LEXAN™ FR RESIN SLD3000

DESCRIPTION

Antistatic colorable/opaque FR PC grade

GENERAL INFORMATION	
Features	Flame Retardant, Antistatic, Transparent/Translucent, Non Cl/Br flame retardant
Fillers	Unreinforced
Polymer Types	Polycarbonate (PC)
Processing Techniques	Injection Molding

INDUSTRY	SUB INDUSTRY
Electrical and Electronics	Electronic Components
Industrial	Material Handling

TYPICAL PROPERTY VALUES

Revision 20241025

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL [1]			
Tensile Stress, yield, 50 mm/min	52	MPa	ASTM D638
Flexural Stress, yield, 6.4 mm	80	MPa	ASTM D790
Flexural Modulus	2030	MPa	ASTM D790
Tensile Strain, break, 50 mm/min	200	%	ISO 527
IMPACT [1]			
Izod Impact, notched, 23°C	700	J/m	ASTM D256
THERMAL [1]			
HDT, 1.82 MPa, 6.4 mm, unannealed	100	°C	ASTM D648
PHYSICAL [1]			
Specific Gravity	1.21	-	ASTM D792
Mold Shrinkage, flow, 1.5-3.2 mm [2]	0.4	%	SABIC method
Mold Shrinkage, xflow, 1.5-3.2 mm [2]	0.5	%	SABIC method
Melt Flow Rate, 260°C/2.16 kgf	19	g/10 min	ASTM D1238
ELECTRICAL [1]			
Surface Resistivity [3]	1.2E+12	Ω	ASTM D257
FLAME CHARACTERISTICS [4]			
UL Yellow Card Link	E207780-228454	-	-
UL Recognized, 94V-2 Flame Class Rating	≥1	mm	UL 94
UL Recognized, 94HB Flame Class Rating	≥0.5	mm	UL 94
INJECTION MOLDING [5]			
Drying Temperature	90 – 100	°C	
Drying Time	4 – 6	Hrs	
Drying Time (Cumulative)	8	Hrs	

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Maximum Moisture Content	0.04	%	
Melt Temperature	240 – 260	°C	
Nozzle Temperature	230 – 260	°C	
Front - Zone 3 Temperature	230 – 260	°C	
Middle - Zone 2 Temperature	220 – 255	°C	
Rear - Zone 1 Temperature	220 – 245	°C	
Mold Temperature	30 – 70	°C	
Back Pressure	0.3 – 0.7	MPa	
Screw Speed	40 – 70	rpm	
Shot to Cylinder Size	30 – 80	%	
Vent Depth	0.38 – 0.76	mm	

(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.
(3) Measurement meets requirements as specified in ASTM D4496.
(4) UL Ratings shown on the technical datasheet might not cover the full range of thicknesses and colors. For details, please see the UL Yellow Card.
(5) 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.

DISCLAIMER