

LEXAN™ DH65011 SHEET

PRODUCT DATASHEET

DESCRIPTION

LEXAN™ DH65011 sheet is a high modulus, non-chlorinated and non-brominated compliant flame retardant opaque PC/ABS based sheet grade with improved chemical resistance against graffiti cleaners available in custom colors and patterns. In addition to good flammability performance, it offers excellent mechanical properties combining impact with very high stiffness and strength and ease of processing making it an excellent candidate for a wide range of applications in industries such as mass transportation.

TYPICAL PROPERTY VALUES ♦

PROPERTY	TEST METHOD	UNITS	VALUE
PHYSICAL			
Density	ASTM D792	g/cm ³	1.35
Rockwell Hardness	ASTM D785		R117
MECHANICAL			
Tensile Strength at Yield, 5 mm/min	ASTM D638	MPa	>60
Tensile Modulus at Yield, 5mm/min	ASTM D638	MPa	4300
Elongation at Yield, 5mm/min	ASTM D638	%	3.6
Elongation at Break, 5mm/min	ASTM D638	%	7.2
Flexural Stress	ASTM D790	MPa	>110
Flexural Modulus	ASTM D790	MPa	4500
IMPACT			
Izod impact, notched 23°C, 2ft lb	ASTM D256	jj/m	108
THERMAL			
Vicat softening temperature, B/120	ISO 306	°C	129
FIRE RATINGS			
Rail			
US	NFPA 130	Pass	3.2MM
Flame Spread Index, Is (<35 max) ^{##}	ASTM E-162	Pass	
Smoke Density			
Ds - 1.5mins. (<100max) ^{##}	ASTM E-662	Pass	
Ds - 4.0mins (<200 max) ^{##}		Pass	
Heat & Visible Smoke Release Rate	ASTM E-1354/	Data on file	

♦ These property values have been derived from LEXAN™ resin data for the material used to produce this sheet product. Variations within normal tolerances are possible for various colors. These typical values are not intended for specification purposes. If minimum certifiable properties are required please contact your local SABIC, Specialty Film & Sheet representative. All values are measured at least after 48 hours storage at 23°C/50% relative humidity. All properties are measured on injection molded samples. All samples are prepared according ISO 294.

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PROCESSING

LEXAN™ DH65011 sheet is suitable for thermoforming. To reach optimal results the materials needs to be heated with sandwich type heating systems to reach uniform heat uptake. Pre-drying of this material is necessary. For pre-drying guidelines follow standard guidelines for pre-drying standard LEXAN™ sheet.

LEXAN DH65011 sheet has a processing window between 160 and 200°C. When forming a draft angle of 3 degrees should be allowed. Post mold shrinkage is dependent on tool temperature and environmental circumstances, but will typically be in the range of 0.4-0.6%. It is strongly recommended to evaluate impact of part and mold design prior to production.

PRE-DRYING

It is important to ensure that LEXAN DH65011 sheets are free of moisture prior to thermoforming. A hot air circulating oven set at 120 °C is recommended, with a 25 mm gap between sheets. Pre-drying times vary from 3-12 hours for 1.2 to 4.0 mm thick sheets.

PRODUCT AVAILABILITY

Standard gauges: 3.2mm

Sizes: 1524 x 1086mm, 1524x1696mm

Textures: DH65011 (Polish/Haircell)

Colors: custom colors and patterns are available

Masking: none

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