



LEXAN™ Resin SLX1432
Americas: COMMERCIAL

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

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	660	kgf/cm ²	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	740	kgf/cm ²	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	6.1	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	126	%	ASTM D 638
Tensile Modulus, 5 mm/min	25600	kgf/cm ²	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	1070	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	25400	kgf/cm ²	ASTM D 790
Tensile Stress, yield, 50 mm/min	65	MPa	ISO 527
Tensile Stress, break, 50 mm/min	71	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	5.8	%	ISO 527
Tensile Strain, break, 50 mm/min	123	%	ISO 527
Tensile Modulus, 1 mm/min	2590	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	99	MPa	ISO 178
Flexural Modulus, 2 mm/min	2390	MPa	ISO 178
IMPACT			
Izod Impact, notched, 23°C	87	cm-kgf/cm	ASTM D 256
Izod Impact, notched, -30°C	12	cm-kgf/cm	ASTM D 256
Instrumented Impact Total Energy, 23°C	774	cm-kgf	ASTM D 3763
Izod Impact, unnotched 80*10*3 +23°C	NB	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*3 +23°C	65	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*3 -30°C	10	kJ/m ²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*3 sp=62mm	65	kJ/m ²	ISO 179/1eA



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TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
IMPACT			
Charpy -30°C, V-notch Edgew 80*10*3 sp=62mm	15	kJ/m ²	ISO 179/1eA
Charpy 23°C, Unnotch Edgew 80*10*3 sp=62mm	NB	kJ/m ²	ISO 179/1eU
THERMAL			
Vicat Softening Temp, Rate B/50	137	°C	ASTM D 1525
HDT, 0.45 MPa, 3.2 mm, unannealed	132	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	120	°C	ASTM D 648
CTE, -40°C to 40°C, flow	6.2E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	6.2E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, flow	6.2E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	6.2E-05	1/°C	ISO 11359-2
Vicat Softening Temp, Rate B/50	137	°C	ISO 306
Vicat Softening Temp, Rate B/120	140	°C	ISO 306
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	118	°C	ISO 75/Af
PHYSICAL			
Specific Gravity	1.22	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm (5)	0.6 - 0.8	%	SABIC Method
Melt Flow Rate, 300°C/1.2 kgf	10	g/10 min	ASTM D 1238
Density	1.23	g/cm ³	ISO 1183
Water Absorption, (23°C/sat)	0.3	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.1	%	ISO 62
Melt Volume Rate, MVR at 300°C/1.2 kg	9	cm ³ /10 min	ISO 1133



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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	120	°C
Drying Time	3 - 4	hrs
Drying Time (Cumulative)	48	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	295 - 315	°C
Nozzle Temperature	290 - 310	°C
Front - Zone 3 Temperature	295 - 315	°C
Middle - Zone 2 Temperature	280 - 305	°C
Rear - Zone 1 Temperature	270 - 295	°C
Mold Temperature	70 - 95	°C
Back Pressure	0.3 - 0.7	MPa
Screw Speed	40 - 70	rpm
Shot to Cylinder Size	40 - 60	%
Vent Depth	0.025 - 0.076	mm



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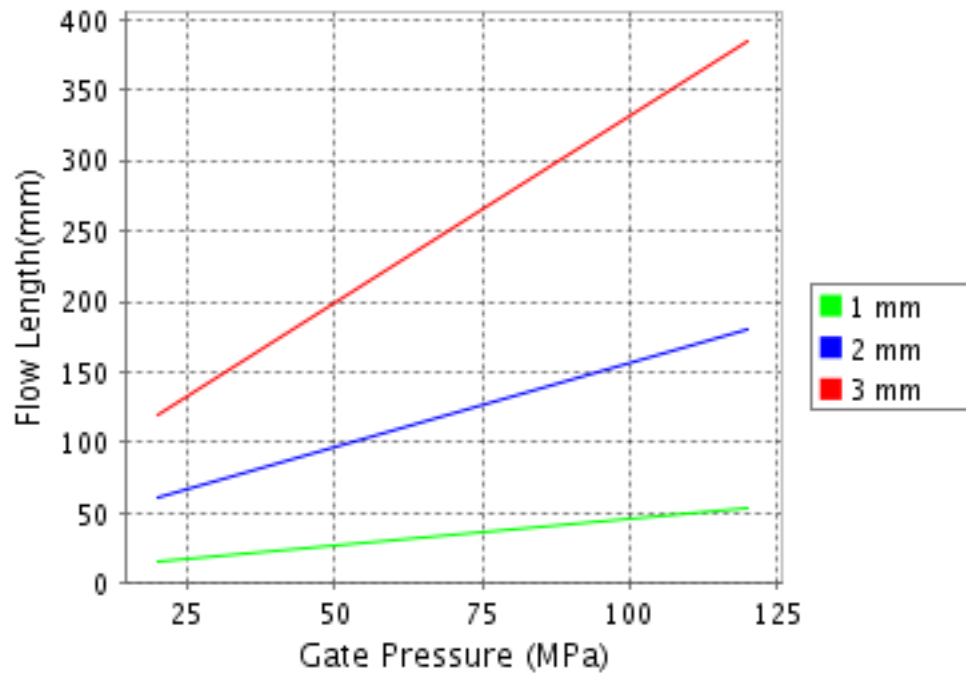
CALCULATED FLOW LENGTH INDICATION

Moldflow® Radial Flow Analysis

LEXAN® SLX1432

Melt Temperature : 305°C

Mold Temperature : 80°C



Note: Technical support is recommended if Gate Pressure is greater than 80 MPa. Contact your local representative.

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