LEXAN™ FR RESINS 500R

REGION AMERICAS

DESCRIPTION

10% GR PC. Optimum combination of high modulus plus excellent impact strength and flame retardance. Internal mold release.

TYPICAL PROPERTY VALUES

Revision 20200610

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	66	MPa	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	55	MPa	ASTM D 638
Tensile Strain, yld, Type I, 5 mm/min	8	%	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	15	%	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	103	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	3440	MPa	ASTM D 790
Hardness, Rockwell M	85	-	ASTM D 785
Hardness, Rockwell R	124	-	ASTM D 785
Taber Abrasion, CS-17, 1 kg	11	mg/1000cy	ASTM D 1044
IMPACT			
Izod Impact, unnotched, 23°C	2136	J/m	ASTM D 4812
Izod Impact, notched, 23°C	106	J/m	ASTM D 256
Tensile Impact Strength, Type S	157	kJ/m²	ASTM D 1822
Falling Dart Impact (D 3029), 23°C	101	J	ASTM D 3029
THERMAL			
Vicat Softening Temp, Rate B/50	154	°C	ASTM D 1525
HDT, 0.45 MPa, 6.4 mm, unannealed	146	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	142	°C	ASTM D 648
CTE, -40°C to 95°C, flow	3.24E-05	1/°C	ASTM E 831
Specific Heat	1.21	J/g-°C	ASTM C 351
Thermal Conductivity	0.2	W/m-°C	ASTM C177
Relative Temp Index, Elec	130	°C	UL 746B
Relative Temp Index, Mech w/impact	130	°C	UL 746B
Relative Temp Index, Mech w/o impact	130	°C	UL 746B
PHYSICAL			
Specific Gravity	1.27	-	ASTM D 792
Specific Volume	0.8	cm³/g	ASTM D 792
Density	1.245	g/cm³	ASTM D 792
Water Absorption, 24 hours	0.12	%	ASTM D 570
Water Absorption, equilibrium, 23C	0.31	%	ASTM D 570
Mold Shrinkage, flow, 3.2 mm	0.2 – 0.4	%	SABIC method
Melt Flow Rate, 300°C/1.2 kgf	7.5	g/10 min	ASTM D 1238
ELECTRICAL			
Volume Resistivity	>1.E+17	Ohm-cm	ASTM D 257

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Dielectric Strength, in air, 3.2 mm	17.7	kV/mm	ASTM D 149
Relative Permittivity, 50/60 Hz	3.1	-	ASTM D 150
Relative Permittivity, 1 MHz	3.05	-	ASTM D 150
Dissipation Factor, 50/60 Hz	0.0008	-	ASTM D 150
Dissipation Factor, 1 MHz	0.0075	-	ASTM D 150
Arc Resistance, Tungsten {PLC}	7	PLC Code	ASTM D 495
Hot Wire Ignition {PLC}	1	PLC Code	UL 746A
High Voltage Arc Track Rate {PLC}	4	PLC Code	UL 746A
High Ampere Arc Ign, surface {PLC}	4	PLC Code	UL 746A
Comparative Tracking Index (UL) {PLC}	3	PLC Code	UL 746A
FLAME CHARACTERISTICS			
UL Yellow Card Link	E121562-220886	-	-
UL Recognized, 94V-0 Flame Class Rating	1.52	mm	UL 94
UL Recognized, 94-5VA Flame Class Rating	3.04	mm	UL 94
Oxygen Index (LOI)	36	%	ASTM D 2863
Radiant Panel Listing	☑	-	UL Tested
UV-light, water exposure/immersion	F2	-	UL 746C
INJECTION MOLDING			
Drying Temperature	120	°C	
Drying Time	3 – 4	hrs	
Drying Time (Cumulative)	48	hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	310 – 330	°C	
Nozzle Temperature	305 – 325	°C	
Front - Zone 3 Temperature	310 – 330	°C	
Middle - Zone 2 Temperature	300 – 320	°C	
Rear - Zone 1 Temperature	290 – 310	°C	
Mold Temperature	80 – 115	°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	

DISCLAIMER