



LEXAN™ Resin EX1632TC

Europe-Africa-Middle East: COMMERCIAL

LEXAN* EX1632TC polycarbonate resin, MVR (300C/1.2kg) 6 cm3/10min, high viscosity, branched, extrusion, mold release, UV stabilized, transparent, translucent and opaque colors. Multiwall sheet, Profiles.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yield, 50 mm/min	65	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	>70	%	ISO 527
Tensile Modulus, 1 mm/min	2350	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	95	MPa	ISO 178
Flexural Modulus, 2 mm/min	2300	MPa	ISO 178
IMPACT			
Izod Impact, unnotched 80*10*3 +23°C	NB	kJ/m ²	ISO 180/1U
Izod Impact, unnotched 80*10*3 -30°C	NB	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*3 +23°C	75	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*3 -30°C	55	kJ/m ²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*3 sp=62mm	70	kJ/m ²	ISO 179/1eA
Charpy -30°C, V-notch Edgew 80*10*3 sp=62mm	50	kJ/m ²	ISO 179/1eA
Charpy 23°C, Unnotch Edgew 80*10*3 sp=62mm	NB	kJ/m ²	ISO 179/1eU
Charpy -30°C, Unnotch Edgew 80*10*3 sp=62mm	NB	kJ/m ²	ISO 179/1eU
THERMAL			
Thermal Conductivity	0.2	W/m-°C	ISO 8302
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
Ball Pressure Test, 125°C +/- 2°C	PASSES	-	IEC 60695-10-2
Vicat Softening Temp, Rate B/50	149	°C	ISO 306
Vicat Softening Temp, Rate B/120	150	°C	ISO 306



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TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
THERMAL			
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	130	°C	ISO 75/Af
PHYSICAL			
Mold Shrinkage, flow, 3.2 mm (5)	0.5 - 0.7	%	SABIC Method
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	6	cm ³ /10 min	ISO 1133
Melt Volume Rate, MVR at 300°C/2.16 kg	11	cm ³ /10 min	ISO 1133
FLAME CHARACTERISTICS			
UL Recognized, 94HB Flame Class Rating (3)	0.8	mm	UL 94
UL Recognized, 94HB Flame Class Rating 2nd value (3)	3	mm	UL 94



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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Multiwall Sheet Extrusion		
Drying Temperature	120	°C
Drying Time	2 - 4	hrs
Barrel - Zone 1 Temperature	240 - 270	°C
Barrel - Zone 2 Temperature	240 - 270	°C
Barrel - Zone 3 Temperature	240 - 270	°C
Hopper Temperature	100 - 120	°C
Adapter Temperature	220 - 260	°C
Die Temperature	220 - 280	°C
Melt Temperature	220 - 280	°C
Calibrator Temperature	50 - 100	°C