

Lexan* Resin SLX2432T

Europe-Africa-Middle East: COMMERCIAL

Medium viscosity PC copolymer with enhanced UV stabilization and added release agent. V2 rated. Available in transparent and tinted colors.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	680	kgf/cm ²	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	730	kgf/cm ²	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	6	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	110	%	ASTM D 638
Tensile Modulus, 50 mm/min	26000	kgf/cm ²	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	1070	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	25400	kgf/cm ²	ASTM D 790
Tensile Stress, yield, 50 mm/min	65	MPa	ISO 527
Tensile Stress, break, 50 mm/min	69	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	6	%	ISO 527
Tensile Strain, break, 50 mm/min	110	%	ISO 527
Tensile Modulus, 1 mm/min	2550	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	105	MPa	ISO 178
Flexural Modulus, 2 mm/min	2500	MPa	ISO 178
IMPACT			
Izod Impact, unnotched, 23°C	265	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	71	cm-kgf/cm	ASTM D 256
Izod Impact, notched, -30°C	9	cm-kgf/cm	ASTM D 256
Instrumented Impact Total Energy, 23°C	785	cm-kgf	ASTM D 3763
Instrumented Impact Total Energy, -40°C	866	cm-kgf	ASTM D 3763
Izod Impact, unnotched 80*10*3 +23°C	NB	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*3 +23°C	25	kJ/m ²	ISO 180/1A

1) Typical values only. Variations within normal tolerances are possible for various colours. All values are measured at least after 48 hours storage at 23°C/50% relative humidity. All properties, except the melt volume rate are measured on injection moulded samples. All samples are prepared according to ISO 294.

2) Only typical data for material selection purpose. Not to be used for part or tool design.
3) This rating is not intended to reflect hazards presented this or any other material under actual fire conditions.
4) Own measurement according to UL.

Source, GMD, Last Update: 03/15/2008

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IMPACT			
Izod Impact, notched 80*10*3 -30°C	10	kJ/m²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*3 sp=62mm	30	kJ/m²	ISO 179/1eA
Charpy -30°C, V-notch Edgew 80*10*3 sp=62mm	15	kJ/m²	ISO 179/1eA
Charpy 23°C, Unnotch Edgew 80*10*3 sp=62mm	NB	kJ/m²	ISO 179/1eU
THERMAL			
Vicat Softening Temp, Rate B/50	135	°C	ASTM D 1525
HDT, 0.45 MPa, 3.2 mm, unannealed	130	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	118	°C	ASTM D 648
CTE, -40°C to 40°C, flow	6.66E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	6.48E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, flow	6.66E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	6.48E-05	1/°C	ISO 11359-2
Ball Pressure Test, 125°C +/- 2°C	PASSES	-	IEC 60695-10-2
Vicat Softening Temp, Rate B/50	135	°C	ISO 306
Vicat Softening Temp, Rate B/120	137	°C	ISO 306
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	130	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	116	°C	ISO 75/Af
PHYSICAL			
Specific Gravity	1.2	-	ASTM D 792
Water Absorption, 24 hours	0.12	%	ASTM D 570
Mold Shrinkage, flow, 3.2 mm	0.5 - 0.7	%	SABIC Method
Melt Flow Rate, 300°C/1.2 kgf	10	g/10 min	ASTM D 1238
Density	1.2	g/cm³	ISO 1183
Water Absorption, (23°C/sat)	0.25	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.17	%	ISO 62

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TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
PHYSICAL			
Melt Volume Rate, MVR at 300°C/1.2 kg	9	cm ³ /10 min	ISO 1133
OPTICAL			
Light Transmission	84	%	ASTM D 1003
Haze	0.8	%	ASTM D 1003
Refractive Index	1.59	-	ASTM D 542
FLAME CHARACTERISTICS			
UL Recognized, 94V-2 Flame Class Rating (3)	1.5	mm	UL 94
Glow Wire Flammability Index 960°C, passes at	1.6	mm	IEC 60695-2-12
Oxygen Index (LOI)	38	%	ISO 4589
UV-light, water exposure/immersion	F1	-	UL 746C

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PROCESSING PARAMETERS	TYPICAL VALUE	UNIT
Injection Molding		
Drying Temperature	120	°C
Drying Time	3 - 4	hrs
Drying Time (Cumulative)	48	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	280 - 300	°C
Nozzle Temperature	275 - 295	°C
Front - Zone 3 Temperature	280 - 300	°C
Middle - Zone 2 Temperature	265 - 290	°C
Rear - Zone 1 Temperature	255 - 280	°C
Mold Temperature	70 - 95	°C
Back Pressure	0.3 - 0.7	MPa
Screw Speed	40 - 70	rpm
Shot to Cylinder Size	40 - 60	%
Vent Depth	0.025 - 0.076	mm

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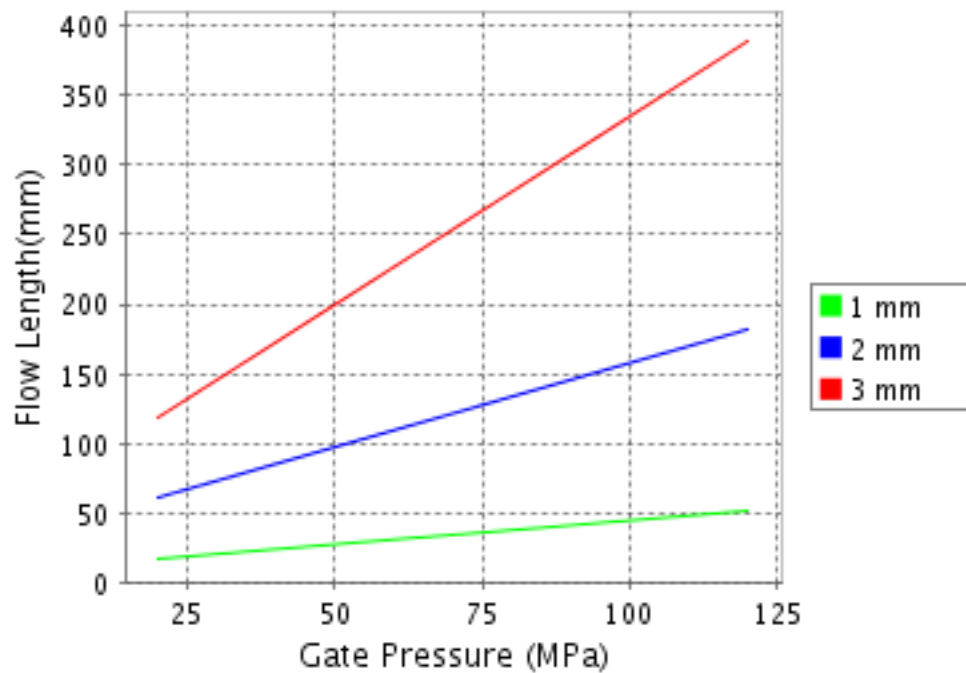
CALCULATED FLOW LENGTH INDICATION

Moldflow® Radial Flow Analysis

Lexan* SLX2432T

Melt Temperature : 305°C

Mold Temperature : 85°C



Note: Technical support is recommended if Gate Pressure is greater than 80 MPa. Contact your local representative.

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