

LEXAN™ SLX2571T resin

Polycarbonate

SABIC Innovative Plastics Europe

Message:

Transparent weatherable PC copolymer for blowmolding/extrusion.

General Information			
Features	Copolymer		
	Good weather resistance		
Appearance	Clear/transparent		
Processing Method	Extrusion blow molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.20	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	3.0	g/10 min	ASTM D1238
Melt Volume-Flow Rate (MVR) (300°C/1.2 kg)	2.70	cm ³ /10min	ISO 1133
Molding Shrinkage - Flow (3.20 mm)	0.60 - 0.80	%	Internal method
Water Absorption			ISO 62
Saturated, 23°C	0.35	%	ISO 62
Equilibrium, 23°C, 50% RH	0.15	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	2400	MPa	ASTM D638
--	2360	MPa	ISO 527-2/1
Tensile Strength			
Yield ²	62.0	MPa	ASTM D638
Yield	63.0	MPa	ISO 527-2/50
Fracture ³	64.0	MPa	ASTM D638
Fracture	63.0	MPa	ISO 527-2/50
Tensile Elongation			
Yield ⁴	7.5	%	ASTM D638
Yield	6.0	%	ISO 527-2/50
Fracture ⁵	110	%	ASTM D638
Fracture	98	%	ISO 527-2/50
Flexural Modulus			
50.0mm span ⁶	2400	MPa	ASTM D790
-- ⁷	2250	MPa	ISO 178
Flexural Stress			
--	94.7	MPa	ISO 178

Yield, 50.0mm span ⁸	101	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ⁹			ISO 179/1eA
-30°C	15	kJ/m ²	ISO 179/1eA
23°C	75	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength ¹⁰ (23°C)	No Break		ISO 179/1eU
Notched Izod Impact			
-30°C	140	J/m	ASTM D256
23°C	850	J/m	ASTM D256
-30°C ¹¹	10	kJ/m ²	ISO 180/1A
23°C ¹²	70	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength ¹³ (23°C)	No Break		ISO 180/1U
Instrumented Dart Impact (23°C, Total Energy)	74.0	J	ASTM D3763
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
1.8 MPa, unannealed, 3.20mm	126	°C	ASTM D648
1.8 MPa, unannealed, 64.0mm span ¹⁴	125	°C	ISO 75-2/Af
Vicat Softening Temperature			
--	143	°C	ASTM D1525, ISO 306/B50 10 ¹⁵
--	145	°C	ISO 306/B120
Linear thermal expansion coefficient			ASTM E831, ISO 11359-2
Flow: -40 to 40°C	6.0E-5	cm/cm/°C	ASTM E831, ISO 11359-2
Lateral: -40 to 40°C	6.4E-5	cm/cm/°C	ASTM E831, ISO 11359-2
Flammability	Nominal Value		Test Method
Flame Rating (1.50 mm, Testing by SABIC)	V-2		UL 94
Extrusion	Nominal Value	Unit	
Drying Temperature	116 - 121	°C	
Drying Time	4.0 - 6.0	hr	
Suggested Max Moisture	0.020	%	
Cylinder Zone 1 Temp.	260 - 274	°C	
Cylinder Zone 2 Temp.	260 - 274	°C	
Cylinder Zone 3 Temp.	260 - 274	°C	
Cylinder Zone 4 Temp.	260 - 274	°C	
Cylinder Zone 5 Temp.	260 - 274	°C	
Adapter Temperature	260 - 274	°C	
Die Temperature	268 - 279	°C	
Extrusion instructions			
Drying Time (Cumulative): 48 hrsHead - Zone 6 - Top Temperature: 260 - 274 °CHead - Zone 7 - Bottom Temperature: 260 - 274 °CMelt Temperature (Parison): 266 - 277 °CMinimum Moisture Content: .01 %Mold Temperature: 66 - 93 °CScrew Speed: 15 - 50 rpm			
NOTE			

1.	5.0 mm/min
2.	Type 1, 50mm/min
3.	Type 1, 50mm/min
4.	Type 1, 50mm/min
5.	Type 1, 50mm/min
6.	1.3 mm/min
7.	2.0 mm/min
8.	1.3 mm/min
9.	80*10*3 sp=62mm
10.	80*10*3 sp=62mm
11.	80*10*3
12.	80*10*3
13.	80*10*3
14.	80*10*4 mm
15.	标准 B (120°C/h), 载荷2 (50N)

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