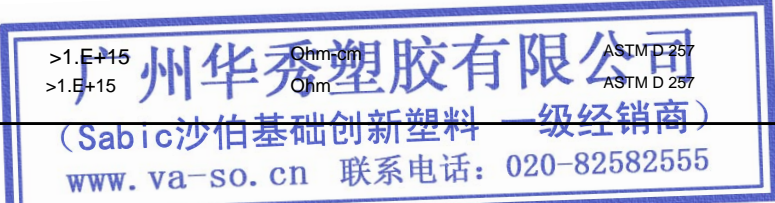




LEXAN™ Resin EXL8483
Asia Pacific: COMMERCIAL

Lexan* EXL8483 is a PC/siloxane copolymer resin with medium flow, excellent low temperature impact and 80% post consumer recycle content. Limited availability and restricted color only. Higher color variability and contamination risks including black specs needs to be considered before approval for use in applications.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	580	kgf/cm ²	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	560	kgf/cm ²	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	6	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	100	%	ASTM D 638
Tensile Modulus, 5 mm/min	22400	kgf/cm ²	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	910	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	21400	kgf/cm ²	ASTM D 790
IMPACT			
Izod Impact, notched, 23°C	81	cm-kgf/cm	ASTM D 256
Izod Impact, notched, -30°C	66	cm-kgf/cm	ASTM D 256
Izod Impact, notched, -40°C	61	cm-kgf/cm	ASTM D 256
Instrumented Impact Total Energy, 23°C	713	cm-kgf	ASTM D 3763
THERMAL			
Vicat Softening Temp, Rate B/50	145	°C	ASTM D 1525
HDT, 1.82 MPa, 3.2mm, unannealed	123	°C	ASTM D 648
CTE, -40°C to 40°C, flow	6.E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	6.E-05	1/°C	ASTM E 831
PHYSICAL			
Specific Gravity	1.2	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm (5)	0.4 - 0.8	%	SABIC Method
Melt Flow Rate, 300°C/1.2 kgf	10	g/10 min	ASTM D 1238
Water Absorption, 23°C/24hrs	0.15	%	SABIC Method
ELECTRICAL			
Volume Resistivity	>1.E+15	Ohm-cm	ASTM D 257
Surface Resistivity	>1.E+15	Ohm	ASTM D 257



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(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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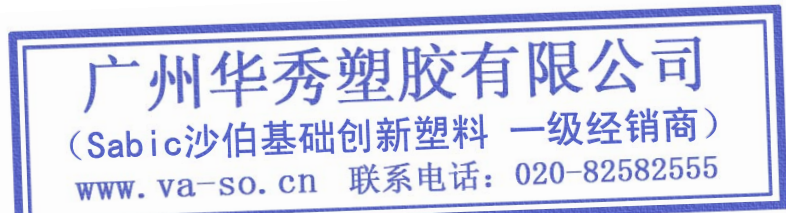
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TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
ELECTRICAL			
Dielectric Strength, in oil, 0.8 mm	15	kV/mm	ASTM D 149
Relative Permittivity, 1 MHz	3	-	ASTM D 150
Dissipation Factor, 1 MHz	0.0093	-	ASTM D 150
FLAME CHARACTERISTICS			
UL Recognized, 94HB Flame Class Rating (3)	0.75	mm	UL 94
Glow Wire Flammability Index 850°C, passes at	1	mm	IEC 60695-2-12
Glow Wire Flammability Index 960°C, passes at	3	mm	IEC 60695-2-12
Glow Wire Ignitability Temperature, 1.0 mm	875	°C	IEC 60695-2-13
Glow Wire Ignitability Temperature, 3.0 mm	875	°C	IEC 60695-2-13



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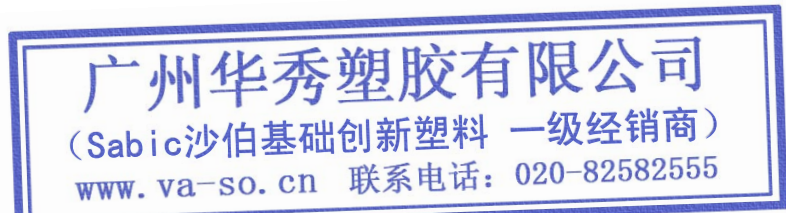
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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	120	°C
Drying Time	3 - 4	hrs
Drying Time (Cumulative)	48	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	295 - 315	°C
Nozzle Temperature	290 - 310	°C
Front - Zone 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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