LEXAN™ 135 resin

Polycarbonate

SABIC Innovative Plastics Europe

Message:

General purpose low flow polycarbonate powder grade

General Information			
Features	Low liquidity General		
Uses	General		
Forms	Powder		
Processing Method	Injection molding		
Physical	**Nominal Value**	**Unit**	**Test Method**
Specific Gravity			ASTM D792
--	1.20	g/cm³	ASTM D792
--	1.19	g/cm³	ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	3.5	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm)	0.50 - 0.70	%	Internal method
Water Absorption			ASTM D570
Equilibrium, 23°C	0.35	%	ASTM D570
Equilibrium, 100°C	0.58	%	ASTM D570
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Strength [1]			ASTM D638
Yield	62.0	MPa	ASTM D638
Fracture	65.0	MPa	ASTM D638
Tensile Elongation [2] (Break)	> 70	%	ASTM D638
Flexural Modulus [3] (50.0 mm Span)	2340	MPa	ASTM D790
Flexural Strength [4] (Yield, 50.0 mm Span)	93.0	MPa	ASTM D790
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact (23°C)	910	J/m	ASTM D256
Unnotched Izod Impact (23°C)	No Break		ASTM D4812
Instrumented Dart Impact (23°C, Energy at Peak Load)	64.0	J	ASTM D3763
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load			ASTM D648
0.45 MPa, unannealed, 6.40mm	137	°C	ASTM D648
1.8 MPa, unannealed, 6.40mm	132	°C	ASTM D648
Vicat Softening Temperature	154	°C	ASTM D1525 [5]
CLTE - Flow (-40 to 95°C)	6.8E-5	cm/cm/°C	ASTM E831

Specific Heat	1250	J/kg/°C	ASTM C351
Optical	**Nominal Value**	**Unit**	**Test Method**
Transmittance (2540 µm)	88.0	%	ASTM D1003
Haze (2540 µm)	1.0	%	ASTM D1003
Injection	**Nominal Value**	**Unit**	
Drying Temperature	121	°C	
Drying Time	3.0 - 4.0	hr	
Drying Time, Maximum	48	hr	
Suggested Max Moisture	0.020	%	
Suggested Shot Size	40 - 60	%	
Rear Temperature	299 - 321	°C	
Middle Temperature	310 - 332	°C	
Front Temperature	321 - 343	°C	
Nozzle Temperature	316 - 338	°C	
Processing (Melt) Temp	321 - 343	°C	
Mold Temperature	82.2 - 116	°C	
Back Pressure	0.345 - 0.689	MPa	
Screw Speed	40 - 70	rpm	
Vent Depth	0.025 - 0.076	mm	

NOTE	
1.	Type 1, 50mm/min
2.	Type 1, 50mm/min
3.	1.3 mm/min
4.	1.3 mm/min
5.	标准 B (120°C/h), 载荷2 (50N)

Recommended distributors for this material

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