

LEXAN™ SLX1432 resin

Polycarbonate
SABIC Innovative Plastics

Message:
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

General Information			
Additive	Mold Release		
Features	Copolymer		
	Good UV Resistance		
	Medium Viscosity		
Appearance	Opaque		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
--	1.22	g/cm ³	ASTM D792
--	1.23	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	10	g/10 min	ASTM D1238
Melt Volume-Flow Rate (MVR) (300°C/1.2 kg)	9.00	cm ³ /10min	ISO 1133
Molding Shrinkage - Flow (3.20 mm)	0.60 to 0.80	%	Internal Method
Water Absorption			ISO 62
Saturation, 23°C	0.30	%	
Equilibrium, 23°C, 50% RH	0.10	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	2520	MPa	ASTM D638
--	2590	MPa	ISO 527-2/1
Tensile Strength			
Yield ²	65.6	MPa	ASTM D638
Yield	65.4	MPa	ISO 527-2/50
Break ³	72.6	MPa	ASTM D638
Break	71.3	MPa	ISO 527-2/50
Tensile Elongation			
Yield ⁴	6.1	%	ASTM D638
Yield	5.8	%	ISO 527-2/50
Break ⁵	130	%	ASTM D638
Break	120	%	ISO 527-2/50
Flexural Modulus			

50.0 mm Span ⁶	2490	MPa	ASTM D790
-- ⁷	2390	MPa	ISO 178
Flexural Stress			
--	99.8	MPa	ISO 178
Yield, 50.0 mm Span ⁸	105	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ⁹			ISO 179/1eA
-30°C	15	kJ/m ²	
23°C	65	kJ/m ²	
Charpy Unnotched Impact Strength ¹⁰ (23°C)	No Break		ISO 179/1eU
Notched Izod Impact			
-30°C	120	J/m	ASTM D256
23°C	860	J/m	ASTM D256
-30°C ¹¹	10	kJ/m ²	ISO 180/1A
23°C ¹²	65	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)	76.0	J	ASTM D3763
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed, 3.20 mm	132	°C	ASTM D648
1.8 MPa, Unannealed, 3.20 mm	120	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ¹⁴	118	°C	ISO 75-2/Af
Vicat Softening Temperature			
--	137	°C	ASTM D1525, ISO 306/B50 10 ¹⁵
--	140	°C	ISO 306/B120
CLTE			
Flow : -40 to 40°C	6.2E-5	cm/cm/°C	
Transverse : -40 to 40°C	6.2E-5	cm/cm/°C	
Injection	Nominal Value	Unit	
Drying Temperature	121	°C	
Drying Time	3.0 to 4.0	hr	
Drying Time, Maximum	48	hr	
Suggested Max Moisture	0.020	%	
Suggested Shot Size	40 to 60	%	
Rear Temperature	271 to 293	°C	
Middle Temperature	282 to 304	°C	
Front Temperature	293 to 316	°C	
Nozzle Temperature	288 to 310	°C	
Processing (Melt) Temp	293 to 316	°C	
Mold Temperature	71.1 to 93.3	°C	

Back Pressure	0.345 to 0.689	MPa
Screw Speed	40 to 70	rpm
Vent Depth	0.025 to 0.076	mm

NOTE

1.	5.0 mm/min
2.	Type I, 50 mm/min
3.	Type I, 50 mm/min
4.	Type I, 50 mm/min
5.	Type I, 50 mm/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.	Rate B (120°C/h), Loading 2 (50 N)

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