

Revision 20231109

LEXANTM VISUALFXTM RESIN FXD153

REGION EUROPE

DESCRIPTION

FXD153 is an Extrusion / Blow molding grade in a Diffusion effect, which is part of the VisualFX family. These effects have been developed to meet increasing Aesthetic demands in the Marketplace. Color Package may affect properties, Application testing always reccomended.

TYPICAL PROPERTY VALUES

PROPERTIES **TYPICAL VALUES** UNITS **TEST METHODS** MECHANICAL⁽¹⁾ Tensile Stress, yld, Type I, 50 mm/min 62 MPa ASTM D638 Tensile Stress, brk, Type I, 50 mm/min 66 MPa ASTM D638 Tensile Strain, yld, Type I, 50 mm/min 7 % ASTM D638 110 ASTM D638 Tensile Strain, brk, Type I, 50 mm/min % Tensile Modulus, 5 mm/min 2340 MPa ASTM D638 Flexural Stress, yld, 1.3 mm/min, 50 mm span ASTM D790 93 MPa Flexural Modulus, 1.3 mm/min, 50 mm span 2340 MPa ASTM D790 IMPACT (1) Izod Impact, unnotched, 23°C ASTM D4812 3204 J/m ASTM D256 Izod Impact, notched, 23°C 748 J/m THERMAL (1) Vicat Softening Temp, Rate B/50 157 °C ASTM D1525 HDT, 0.45 MPa, 3.2 mm, unannealed °C ASTM D648 138 HDT, 1.82 MPa, 3.2mm, unannealed °C ASTM D648 132 CTE, -40°C to 40°C, xflow 6.8E-05 1/°C ASTM E831 PHYSICAL (1) Specific Gravity 1.2 ASTM D792 Mold Shrinkage, flow, 3.2 mm (2) 0.5 - 0.7% SABIC method Melt Flow Rate, 300°C/1.2 kgf 2.5 g/10 min ASTM D1238 INJECTION MOLDING (3) °C **Drying Temperature** 120 Drying Time 3 – 4 Hrs Drying Time (Cumulative) 48 Hrs Maximum Moisture Content 0.02 % °C Melt Temperature 320 - 345 °C Nozzle Temperature 315 - 340320 - 345 °C Front - Zone 3 Temperature Middle - Zone 2 Temperature 310 - 330 °C °C Rear - Zone 1 Temperature 300 - 32080 - 115 °C Mold Temperature **Back Pressure** 0.3 - 0.7MPa Screw Speed 40 - 70 rpm Shot to Cylinder Size 40 - 60 % Vent Depth 0.025 - 0.076 mm

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CHEMISTRY THAT MATTERS



- (1) The information stated on Technical Datasheets should be used as indicative only for material selection purposes and not be utilized as specification or used for part or tool design.
- (2) Measurements made from laboratory test coupon. Actual shrinkage may vary outside of range due to differences in processing conditions, equipment, part geometry and tool design. It is recommended that mold shrinkage studies be performed with surrogate or legacy tooling prior to cutting tools for new molded article. The information stated on Technical Datasheets should be used as indicative only for material selection purposes and not be utilized as specification or used for part or tool design.
- (3) Injection Molding parameters are only mentioned as general guidelines. These may not apply or may need adjustment in specific situations such as low shot sizes, large part molding, thin wall molding and gas-assist molding.

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