



LEXAN™ Resin 135RESIN

Europe-Africa-Middle East: COMMERCIAL

LEXAN 135RESIN_111 is the highest viscosity linear polycarbonate resin powder type. Suitable for extrusion processes. The product datasheet shows typical values which can be obtained when the polycarbonate powder is converted into extruded products.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yield, 50 mm/min	63	MPa	ISO 527
Tensile Stress, break, 50 mm/min	70	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	7	%	ISO 527
Tensile Strain, break, 50 mm/min	120	%	ISO 527
Tensile Modulus, 1 mm/min	2350	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	90	MPa	ISO 178
Flexural Modulus, 2 mm/min	2300	MPa	ISO 178
THERMAL			
CTE, -40°C to 40°C, xflow	7.E-05	1/°C	ISO 11359-2
CTE, 23°C to 80°C, flow	7.E-05	1/°C	ISO 11359-2
Vicat Softening Temp, Rate B/50	144	°C	ISO 306
Vicat Softening Temp, Rate B/120	145	°C	ISO 306
HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm	128	°C	ISO 75/Ae
PHYSICAL			
Density	1.2	g/cm ³	ISO 1183
Water Absorption, (23°C/sat)	0.35	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.15	%	ISO 62
Melt Volume Rate, MVR at 300°C/1.2 kg	3	cm ³ /10 min	ISO 1133



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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Profile Extrusion		
Drying Temperature	120	°C
Drying Time	2 - 4	hrs
Melt Temperature	270 - 280	°C
Barrel - Zone 1 Temperature	260 - 280	°C
Barrel - Zone 2 Temperature	260 - 280	°C
Barrel - Zone 3 Temperature	260 - 280	°C
Barrel - Zone 4 Temperature	260 - 280	°C
Hopper Temperature	40 - 60	°C
Adapter Temperature	260 - 280	°C
Die Temperature	250 - 260	°C
Calibrator Temperature	70 - 90	°C