



LEXAN™ Resin EX1332T

Europe-Africa-Middle East: COMMERCIAL

LEXAN® EX1332T polycarbonate resin, MVR (300C/1.2kg) 2 cm³/10min, high viscosity, branched, extrusion, mold release, UV stabilized, transparent, translucent and opaque colors. Multiwall sheet, Profiles.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yield, 50 mm/min	65	MPa	ISO 527
Tensile Stress, break, 50 mm/min	70	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	7	%	ISO 527
Tensile Strain, break, 50 mm/min	>70	%	ISO 527
Tensile Modulus, 1 mm/min	2350	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	95	MPa	ISO 178
Flexural Modulus, 2 mm/min	2300	MPa	ISO 178
IMPACT			
Izod Impact, unnotched 80*10*3 +23°C	NB	kJ/m ²	ISO 180/1U
Izod Impact, unnotched 80*10*3 -30°C	NB	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*3 +23°C	75	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*3 -30°C	55	kJ/m ²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*3 sp=62mm	70	kJ/m ²	ISO 179/1eA
Charpy -30°C, V-notch Edgew 80*10*3 sp=62mm	50	kJ/m ²	ISO 179/1eA
Charpy 23°C, Unnotch Edgew 80*10*3 sp=62mm	NB	kJ/m ²	ISO 179/1eU
Charpy -30°C, Unnotch Edgew 80*10*3 sp=62mm	NB	kJ/m ²	ISO 179/1eU
THERMAL			
Thermal Conductivity	0.2	W/m-°C	ISO 8302
CTE, 23°C to 80°C, flow	7.E-05	1/°C	ISO 11359-2
Ball Pressure Test, 125°C +/- 2°C	PASSES	-	IEC 60695-10-2
Vicat Softening Temp, Rate B/50	149	°C	ISO 306
Vicat Softening Temp, Rate B/120	150	°C	ISO 306
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	130	°C	ISO 75/Af

(1) Typical values only. Variations within normal tolerances are possible for various colors. All values are measured after at least 48 hours storage at 23°C/50% relative humidity. All properties, except the melt volume and melt flow rates, are measured on injection molded samples. All samples tested under ISO test standards are prepared according to ISO 294.

(2) Only typical data for selection purposes. Not to be used for part or tool design.

(3) This rating is not intended to reflect hazards presented by this or any other material under actual fire conditions.

(4) Internal measurements according to UL standards.

(5) Measurements made from laboratory test coupon. Actual shrinkage may vary outside of range due to differences in processing conditions, equipment, part geometry and tool design. It is recommended that mold shrinkage studies be performed with surrogate or legacy tooling prior to cutting tools for new molded article.

Source GMD, last updated:

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TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
PHYSICAL			
Mold Shrinkage, flow, 3.2 mm (5)	0.5 - 0.7	%	SABIC Method
Density	1.2	g/cm ³	ISO 1183
Water Absorption, (23°C/sat)	0.35	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.15	%	ISO 62
Melt Volume Rate, MVR at 300°C/1.2 kg	3	cm ³ /10 min	ISO 1133
Melt Volume Rate, MVR at 300°C/2.16 kg	5	cm ³ /10 min	ISO 1133
OPTICAL			
Light Transmission, 2.54 mm	88 - 90	%	ASTM D 1003
FLAME CHARACTERISTICS			
Glow Wire Flammability Index 850°C, passes at	1	mm	IEC 60695-2-12

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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Multiwall Sheet Extrusion		
Drying Temperature	120	°C
Drying Time	2 - 4	hrs
Barrel - Zone 1 Temperature	260 - 300	°C
Barrel - Zone 2 Temperature	260 - 290	°C
Barrel - Zone 3 Temperature	260 - 290	°C
Hopper Temperature	100 - 120	°C
Adapter Temperature	240 - 280	°C
Die Temperature	240 - 300	°C
Melt Temperature	260 - 300	°C
Calibrator Temperature	50 - 100	°C

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