

LEXAN™ EXL1494T resin

Polycarbonate
SABIC Innovative Plastics

Message:

LEXAN EXL1494T polycarbonate (PC) siloxane copolymer resin is an injection molding grade with FDA and EU food contact compliance. This resin offers extreme low temperature (-40 C) ductility in combination with medium flow characteristics, improved release and excellent processability with opportunities for shorter IM cycle times compared to standard PC. LEXAN EXL1494T resin is available in transparent and opaque colors and is an excellent candidate for a broad range of food contact applications.

General Information			
Features	Copolymer		
	Workability, good		
	Fast molding cycle		
	Medium liquidity		
	Compliance of Food Exposure		
	Good demoulding performance		
	ductility		
Uses	Non-specific food applications		
Agency Ratings	FDA Food Exposure, Not Rated		
	European food contact, not rated		
Appearance	Opacity		
	Clear/transparent		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.19	g/cm³	ASTM D792, 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)	9.50	cm³/10min	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	0.12	%	ISO 62
Equilibrium, 23°C, 50% RH	0.093	%	ISO 62
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (L-Scale)	87		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			

-- ¹	2190	MPa	ASTM D638
--	2310	MPa	ISO 527-2/1
Tensile Strength			
Yield ²	57.6	MPa	ASTM D638
Yield	56.8	MPa	ISO 527-2/50
Fracture ³	59.1	MPa	ASTM D638
Fracture	55.3	MPa	ISO 527-2/50
Tensile Elongation			
Yield ⁴	5.6	%	ASTM D638
Yield	5.4	%	ISO 527-2/50
Fracture ⁵	120	%	ASTM D638
Fracture	110	%	ISO 527-2/50
Flexural Modulus			
50.0mm span ⁶	2180	MPa	ASTM D790
-- ⁷	2120	MPa	ISO 178
Flexural Stress			
--	88.6	MPa	ISO 178
Yield, 50.0mm span ⁸	92.0	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	70	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			
-30°C	710	J/m	ASTM D256
23°C	820	J/m	ASTM D256
-30°C ¹¹	55	kJ/m ²	ISO 180/1A
23°C ¹²	65	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength ¹³			ISO 180/1U
-30°C	No Break		ISO 180/1U
23°C	No Break		ISO 180/1U
Instrumented Dart Impact			ASTM D3763
-30°C, Total Energy	77.4	J	ASTM D3763
23°C, Total Energy	75.5	J	ASTM D3763
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
1.8 MPa, unannealed, 3.20mm	121	°C	ASTM D648
1.8 MPa, unannealed, 64.0mm span ¹⁴	116	°C	ISO 75-2/Af
Vicat Softening Temperature			

--	139	°C	ASTM D1525, ISO 306/B120 11 ¹⁵
--	138	°C	ISO 306/B50
Ball Pressure Test (125°C)	Pass		IEC 60695-10-2
Linear thermal expansion coefficient			
Flow: -40 to 95°C	6.7E-5	cm/cm/°C	ASTM E831
Flow: 23 to 80°C	6.7E-5	cm/cm/°C	ISO 11359-2
Lateral: -40 to 95°C	8.0E-5	cm/cm/°C	ASTM E831
Lateral: 23 to 80°C	8.0E-5	cm/cm/°C	ISO 11359-2
RTI Elec	130	°C	UL 746
RTI	130	°C	UL 746
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	> 1.0E+15	ohms	ASTM D257
Volume Resistivity	> 1.0E+15	ohms · cm	ASTM D257
Flammability	Nominal Value	Unit	Test Method
Flame Rating (3.00 mm)	V-2		UL 94
Glow Wire Flammability Index (3.00 mm)	960	°C	IEC 60695-2-12
Glow Wire Ignition Temperature			IEC 60695-2-13
0.800 mm	850	°C	IEC 60695-2-13
3.00 mm	850	°C	IEC 60695-2-13
Optical	Nominal Value	Unit	Test Method
Transmittance (2540 µm)	82.0	%	ASTM D1003
Haze (2540 µm)	3.0	%	ASTM D1003
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.	80*10*3
13.	80*10*3
14.	80*10*4 mm
15.	速率 A (50°C/h), 载荷2 (50N)

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