

Lexan* Resin EX1632T
Americas: COMMERCIAL

Lexan* EX1632T polycarbonate resin is designed for use in multi-wall sheet or profile extrusion applications. It contains branched polycarbonate resin, release, and UV stabilizer. It is available in a limited number of colors.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	620	kgf/cm ²	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	580	kgf/cm ²	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	6.3	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	98.8	%	ASTM D 638
Tensile Modulus, 5 mm/min	22500	kgf/cm ²	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	1000	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	24100	kgf/cm ²	ASTM D 790
IMPACT			
Izod Impact, notched, 23°C	81	cm-kgf/cm	ASTM D 256
Izod Impact, notched, -30°C	15	cm-kgf/cm	ASTM D 256
Instrumented Impact Total Energy, 23°C	757	cm-kgf	ASTM D 3763
THERMAL			
Vicat Softening Temp, Rate B/50	145	°C	ASTM D 1525
HDT, 0.45 MPa, 3.2 mm, unannealed	140	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	130	°C	ASTM D 648
CTE, -40°C to 40°C, flow	6.5E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	6.6E-05	1/°C	ASTM E 831
Vicat Softening Temp, Rate B/120	147	°C	ISO 306
PHYSICAL			
Mold Shrinkage, flow, 3.2 mm (5)	1	%	SABIC Method
Melt Flow Rate, 300°C/1.2 kgf	6	g/10 min	ASTM D 1238
Density	1.19	g/cm ³	ISO 1183



(1) Typical values only. Variations within normal tolerances are possible for various colors. All values are measured after at least 48 hours storage at 23±176.C/50% relative humidity. All properties, except the melt volume and melt flow rates, are measured on injection molded samples. All samples tested under ISO test standards are prepared according to ISO 294.

(2) Only typical data for selection purposes. Not to be used for part or tool design.
 (3) This rating is not intended to reflect hazards presented by this or any other material under actual fire conditions.
 (4) Internal measurements according to UL standards.
 (5) Measurements made from laboratory test coupon. Actual shrinkage may vary outside of range due to differences in processing conditions, equipment, part geometry and tool design. It is recommended that mold shrinkage studies be performed with surrogate or legacy tooling prior to cutting tools for new molded article.

Source GMD, last updated:

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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Extrusion		
Drying Temperature	75 - 90	°C
Drying Time	2 - 4	hrs
Minimum Moisture Content	0.04	%
Melt Temperature	180 - 200	°C
Barrel - Zone 1 Temperature	165	°C
Barrel - Zone 2 Temperature	170	°C
Barrel - Zone 3 Temperature	175	°C
Barrel - Zone 4 Temperature	180	°C
Roll Stack Temperature - Top	175 - 180	°C
Roll Stack Temperature - Middle	175 - 180	°C
Roll Stack Temperature - Bottom	175 - 180	°C



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