

LEXAN™ DP8B35 FILM

PRODUCT DATASHEET

DESCRIPTION

LEXAN™ DP8B35 is a one side primed film designed for increased digital UV ink adhesion under laminating adhesive exposure where other polycarbonate film solutions may not perform as needed. Due to rapid development of ink adhesion, post drying of the printed artwork prior to adhesive lamination can be eliminated (with many digital ink sets) thus reducing production cycle time. It offers high temperature resistance, excellent dimensional stability, as well as good printability making it very suitable for multi-layer printing for applications such as overlays, floor graphics, high-performance labels and in-mold decoration. It is optimized for UV inks and offers ease of processing for thermoforming, embossing, die-cutting, hydro-forming and bending.

TYPICAL PROPERTY VALUES

| PROPERTY | ASTM TEST METHOD | UNITS (USCS) | VALUE | ISO TEST METHOD | UNITS (SI) | VALUE |
|---|-----------------------|-------------------------------|-----------|-----------------|-------------------------|-------|
| MECHANICAL | | | | | | |
| Tensile Strength @ Yield | ASTM D882 | psi | 8500 | ISO 527 | MPa | 62 |
| Ultimate | ASTM D882 | psi | 9000 | ISO 527 | MPa | 65 |
| Tensile Modulus | ASTM D882 | psi | 300000 | ISO 527 | MPa | 2100 |
| Tensile Elongation at Break | ASTM D882 | % | 100-156 | ISO 527 | % | 100 |
| Gardner Impact Strength at 0.03" (0.75 mm) | ASTM D3029 | ft-lb | 23 | ISO 6603-1 | J | 31 |
| Tear Strength | | | | | | |
| Initiation | ASTM D1004 | lb/mil | 1.4-1.8 | | kN/m | 245 |
| Propagation | ASTM D1922 | g/mil | 30-55 | | kN/m | 10-20 |
| Puncture Resistance (Dynatup) | ASTM D3763 | ft-lb | 9 | | J | 12 |
| Fold Endurance (MIT) | | | | | | |
| 0.010" (0.25 mm) | ASTM D2176-69 | double folds | 60 | | | |
| 0.020" (0.50 mm) | ASTM D2176-69 | double folds | 20 | | | |
| THERMAL | | | | | | |
| Coefficient of Thermal Conductivity | ASTM D5470 | Btu/hr/ft ² /°F/in | 1.35 | | W/m ² °K | 0.2 |
| Coefficient of Thermal Expansion | ASTM E831 | (x10 ⁻⁵ /°F) | 3.2 | ISO 11359 | (x10 ⁻⁵ /°C) | 7 |
| Specific Heat @40°F (4°C) | ASTM E1269 | Btu/lb/°F | 0.3 | | KJ/Kg-°C | 1.25 |
| Glass Transition Temperature | ASTM D3417 / D3418 | °F | 307 | ISO 11357 | °C | 153 |
| Vicat Softening Temperature, B | ASTM 1525-00 modified | °F | 323 | | °C | 150 |
| Heat Deflection Temp. by TMA at 1.8 Mpa | | °F | 290 | ISO 75 Modified | °C | 135 |
| Brittleness Temperature | ASTM D746 | °F | -211 | | °C | -135 |
| PHYSICAL | | | | | | |
| Density | ASTM D792 | slug/ft ³ | 2.3 | ISO 1183 | kg/m ³ | 1200 |
| Water Absorption, 24 hrs. | ASTM D570 | % change | 0.35 | ISO 62 | % change | 0.35 |
| Surface Roughness (RMS) | ASTM D5946-01 | μ | See chart | | | |
| Surface Energy(1 st surface/ 2 nd surface) | Dyne Pens | Dyne | 37/31 | | | |
| Surface Tension(1 st surface/ 2 nd surface) | ASTM D3363 | - | >44/38-40 | | | |
| Taber Abrasion | ASTM D1044 | delta Haze | <1 | | | |

| PROPERTY | ASTM TEST METHOD | UNITS (USCS) | VALUE | ISO TEST METHOD | UNITS (SI) | VALUE |
|-------------------------------------|------------------------|--------------|-----------|-----------------|------------|-----------|
| OPTICAL | | | | | | |
| Refractive Index @77°F (25°C) | ASTM D542A | - | 1.6 | | | |
| Light Transmission | ASTM D1003 | % | 80 | | | |
| Yellowness Index | ASTM D1925 | % | 2.2 | | | |
| Haze | ASTM D1003 | % | 102 | | | |
| Gloss over Flat Black min/max @ 60° | ASTM D523-60 | - | See chart | ISO 2813 | - | See chart |
| UV cutout | UV/Visual Spectroscopy | % | 0.3 | | | |

◆ These are typical properties and are not intended for specification purposes. If minimum certifiable properties are required, please contact your local SABIC representative or the SABIC Quality Services Department. Reported values are based on 0.250 mm (0.010”) thickness film unless otherwise noted.

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MANUFACTURING SPECIFICATIONS

| NOMINAL GAUGE RANGES | MIN./MAX LIMIT OF NOMINAL |
|----------------------------------|---------------------------|
| 0.003” (0.075 mm) | ± 10% |
| 0.005 - 0.007” (0.125 - 0.175mm) | ± 8% |
| 0.010-0.015” (0.250-0.375 mm) | ± 5% |
| 0.020” (0.500 mm) | ± 3 |

APPLICATION GUIDELINES

- Product designed for use with UV curable ink sets and do not achieve acceptable adhesion with the HP Indigo print process.
- Complete first pass ink coverage is recommended as post flood coating will not develop the same bond integrity and may delaminate under adhesive lamination film exposure.
- Typical contact angle on the coated side is 40-60 degrees.

CONTACT US:

MIDDLE EAST AND AFRICA
 SABIC Global Headquarters
 PO Box 5101
 Riyadh 11422
 Saudi Arabia
 T +966 (0) 1 225 8000
 F +966 (0) 1 225 9000
 E info@sabic.com

AMERICAS
 Functional Forms
 2500 City West Boulevard
 Suite 100
 Houston, TX 77042
 USA
 Toll-free (800) 323 3783
 F (888) 443 2033
 E spinside.sales@sabic.com

EUROPE
 Functional Forms
 Plasticslaan 1
 4612 PX
 Bergen op Zoom
 The Netherlands
 T +31 (0)164 293678
 F +31 (0)164 293272
 E ff.info@sabic-ip.com

ASIA PACIFIC
 Functional Forms
 2550 Xiupu Road
 Pudong
 201319 Shanghai
 China
 T +86 21 2037 8188
 F +86 21 2037 8288
 E ff.info@sabic.com

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