

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.

Property

TYPICAL PROPERTIES ⁽¹⁾			
MECHANICAL	Value	Unit	Standard
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	Value	Unit	Standard
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	Value	Unit	Standard
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

Source GMD, last updated:10/30/2007

Processing

Parameter	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

Source GMD, last updated:10/30/2007

THESE PROPERTY VALUES ARE NOT INTENDED FOR SPECIFICATION PURPOSES.

PLEASE CHECK WITH YOUR [\(LOCAL SALES OFFICE\)](#) FOR AVAILABILITY IN YOUR REGION

(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°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.

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