

LEXANTM FR RESIN LUX7189

REGION ASIA

DESCRIPTION

LEXAN LUX7189 is an injection moldable polycarbonate (PC) with an MVR (300°C/1.2kg) 23. It contains non-brominated, non-chlorinated flame retardant systems with UL-94 V0@1.5mm rating. It is designed for high light reflectance and shielding applications with good UV weathering capability.

TYPICAL PROPERTY VALUES

Revision 20250513

PROFERTIES TYPICAL VALUES UNITS EST METHODS MECHANICAL Tersile Stress, yid, Type 1, 50 mm/min 60 Man ASTM 0638 Tersile Stress, jid, Type 1, 50 mm/min 92 Man ASTM 0638 Tersile Stress, jid, Type 1, 50 mm/min 10 % ASTM 0638 Tersile Strain, jid, Type 1, 50 mm/min 110 % ASTM 0638 Tersile Strain, jid, Type 1, 50 mm/min 100 Man ASTM 0638 Tersile Strain, jid, Type 1, 50 mm/min 100 Man ASTM 0638 Tersile Strain, jid, Type 1, 50 mm/min 100 Man ASTM 0790 Flexural Stress, yid, 1,3 mm/min, 50 mm span 8 Man ASTM 0790 Flexural Modulus, 1,3 mm/min, 50 mm span 170 ASTM 0790 MPACT Tersile Strain, jid, Type 1,50 mm/min ASTM 0790 Broad impact, notched, 23°C 150 Jim ASTM 0792 Ized Impact, notched, 23°C 150 Jim ASTM 0792 Ized Mipact, notched, 23°C 150 ASTM 0792 ASTM 0792 Ized Martination Strain Strain Strain Strain Strain Strain Stra				
Tensile Stress, brd, Type I, 50 mm/min 60 MPa ASTM D638 Tensile Stress, brk, Type I, 50 mm/min 52 MPa ASTM D638 Tensile Strain, Jrk, Type I, 50 mm/min 10 % ASTM D638 Tensile Strain, Jrk, Type I, 50 mm/min 10 % ASTM D638 Tensile Modulus, 50 mm/min, 50 mm span 2700 MPa ASTM D638 Beward Modulus, 13 mm/min, 50 mm span 200 MPa ASTM D698 Beward Modulus, 13 mm/min, 50 mm span 200 MPa ASTM D698 Beward Modulus, 13 mm/min, 50 mm span 20 MPa ASTM D698 Beward Modulus, 13 mm/min, 50 mm span 20 MPa ASTM D698 Beward Modulus, 13 mm/min, 50 mm span 20 MPa ASTM D698 Beward Modulus, 13 mm/min, 50 mm span 20 MPa ASTM D698 Beward Modulus, 13 mm/min, 50 mm span 21 MPa ASTM D698 Book Indigentil Modulus, 13 mm/min, 50 mm span 21 MSTM D698 ASTM D698 Book Indigentil Modulus, 13 mm/min, 50 mm span 10 MSTM D698 ASTM D698 <td< th=""><th>PROPERTIES</th><th>TYPICAL VALUES</th><th>UNITS</th><th>TEST METHODS</th></td<>	PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Tensile Stress, br. k, Type I, 50 mm/min 52 MPa ASTM D638 Tensile Strain, Jrd, Type I, 50 mm/min 6 4 ASTM D638 Tensile Modulus, 50 mm/min 2700 MPa ASTM D638 Flexural Stress, Jrd, 1.3 mm/min, 50 mm span 9 MPa ASTM D790 Flexural Stress, Jrd, 1.3 mm/min, 50 mm span 9 MPa ASTM D790 MDACT V MPa ASTM D4812 Evod Impact, notched, 23°C 2140 Jm ASTM D256 Izod Impact, notched, 23°C 150 Jm ASTM D256 Izod Impact, notched, 23°C 350 Jm ASTM D256 Izod Impact, notched, 23°C 350 ASTM D256 ASTM D256 Izod Impact, notched, 23°C 350 ASTM D256 ASTM D256 Izod	MECHANICAL			
Tensile Strain, Iyd. Type I, 50 mm/min 6 % ASTM D638 Tensile Strain, Ixf. Type I, 50 mm/min 110 % ASTM D638 Tensile Modulus, 50 mm/min 98 MPa ASTM D638 Flexural Modulus, 1.3 mm/min, 50 mm span 92 MPa ASTM D790 Hexural Modulus, 1.3 mm/min, 50 mm span 270 MPa ASTM D790 Implication of Minach, unnotched, 23°C 210 MPa ASTM D4812 Izod Impact, unnotched, 23°C 150 J/m ASTM D4812 Izod Impact, notched, 30°C 10 J/m ASTM D4812 Izod Impact, notched, 30°C 10 J/m ASTM D4812 Izod Impact, notched, 30°C 30 ASTM D256 Izod Impact, notched, 30°C 30 ASTM D482 Izod Impact, notched, 30°C 30 ASTM D483 Izod Impact, notched, 30°C 30 ASTM D486 Izod Impact, notched, 30°C 30 ASTM D484 Izod Impact, notched, 30°C 30 ASTM D484 Izod Impact, notched, 30°C 30 ASTM D484 Izod	Tensile Stress, yld, Type I, 50 mm/min	60	MPa	ASTM D638
Tensile Strain, brk, Type 1.50 mm/min 110 % ASTM D638 Tensile Modulus, 50 mm/min 2700 MPa ASTM D638 Resural Stress, yld, 1.3 mm/min, 50 mm span 2700 MPa ASTM D790 Besural Modulus, 1.3 mm/min, 50 mm span 2700 MPa ASTM D790 IMPACT U Jim ASTM D780 Impact, unnotched, 23°C 2140 Jim ASTM D256 Izod Impact, notched, 30°C 100 Jim ASTM D256 Izod Impact, notched, 30°C 100 Jim ASTM D256 Izod Impact, notched, 30°C 80 3 ASTM D568 Izod Impact, notched, 30°C 80 3 ASTM D568 Izod Impact, notched, 30°C 80 ASTM D568 Izod Impact, notched, 30°C 4 ASTM D568 Izod Impact, notched, 30°C ASTM D568 ASTM D568 Izo	Tensile Stress, brk, Type I, 50 mm/min	52	MPa	ASTM D638
Tensile Modulus, 50 mm/min 2700 MRG ASTM D638 Flexural Modulus, 1.3 mm/min, 50 mm span 98 MRG ASTM D790 Flexural Modulus, 1.3 mm/min, 50 mm span 2700 MRG ASTM D790 TMPACT V V ASTM D4812 Izod Impact, unnotched, 23°C 2140 Jm ASTM D4812 Izod Impact, notched, 30°C 100 Jm ASTM D256 Izod Impact, notched, 30°C 100 Jm ASTM D256 Izot Impact, notched, 30°C 100 Jm ASTM D256 Izot Impact, notched, 30°C 100 Jm ASTM D525 Izot Impact, notched, 30°C 100 Jm ASTM D526 Izot Impact, notched, 30°C 35 ASTM D526 MTG Izot Softening Temp, Rate B/50 140 C ASTM D648 IDT, 0.45 MPa, 3.2 mm, unannealed 155 C ASTM D648 IEC, 40°C to 40°C, flow 6.50 17°C ASTM D792 IDT, 40°C to 40°C, flow 5.50 30 ASTM D792 Design Gravity 5 <td>Tensile Strain, yld, Type I, 50 mm/min</td> <td>6</td> <td>%</td> <td>ASTM D638</td>	Tensile Strain, yld, Type I, 50 mm/min	6	%	ASTM D638
Flexural Stress, yid, 1.3 mm/min, 50 mm span 98 MPa ASTM D790 Flexural Modulus, 1.3 mm/min, 50 mm span 2700 MPa ASTM D790 IMPACT Load Impact, unnotched, 23°C 1240 J/m ASTM D452 Izod Impact, notched, 23°C 100 J/m ASTM D256 Izod Impact, notched, 23°C 100 J/m ASTM D256 Izotal Impact Energy@peak, 23°C 90 J/m ASTM D256 Instrumented Dart Impact Energy@peak, 23°C 90 J/m ASTM D356 HOT, 458 Mpa, 32 mm, unannealed 440 60 ASTM D1525 BDT, 4.58 MPa, 3.2 mm, unannealed 125 °C ASTM D648 CTL, 40°C to 40°C, flow 15 60 ASTM D648 CTL, 40°C to 40°C, flow 15 7°C ASTM D648 CTL, 40°C to 40°C, flow 3 5 ASTM D648 CTL, 40°C to 40°C, flow 3 5 ASTM D648 CTL, 40°C to 40°C, flow 3 5 ASTM D648 Description 3 9 ASTM	Tensile Strain, brk, Type I, 50 mm/min	110	%	ASTM D638
Bleaval Modulus, 1.3 mm/min, 50 mm span 2700 MPe ASTM D490 IMPACT IMPACT IMPACT IMPACT IMPACT ASTM D4812 IMPACT ASTM D4812 IMPACT ASTM D4812 IMPACT ASTM D4812 IMPACT ASTM D4864 IMPACT IMPACT ASTM D4864	Tensile Modulus, 50 mm/min	2700	MPa	ASTM D638
IMPACT IZOR Impact, unnotched, 23°C 2140 Jm ASTM D4812 Izod Impact, notched, 23°C 150 Jm ASTM D256 Izod Impact, notched, 23°C 150 Jm ASTM D256 Izod Impact, notched, 30°C 150 Jm ASTM D256 Isotrumented Dart Impact Energy@peak, 23°C 59 3 m XSTM D376 THERMAC V ASTM D1525 XSTM D648 HDT, 0.45 MPa, 3.2 mm, unannealed 140 °C ASTM D648 HDT, 1.82 MPa, 3.2 mm, unannealed 125 °C ASTM D648 CTC, 40°C to 40°C, flow 6.05 11°C ASTM D648 CTE, 40°C to 40°C, flow 6.06 ASTM D648 ASTM D648 CTE, 40°C to 40°C, flow 1.3 C ASTM D648 DEVISION 1.3 C ASTM D648 ASTM D648 CTE, 40°C to 40°C, flow 1.3 C ASTM D648 ASTM D648 DEVISION 1.3 C ASTM D648	Flexural Stress, yld, 1.3 mm/min, 50 mm span	98	MPa	ASTM D790
Izod Impact, unnotched, 23°C2140J/mASTM D256Izod Impact, notched, 23°C150J/mASTM D256Izod Impact, notched, 30°C100J/mASTM D256Instrumented Dart Impact Energy @peak, 23°C59J/mASTM D256HERRAML*********************************	Flexural Modulus, 1.3 mm/min, 50 mm span	2700	MPa	ASTM D790
Izod Impact, notched, 23°C 150 J/m ASTM D256 Izod Impact, notched, 30°C 100 J/m ASTM D256 Instrumented Dart Impact Energy@peak, 23°C 59 J ASTM D256 THERMAL Vicat Softening Temp, Rate B/50 140 °C ASTM D255 HDT, 0.45 MPa, 3.2 mm, unannealed 125 °C ASTM D648 HDT, 1.82 MPa, 3.2 mm, unannealed 125 °C ASTM D648 CTE, 40°C to 40°C, flow 6.265 10°C ASTM D648 CTE, 40°C to 40°C, xflow 6.56.95 10°C ASTM D648 PHYSICAL SECULTION TO TABLE MEDICAL STRUMBART MED ASTM D648 Density 1.3 2.0 ASTM D792 Mold Shrinkage, flow, 3.2 mm 2.5 ASTM D792 Met Flow Rate, 300°C/1.2 kgf 5.0 3.0 ASTM D792 Make Flow Rate, 300°C/1.2 kgf 2.5 ASTM D792 UR Recognized, 94.90 Flame Class Rating 3.2 m U.94 UR Recognized, 94.95 Flame Class Rating 2.0 C L </td <td>IMPACT</td> <td></td> <td></td> <td></td>	IMPACT			
Ize of Impact, notched, -30°C 100 J/m ASM D256 Instrumented Dart Impact Energy@peak, 23°C 59 J ASTM D3763 THERMAL Vicat Softening Temp, Rate B/50 140 °C ASTM D525 HDT, 0.45 MPa, 3.2 mm, unannealed 135 °C ASTM D648 HDT, 182 MPa, 3.2 mm, unannealed 125 °C ASTM D648 CTE, -40°C to 40°C, flow 5.650 1/°C ASTM D648 CTE, 40°C to 40°C, flow 1.3 °C ASTM D792 HYBSICAL VESCHI'c Gravity 1.3 °C ASTM D792 Desity 1.3 °C ASTM D792 Mold Shrinkage, flow, 3.2 mm 0.5 − 0.7 % ASTM D792 Mold Shrinkage, flow, 3.2 mm 0.5 − 0.7 % ASTM D1238 HUB Recognized, 94°-0 Flame Class Rating 1.5 mm U.94 UR Recognized, 94°-0 Flame Class Rating 3 mm U.94 UR Recognized, 94°-0 Flame Class Rating 3 Mm U.94 UR SCHOLL	Izod Impact, unnotched, 23°C	2140	J/m	ASTM D4812
Instrumented Dart Impact Energy@peak, 23°C 99 1 ASM D3763 THERMAL Vicat Softening Temp, Rate B/50 140 °C ASTM D1525 HDT, 0.45 MPa, 3.2 mm, unannealed 135 °C ASTM D648 HDT, 1.82 MPa, 3.2mm, unannealed 125 °C ASTM D648 CEC. 40°C to 40°C, flow 1.2°C ASTM D648 ASTM D648 CEC. 40°C to 40°C, flow 5.60.5 1/°C ASTM D648 CEC. 40°C to 40°C, flow 5.60.5 1/°C ASTM D648 CPL 40°C to 40°C, flow 5.50.5 9.0 ASTM D792 DEPRISE Specific Gravity 1.3 9.0 ASTM D792 Deprise 9.0 ASTM D792 ASTM D792 Bonkity Flow Rate, 300°C/1.2 kgf 2.0 2.0 9.0 ASTM D792 BOLA SCALLER 1.5 Mm D1.9 ASTM D792 BOLA SCALLER 1.0 Mm D1.9 ASTM D792 BOLA SCALLER 1.0 Mm <td>Izod Impact, notched, 23°C</td> <td>150</td> <td>J/m</td> <td>ASTM D256</td>	Izod Impact, notched, 23°C	150	J/m	ASTM D256
THERMAL Vicat Softening Temp, Rate B/50 140 °C ASTM D1525 HDT, 0.45 MPa, 3.2 mm, unannealed 135 °C ASTM D648 HDT, 1.82 MPa, 3.2 mm, unannealed 125 °C ASTM D648 CTE, 40°C to 40°C, flow 6.605 1/°C ASTM E831 CTE, 40°C to 40°C, xflow 5.605 1/°C ASTM E831 PHYSICAE Specific Gravity 1.3 5 (m²) ASTM D792 Density 1.3 5 (m²) ASTM D792 Mold Shrinkage, flow, 3.2 mm 5.5 - 0.7 % ASTM D792 Melt Flow Rate, 300°C/1.2 kgf 22 yl 0min ASTM D1238 FLAME CHARACTERISTICS UL Recognized, 94-5VB Flame Class Rating 1.5 mm U. 94 UL Recognized, 94-5VB Flame Class Rating 3 mm U. 94 UL Recognized, 94-5VB Flame Class Rating 2.5 mm U. 94 USECTION MOLDING ** ** Drying Temperature 2 ** ** Dry	Izod Impact, notched, -30°C	100	J/m	ASTM D256
Vicat Softening Temp, Rate B/50 140 °C ASTM D1525 HDT, 0.45 MPa, 3.2 mm, unannealed 135 °C ASTM D648 HDT, 1.82 MPa, 3.2 mm, unannealed 125 °C ASTM D648 CTE, 40°C to 40°C, folow 6.605 1/°C ASTM E831 CTE, 40°C to 40°C, folow 5.605 1/°C ASTM E831 CTE, 40°C to 40°C, folow 5.605 1/°C ASTM E831 CTE, 40°C to 40°C, folow 5.605 1/°C ASTM E831 CTE, 40°C to 40°C, folow 5.605 1/°C ASTM E831 CTE, 40°C to 40°C, folow 5.605 1.9°C ASTM E831 CTEM, 40°C to 40°C, folow 5.605 9.0°C ASTM E831 CTEM, 40°C to 40°C, folow 5.0°C 9.0°C ASTM E831 Description Folow, 3.2 mm 5.0°C 9.0°C 9.0°C LOS ASSISTANCE 5.0°C 9.0°C 9.0°C LOS ASSISTANCE 5.0°C 9.0°C 9.0°	Instrumented Dart Impact Energy @ peak, 23°C	59	J	ASTM D3763
HDT, 0.45 MPa, 3.2 mm, unannealed 155 °C ASTM D648 HDT, 1.82 MPa, 3.2 mm, unannealed 125 °C ASTM D648 CTE, 40°C to 40°C, flow 6.605 1/°C ASTM E831 CTE, 40°C to 40°C, flow 6.605 1/°C ASTM E831 CTE, 40°C to 40°C, flow 6.605 1/°C ASTM E831 CTE, 40°C to 40°C, flow 1.3 - ASTM E831 PMSICAL V V ASTM E831 PMSICAL J ASTM D792 ASTM D792 Mold Shrinkage, flow, 3.2 mm 1.3 3.6 ASTM D792 Mold Shrinkage, flow, 3.2 mm 2.5 7.7 % ASTM D792 Melt Flow Rate, 300°C/1.2 kgf 2.5 2.7 % ASTM D193 ASTM D193 UL Recognized, 94-Vo Flame Class Rating 1.5 mm UL 94 MIS UL Recognized, 94-SVB Flame Class Rating 2.5 mm UL 94 MIS INJECTION MOLDING C C C C Drying Time C C C	THERMAL			
HDT, 1.82 MPa, 3.2mm, unannealed 125 °C ASTM D648 CTE, 40°C to 40°C, flow 6.605 1,°C ASTM E831 CTE, 40°C to 40°C, xflow 5.605 1,°C ASTM E831 PHYSICAL Specific Gravity 3.3 - ASTM D792 Boensity 1.3 ycm³ ASTM D792 Mold Shrinkage, flow, 3.2 mm 0.5 − 0.7 % SABIC method Melt Flow Rate, 300°C/1.2 kgf 2 yl min ASTM D1238 FLAME CHARACTERISTICS mm U.94 UL Recognized, 94-V0 Flame Class Rating 3 mm U.94 UL Recognized, 94-SV3 Flame Class Rating 3 mm U.94 UL Recognized, 94-SV3 Flame Class Rating 3 mm U.94 INJECTION MOLDING T T T Drying Temperature 3 4 Hs T Drying Time (Cumulative) 48 Hs T T T T T T T T T T T	Vicat Softening Temp, Rate B/50	140	°C	ASTM D1525
CTE, 40°C to 40°C, flow6.6.051/°CASTM E831CTE, 40°C to 40°C, xflow6.56.051/°CASTM E831PHYSICALSpecific Gravity1.3-ASTM D792Density1.3g/cm³ASTM D792Mold Shrinkage, flow, 3.2 mm0.5 − 0.7% D8IC methodMelt Flow Rate, 300°C/1.2 kgf2g/10 minASTM D1238FLAME CHARACTERISTICSUL Recognized, 94-0 Flame Class Rating1.5mmU.94UL Recognized, 94-5VR Flame Class Rating3mmU.94UL Recognized, 94-5VB Flame Class Rating2.5mmU.94INJECTION MOLDINGTyring Temperature120°CDrying Temperature3 − 4HrsDrying Time (Cumulative)48HrsMaximum Moisture Content0.02%Maximum Moisture Content270 − 295°C	HDT, 0.45 MPa, 3.2 mm, unannealed	135	°C	ASTM D648
CTE, 40°C to 40°C, xflow5.5E.051/°CASTM E831PHYSICALSpecific Gravity1.32ASTM D792Density1.33ASTM D792Mold Shrinkage, flow, 3.2 mm0.5 − 0.7%ASTM D792Melt Flow Rate, 300°C/1.2 kgf223LAME CHARACTERISTICSUL Recognized, 94-V9 Flame Class Rating1.5mmUL 94UL Recognized, 94-SVA Flame Class Rating3mmUL 94UL Recognized, 94-SVB Flame Class Rating25mmUL 94INJECTION MOLDINGTyring Temperature120°CDrying Time3 − 4HrsDrying Time (Cumulative)48HrsMaximum Moisture Content0.02%Helt Temperature270 − 295°C	HDT, 1.82 MPa, 3.2mm, unannealed	125	°C	ASTM D648
PHYSICAL Specific Gravity 1.3 Mold Shrinkage, flow, 3.2 mm Mol	CTE, -40°C to 40°C, flow	6.E-05	1/°C	ASTM E831
Specific Gravity1.3-ASTM D792Density1.3g/cm³ASTM D792Mold Shrinkage, flow, 3.2 mm0.5 - 0.7%ABIC methodMelt Flow Rate, 300°C/1.2 kgf22y/10 minASTM D1238ELAME CHARACTERISTICSUL Recognized, 94V-0 Flame Class Rating1.5mmUL 94UL Recognized, 94-5VA Flame Class Rating3mmUL 94UL Recognized, 94-5VB Flame Class Rating2.5mmUL 94UL Recognized, 94-5VB Flame Class Rating2.5mmUL 94INJECTION MOLDINGDrying Temperature120°CDrying Time3 - 4HrsDrying Time (Cumulative)48HrsMaximum Moisture Content0.02%Melt Temperature270 - 295°C	CTE, -40°C to 40°C, xflow	6.5E-05	1/°C	ASTM E831
Density Mold Shrinkage, flow, 3.2 mm Melt Flow Rate, 300°C/1.2 kgf UL Recognized, 94V-0 Flame Class Rating UL Recognized, 94-5VA Flame Class Rating UL Recognized, 94-5VB Flame Class Rating Dying Temperature Drying Time Cumulative) Maximum Moisture Content Maximum Moisture Content Donator 1.3 1.5 1.5 1.5 1.5 1.5 1.5 1.5	PHYSICAL			
Mold Shrinkage, flow, 3.2 mm Melt Flow Rate, 300°C/1.2 kgf 22 22 3/10 min ASTM D1238 FLAME CHARACTERISTICS UL Recognized, 94V-0 Flame Class Rating 1.5 Min Min Min Min Min Min Min Mi	Specific Gravity	1.3	-	ASTM D792
Melt Flow Rate, 300°C/1.2 kgf FLAME CHARACTERISTICS UL Recognized, 94V-0 Flame Class Rating UL Recognized, 94-5VA Flame Class Rating UL Recognized, 94-5VB Flame Class Rating UL Recognized, 94-5VB Flame Class Rating UL Recognized, 94-5VB Flame Class Rating UL 94 UL 94	Density	1.3	g/cm³	ASTM D792
FLAME CHARACTERISTICS UL Recognized, 94V-0 Flame Class Rating UL Recognized, 94-5VA Flame Class Rating UL Recognized, 94-5VB Flame Class Rating UL Recognized, 94-5VB Flame Class Rating Du Recognized, 94-5VB Flame Class Rating 120 Drying Temperature Drying Time 120 3-4 Hrs Drying Time (Cumulative) 48 Hrs Maximum Moisture Content Maximum Moisture Content 120 270-295 CC CC CC CC CC CC CC CC CC	Mold Shrinkage, flow, 3.2 mm	0.5 – 0.7	%	SABIC method
UL Recognized, 94V-0 Flame Class Rating1.5mmUL 94UL Recognized, 94-5VA Flame Class Rating3mmUL 94UL Recognized, 94-5VB Flame Class Rating2.5mmUL 94INJECTION MOLDINGDrying Temperature120°C**Drying Time3-4HrsDrying Time (Cumulative)48HrsMaximum Moisture Content0.02%Melt Temperature270-295°C	Melt Flow Rate, 300°C/1.2 kgf	22	g/10 min	ASTM D1238
UL Recognized, 94-5VA Flame Class Rating 3 mm UL 94 UL Recognized, 94-5VB Flame Class Rating 2.5 mm UL 94 INJECTION MOLDING Drying Temperature 120 °C Drying Time (Cumulative) 48 Hrs Maximum Moisture Content 200.02 % Melt Temperature 200.02 °C C'C C'C C'C C'C C'C C'C C'C	FLAME CHARACTERISTICS			
UL Recognized, 94-5VB Flame Class Rating 2.5 mm UL 94 INJECTION MOLDING Drying Temperature 120 °C Drying Time (Cumulative) 48 Hrs Maximum Moisture Content 200.2 % Melt Temperature 270 – 295 °C The maximum Moisture Content 270 – 295	UL Recognized, 94V-0 Flame Class Rating	1.5	mm	UL 94
INJECTION MOLDINGDrying Temperature120°CDrying Time3 - 4HrsDrying Time (Cumulative)48HrsMaximum Moisture Content0.02%Melt Temperature270 - 295°C	UL Recognized, 94-5VA Flame Class Rating	3	mm	UL 94
Drying Temperature 120 °C Drying Time 3 - 4 Hrs Drying Time (Cumulative) 48 Hrs Maximum Moisture Content 0.02 % Melt Temperature 270 - 295 °C	UL Recognized, 94-5VB Flame Class Rating	2.5	mm	UL 94
Drying Time 3 - 4 Hrs Drying Time (Cumulative) 48 Hrs Maximum Moisture Content 0.02 % Melt Temperature 270 - 295 °C	INJECTION MOLDING			
Drying Time (Cumulative) 48 Maximum Moisture Content 0.02 87 Melt Temperature 270 – 295 68 C Hrs 68 C C C C C C C C C C C C C C C C C C	Drying Temperature	120	°C	
Maximum Moisture Content 0.02 % Melt Temperature 270 – 295 °C	Drying Time	3 – 4	Hrs	
Melt Temperature 270 – 295 °C	Drying Time (Cumulative)	48	Hrs	
·	Maximum Moisture Content	0.02	%	
Nozzle Temperature 265 – 290 °C	Melt Temperature	270 – 295	°C	
	Nozzle Temperature	265 – 290	°C	



PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Front - Zone 3 Temperature	270 – 295	°C	
Middle - Zone 2 Temperature	260 – 280	°C	
Rear - Zone 1 Temperature	250 – 270	°C	
Mold Temperature	70 – 95	°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	

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