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