

LEXAN™ EX1632T resin

Polycarbonate

SABIC Innovative Plastics Europe

Message:

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.

General Information	
UL YellowCard	E121562-100989271
Additive	demoulding UV stabilizer
Features	Branched polymer structure
Appearance	Available colors
Processing Method	Extrusion Sheet extrusion molding

Physical	Nominal Value	Unit	Test Method
Density	1.19	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	6.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm)	0.50 - 0.70	%	Internal method

Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ¹	2220	MPa	ASTM D638
Tensile Strength ²			ASTM D638
Yield	61.0	MPa	ASTM D638
Fracture	57.0	MPa	ASTM D638
Tensile Elongation ³			ASTM D638
Yield	6.3	%	ASTM D638
Fracture	99	%	ASTM D638
Flexural Modulus ⁴ (50.0 mm Span)	2370	MPa	ASTM D790
Flexural Strength ⁵ (Yield, 50.0 mm Span)	99.0	MPa	ASTM D790

Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-30°C	150	J/m	ASTM D256
23°C	800	J/m	ASTM D256
Instrumented Dart Impact (23°C, Total Energy)	74.3	J	ASTM D3763

Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, unannealed, 3.20mm	140	°C	ASTM D648
1.8 MPa, unannealed, 3.20mm	130	°C	ASTM D648

Vicat Softening Temperature			
--	145	°C	ASTM D1525 ⁶
--	147	°C	ISO 306/B120
Linear thermal expansion coefficient			ASTM E831
Flow: -40 to 40°C	6.5E-5	cm/cm/°C	ASTM E831
Lateral: -40 to 40°C	6.6E-5	cm/cm/°C	ASTM E831
Flammability	Nominal Value		Test Method
Flame Rating (0.800 mm, Testing by SABIC)	HB		UL 94
Extrusion instructions			

Multiwall Sheet Extrusion Parameters:
 Adapter Temperature: 220 - 260 C
 Barrel - Zone 1 Temperature: 240 - 270 C
 Barrel - Zone 2 Temperature: 240 - 270 C
 Barrel - Zone 3 Temperature: 240 - 270 C
 Calibrator Temperature: 50 - 100 C
 Die Temperature: 220 - 280 C
 Drying Temperature: 120 C
 Drying Time: 2 - 4 hrs
 Hopper Temperature: 100 - 120 C
 Melt Temperature: 220 - 280 C

NOTE	
1.	5.0 mm/min
2.	Type 1, 50mm/min
3.	Type 1, 50mm/min
4.	1.3 mm/min
5.	1.3 mm/min
6.	标准 B (120°C/h), 载荷2 (50N)

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