

# 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
<b>MECHANICAL</b>						
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			
<b>THERMAL</b>						
Coefficient of Thermal Conductivity	ASTM D5470	Btu/hr/ft <sup>2</sup> /°F/in	1.35		W/m <sup>2</sup> °K	0.2
Coefficient of Thermal Expansion	ASTM E831	(x10 <sup>-5</sup> /°F)	3.2	ISO 11359	(x10 <sup>-5</sup> /°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
<b>PHYSICAL</b>						
Density	ASTM D792	slug/ft <sup>3</sup>	2.3	ISO 1183	kg/m <sup>3</sup>	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 <sup>st</sup> surface/ 2 <sup>nd</sup> surface)	Dyne Pens	Dyne	37/31			
Surface Tension(1 <sup>st</sup> surface/ 2 <sup>nd</sup> 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
<b>OPTICAL</b>						
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.

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