

## Lexan\* Resin SLX1432

Americas: COMMERCIAL

Medium viscosity PC copolymer with enhanced UV stabilization and added release agent. Available in opaque colors. Typical minimum color tolerance limit is DE CMC < 1.0

### Property

TYPICAL PROPERTIES <sup>(1)</sup>			
MECHANICAL	Value	Unit	Standard
Tensile Stress, yld, Type I, 50 mm/min	65	MPa	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	72	MPa	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	6.1	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	126	%	ASTM D 638
Tensile Modulus, 5 mm/min	2520	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	105	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	2490	MPa	ASTM D 790
Tensile Stress, yield, 50 mm/min	65	MPa	ISO 527
Tensile Stress, break, 50 mm/min	71	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	5.8	%	ISO 527
Tensile Strain, break, 50 mm/min	123	%	ISO 527
Tensile Modulus, 1 mm/min	2590	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	99	MPa	ISO 178
Flexural Modulus, 2 mm/min	2390	MPa	ISO 178
IMPACT	Value	Unit	Standard
Izod Impact, notched, 23°C	860	J/m	ASTM D 256
Izod Impact, notched, -30°C	123	J/m	ASTM D 256
Instrumented Impact Total Energy, 23°C	76	J	ASTM D 3763
Izod Impact, unnotched 80*10*3 +23°C	NB	kJ/m <sup>2</sup>	ISO 180/1U
Izod Impact, notched 80*10*3 +23°C	65	kJ/m <sup>2</sup>	ISO 180/1A
Izod Impact, notched 80*10*3 -30°C	10	kJ/m <sup>2</sup>	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*3 sp=62mm	65	kJ/m <sup>2</sup>	ISO 179/1eA
Charpy -30°C, V-notch Edgew 80*10*3 sp=62mm	15	kJ/m <sup>2</sup>	ISO 179/1eA
Charpy 23°C, Unnotch Edgew 80*10*3 sp=62mm	NB	kJ/m <sup>2</sup>	ISO 179/1eU
THERMAL	Value	Unit	Standard
Vicat Softening Temp, Rate B/50	137	°C	ASTM D 1525
HDT, 0.45 MPa, 3.2 mm, unannealed	132	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	120	°C	ASTM D 648
CTE, -40°C to 40°C, flow	6.2E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	6.2E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, flow	6.2E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	6.2E-05	1/°C	ISO 11359-2
Vicat Softening Temp, Rate B/50	137	°C	ISO 306
Vicat Softening Temp, Rate B/120	140	°C	ISO 306
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	118	°C	ISO 75/Af
PHYSICAL	Value	Unit	Standard
Specific Gravity	1.22	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	0.6 - 0.8	%	SABIC Method

Melt Flow Rate, 300°C/1.2 kgf	10	g/10 min	ASTM D 1238
Density	1.23	g/cm <sup>3</sup>	ISO 1183
Water Absorption, (23°C/sat)	0.3	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.1	%	ISO 62
Melt Volume Rate, MVR at 300°C/1.2 kg	9	cm <sup>3</sup> /10 min	ISO 1133

Source GMD, last updated:05/24/2005

## Processing

Parameter	Value	Unit
<b>Injection Molding</b>		
Drying Temperature	120	°C
Drying Time	3 - 4	hrs
Drying Time (Cumulative)	48	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	295 - 315	°C
Nozzle Temperature	290 - 310	°C
Front - Zone 3 Temperature	295 - 315	°C
Middle - Zone 2 Temperature	280 - 305	°C
Rear - Zone 1 Temperature	270 - 295	°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

Source GMD, last updated:05/24/2005

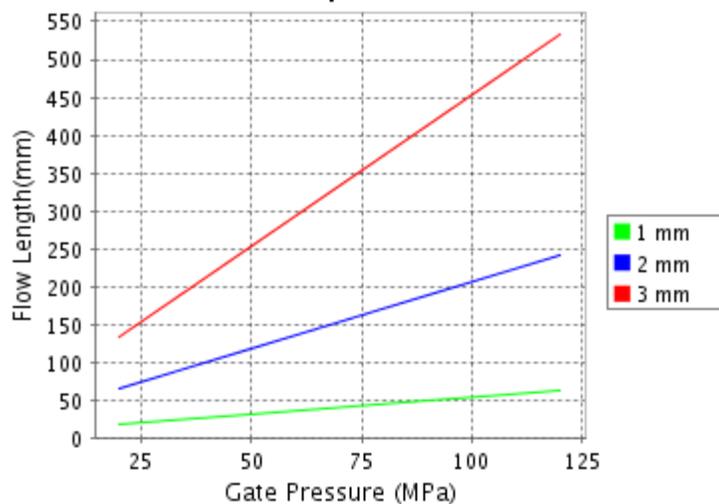
### CALCULATED FLOW LENGTH INDICATION

Moldflow® Radial Flow Analysis

Lexan® FXM123R

Melt Temperature : 290°C

Mold Temperature : 90°C



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

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THESE PROPERTY VALUES ARE NOT INTENDED FOR SPECIFICATION PURPOSES.

PLEASE CHECK WITH YOUR [\(LOCAL SALES OFFICE\)](#) FOR AVAILABILITY IN YOUR REGION

(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.

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