

LEXAN™ EXL9330 resin

Polycarbonate
SABIC Innovative Plastics

Message:
Opaque PC-Siloxane copolymer with excellent processability. Non-chlorinated, non-brominated flame retardant product in most colors. UV-stabilized. UL rated f1/V-0/5VA.

General Information			
Additive	UV stabilizer		
	Flame retardancy		
Features	Chlorine Free		
	Copolymer		
	Workability, good		
	Bromine-free		
	Flame retardancy		
RoHS Compliance	RoHS compliance		
Appearance	Opacity		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
--	1.18	g/cm ³	ASTM D792
--	1.19	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	10	g/10 min	ASTM D1238
Melt Volume-Flow Rate (MVR) (300°C/1.2 kg)	9.00	cm ³ /10min	ISO 1133
Molding Shrinkage			Internal method
Flow: 3.20mm	0.40 - 0.80	%	Internal method
Transverse flow: 3.20mm	0.40 - 0.80	%	Internal method
Water Absorption			ISO 62
Saturated, 23°C	0.35	%	ISO 62
Equilibrium, 23°C, 50% RH	0.15	%	ISO 62
Outdoor Suitability	f1		UL 746C
Hardness	Nominal Value	Unit	Test Method
Ball Indentation Hardness (H 358/30)	90.0	MPa	ISO 2039-1
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	2100	MPa	ASTM D638
--	2100	MPa	ISO 527-2/1
Tensile Strength			

Yield ²	58.6	MPa	ASTM D638
Yield	55.0	MPa	ISO 527-2/50
Fracture ³	61.4	MPa	ASTM D638
Fracture	60.0	MPa	ISO 527-2/50
Tensile Elongation			
Yield ⁴	6.0	%	ASTM D638
Yield	6.0	%	ISO 527-2/50
Fracture ⁵	130	%	ASTM D638
Fracture	130	%	ISO 527-2/50
Flexural Modulus			
50.0mm span ⁶	2070	MPa	ASTM D790
-- ⁷	2200	MPa	ISO 178
Flexural Stress			
--	85.0	MPa	ISO 178
Yield, 50.0mm span ⁸	88.9	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ⁹			ISO 179/1eA
-30°C	60	kJ/m ²	ISO 179/1eA
23°C	75	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength ¹⁰			ISO 179/1eU
-30°C	No Break		ISO 179/1eU
23°C	No Break		ISO 179/1eU
Notched Izod Impact			
-50°C	590	J/m	ASTM D256
-30°C	680	J/m	ASTM D256
23°C	800	J/m	ASTM D256
23°C, 6.40 mm	640	J/m	ASTM D256
-30°C ¹¹	55	kJ/m ²	ISO 180/1A
-30°C ¹²	65	kJ/m ²	ISO 180/4A
23°C ¹³	70	kJ/m ²	ISO 180/1A
23°C ¹⁴	80	kJ/m ²	ISO 180/4A
Unnotched Izod Impact			
23°C ¹⁵	1100	J/m	Internal method
-30°C ¹⁶	No Break		ISO 180/1U
23°C ¹⁷	No Break		ISO 180/1U
Instrumented Dart Impact (23°C, Total Energy)	52.9	J	ASTM D3763
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, unannealed, 3.20mm	134	°C	ASTM D648
0.45 MPa, unannealed, 100 mm span ¹⁸	135	°C	ISO 75-2/Be
1.8 MPa, unannealed, 3.20mm	121	°C	ASTM D648

1.8 MPa, unannealed, 6.40mm	124	°C	ASTM D648
1.8 MPa, unannealed, 100 mm span ¹⁹	124	°C	ISO 75-2/Ae
Vicat Softening Temperature			
--	142	°C	ASTM D1525, ISO 306/B120 13 ²⁰
--	140	°C	ISO 306/B50
Ball Pressure Test (125°C)	Pass		IEC 60695-10-2
Linear thermal expansion coefficient			
Flow: -40 to 40°C	6.7E-5	cm/cm/°C	ASTM E831
Flow: 23 to 80°C	7.2E-5	cm/cm/°C	ISO 11359-2
Lateral: -40 to 40°C	6.7E-5	cm/cm/°C	ASTM E831
Lateral: 23 to 80°C	7.7E-5	cm/cm/°C	ISO 11359-2
RTI Elec	125	°C	UL 746
RTI Imp	115	°C	UL 746
RTI	120	°C	UL 746
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	> 1.0E+15	ohms	IEC 60093
Volume Resistivity	> 1.0E+15	ohms·cm	IEC 60093
Dielectric Strength			
3.20 mm, in Oil	17	kV/mm	ASTM D149
3.20mm, in oil	16	kV/mm	IEC 60243-1
Dielectric Constant			
50 Hz	2.95		ASTM D150
60 Hz	2.95		ASTM D150
1 MHz	2.90		ASTM D150
50 Hz	2.60		IEC 60250
60 Hz	2.60		IEC 60250
1 MHz	2.70		IEC 60250
Dissipation Factor			
50 Hz	2.4E-3		ASTM D150
60 Hz	2.4E-3		ASTM D150
1 MHz	8.5E-3		ASTM D150, IEC 60250
50 Hz	1.0E-3		IEC 60250
60 Hz	1.0E-3		IEC 60250
Comparative Tracking Index (CTI)	PLC 3		UL 746
Comparative Tracking Index	225	V	IEC 60112
High Amp Arc Ignition (HAI)	PLC 0		UL 746
Hot-wire Ignition (HWI)	PLC 1		UL 746
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
1.50 mm	V-0		UL 94
3.00 mm	5VA		UL 94

Glow Wire Flammability Index (1.00 mm)	960	°C	IEC 60695-2-12
Glow Wire Ignition Temperature (1.00 mm)	825	°C	IEC 60695-2-13
Oxygen Index	35	%	ISO 4589-2
Injection	Nominal Value	Unit	
Drying Temperature	121	°C	
Drying Time	3.0 - 4.0	hr	
Drying Time, Maximum	48	hr	
Suggested Max Moisture	0.020	%	
Suggested Shot Size	40 - 60	%	
Rear Temperature	217 - 293	°C	
Middle Temperature	282 - 304	°C	
Front Temperature	293 - 316	°C	
Nozzle Temperature	288 - 310	°C	
Processing (Melt) Temp	293 - 316	°C	
Mold Temperature	71.0 - 93.0	°C	
Back Pressure	0.345 - 0.689	MPa	
Screw Speed	40 - 70	rpm	
Vent Depth	0.025 - 0.076	mm	
NOTE			
1.	50 mm/min		
2.	Type 1, 50mm/min		
3.	Type 1, 50mm/min		
4.	Type 1, 50mm/min		
5.	Type 1, 50mm/min		
6.	1.3 mm/min		
7.	2.0 mm/min		
8.	1.3 mm/min		
9.	80*10*3 sp=62mm		
10.	80*10*3 sp=62mm		
11.	80*10*3		
12.	63.5*12.7*3.2		
13.	80*10*3		
14.	63.5*12.7*3.2		
15.	Double-Gated		
16.	80*10*3		
17.	80*10*3		
18.	120*10*4 mm		
19.	120*10*4 mm		
20.	标准 B (120°C/h), 载荷2 (50N)		

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