

LEXAN™ 135 resin

Polycarbonate

SABIC Innovative Plastics Europe

Message:

LEXAN 135RESIN_111 is the highest viscosity linear polycarbonate resin powder type. Suitable for extrusion processes. The product datasheet shows typical values which can be obtained when the polycarbonate powder is converted into extruded products.

General Information			
Features	High Viscosity		
	Linear Polymer Structure		
RoHS Compliance	RoHS Compliant		
Forms	Powder		
Processing Method	Profile Extrusion		
Physical	Nominal Value	Unit	Test Method
Density	1.20	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (300°C/1.2 kg)	3.00	cm ³ /10min	ISO 1133
Water Absorption			ISO 62
Saturation, 23°C	0.35	%	
Equilibrium, 23°C, 50% RH	0.15	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2350	MPa	ISO 527-2/1
Tensile Stress			ISO 527-2/50
Yield	63.0	MPa	
Break	70.0	MPa	
Tensile Strain			ISO 527-2/50
Yield	7.0	%	
Break	120	%	
Flexural Modulus ¹	2300	MPa	ISO 178
Flexural Stress	90.0	MPa	ISO 178
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature ² (1.8 MPa, Unannealed, 100 mm Span)	128	°C	ISO 75-2/Ae
Vicat Softening Temperature			
--	144	°C	ISO 306/B50
--	145	°C	ISO 306/B120
CLTE			ISO 11359-2
Flow : 23 to 80°C	7.0E-5	cm/cm/°C	
Transverse : -40 to 40°C	7.0E-5	cm/cm/°C	
Extrusion	Nominal Value	Unit	

Drying Temperature	120	°C
Drying Time	2.0 to 4.0	hr
Hopper Temperature	40.0 to 60.0	°C
Cylinder Zone 1 Temp.	260 to 280	°C
Cylinder Zone 2 Temp.	260 to 280	°C
Cylinder Zone 3 Temp.	260 to 280	°C
Cylinder Zone 4 Temp.	260 to 280	°C
Adapter Temperature	260 to 280	°C
Melt Temperature	270 to 280	°C
Die Temperature	250 to 260	°C
Calibration Temp, First	70.0 to 90.0	°C

NOTE

1. 2.0 mm/min
2. 120*10*4 mm

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