

LEXANTM VISUALFXTM RESIN FXE171R

REGION EUROPE

DESCRIPTION

High flow PC. Internal mold release. Thin wall applications. ILLUMINATE special effects (fluorescent/edge glow colors).

TYPICAL PROPERTY VALUES

Revision 20231109

CTE, 23°C to 80°C, flow 7.E-05 1/°C ISO 11359-2 Ball Pressure Test, 125°C +/- 2°C PASSES - IEC 60695-10-2 Vicat Softening Temp, Rate B/50 139 °C ISO 306 Vicat Softening Temp, Rate B/120 140 °C ISO 75/Be HDT/Be, 0.45MPa Edgew 120*10*4 sp=100mm 133 °C ISO 75/Be HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm 121 °C ISO 75/Ae Relative Temp Index, Elec (2) 80 °C UL 746B Relative Temp Index, Mech w/o impact (2) 80 °C UL 746B Relative Temp Index, Mech w/o impact (2) 80 °C UL 746B PHYSICAL (1) V V ABIC method Mold Shrinkage on Tensile Bar, flow (3) 0.5 – 0.7 % SABIC method Density 1,2 g/cm³ ISO 1183	PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Tensile Stress, yield, 50 mm/min 63 MPa ISO 527 Tensile Stress, break, 50 mm/min 50 MPa ISO 527 Tensile Strain, yield, 50 mm/min 6 % ISO 527 Tensile Strain, break, 50 mm/min 70 % ISO 527 Tensile Modulus, 1 mm/min 2350 MPa ISO 178 Flexural Stress, yield, 2 mm/min 90 MPa ISO 178 Ball Indentation Hardness, H358/30 90 MPa ISO 180/18 Ball Indentation Hardness, H358/30 MB IsO 180/19 ISO 180/10 Izod Impact, unnotched 80°10°3 +23°C MB Id/m² ISO 180/10 Izod Impact, unnotched 80°10°3 -23°C MB Id/m² ISO 180/10 Izod Impact, notched 80°10°3 -30°C 11 Id/m² ISO 180/10 Izod Impact, notched 80°10°3 sp-62mm 60 Id/m² ISO 180/14 Charpy 23°C, Venotch Edgew 80°10°3 sp-62mm 12 Id/m² ISO 179/1eA Charpy 23°C, Unnotch Edgew 80°10°3 sp-62mm NB Id/m² ISO 179/1eA Charpy 23°C, Unnotch Edgew 80°10°3 sp-62mm <td< td=""><td>MECHANICAL (1)</td><td></td><td></td><td></td></td<>	MECHANICAL (1)			
Tensile Stress, break, 50 mm/min 50 MPa ISO 527 Tensile Strain, yield, 50 mm/min 6 4 8 105 27 Tensile Strain, yield, 50 mm/min 70 % 105 27 Tensile Modulus, 1 mm/min 2350 MPa 100 78 Flexural Stress, yield, 2 mm/min 90 MPa 100 178 Ball Indentation Hardness, H358/30 95 MPa 100 178 Ball Indentation Hardness, H358/30 95 MPa 100 178 IMPACT (***)** VIII.** ISO 180 [10 Izod Impact, unnotched 80*10*3 +23**C NB MI/m² 100 180 [10 Izod Impact, unnotched 80*10*3 -30**C 10 MI/m² 100 180 [10 Izod Impact, notched 80*10*3 -30**C 10 MI/m² 100 180 [10 Izod Impact, notched 80*10*3 -30**C 10 MI/m² 10 180 [10 Charpy 23**C, Vnotch Edgew 80*10*3 sp=62mm 10 MI/m² 10 179 [10 Charpy 23**C, Unnotch Edgew 80*10*3 sp=62mm NB MI/m² 10 179 [10 Charpy 23**C, Unnotch Edgew 80*10*3 sp=62mm 72.00 <t< td=""><td></td><td>63</td><td>MPa</td><td>ISO 527</td></t<>		63	MPa	ISO 527
Tensile Strain, yield, 50 mm/min 6 % ISO 527 Tensile Strain, break, 50 mm/min 70 % ISO 527 Tensile Modulus, 1 mm/min 2350 MPa ISO 527 Flexural Modulus, 2 mm/min 2300 MPa ISO 178 Ball Indentation Hardness, H358/30 95 MPa ISO 180/14 Impact "** ISO 180/14 ISO 180/14 ISO 180/14 Impact "** ISO 180/14 ISO 180/14 ISO 180/14 Impact unnotched 80*10*3*42** MB Impact with Marked 80*10*3*30** ISO 180/14 ISO 180/14 Izod Impact, unnotched 80*10*3*30** MB Impact with Marked 80*10** ISO 180/14 ISO 180/14 Izod Impact, untotched 80*10*3*3*p=62mm 10 Id/m² ISO 180/14 ISO 19/16A Charpy 23*C, Unnotch Edgew 80*10*3*3*p=62mm 10 Id/m² ISO 179/16A ISO 179/16A Charpy 23*C, Unnotch Edgew 80*10*3*3*p=62mm NB Id/m² ISO 179/16A ISO 179/16A Charpy 23*C, Unnotch Edgew 80*10*3*3*p=62mm RB Izo 25 Izo 25 Izo 25 Izo 25 <				
Tensile Strain, break, 50 mm/min 70 % ioo 527 Tensile Modulus, 1 mm/min 2350 MPa 150 527 Flexural Stress, yield, 2 mm/min 90 MPa 150 178 Ball Indentation Hardness, H358/30 95 MPa 150 78 IMPACT (*)***********************************	•			
Tensile Modulus, 1 mm/min 2350 MPa ISO 527 Flexural Stress, yield, 2 mm/min 90 MPa ISO 178 Flexural Modulus, 2 mm/min 2300 MPa ISO 178 Ball Indentation Hardness, H358/30 95 MPa ISO 180/10 IMPACT (**)**** VIII VIII VIII VIII Izod Impact, unnotched 80*10*3 +33°C NB KI/m² ISO 180/10 VIII Izod Impact, unnotched 80*10*3 +32°C NB KI/m² ISO 180/10 VIII Izod Impact, notched 80*10*3 +32°C NB KI/m² ISO 180/10 VIII Izod Impact, notched 80*10*3 +32°C 11 KI/m² ISO 180/10 VIII Izod Impact, notched 80*10*3 +32°C 11 KI/m² ISO 180/14 VIII Izod Impact, notched 80*10*3 +32°C 11 KI/m² ISO 180/14 VIII Charpy 30*C, Vinotch Edgew 80*10*3 spe62mm 12 KI/m² ISO 179/14 VIII Charpy 30*C, Unnotch Edgew 80*10*3 spe62mm NB I/l² ISO 180/13 VIII THEMAL (**)****				
Flexural Stress, yield, 2 mm/min 90 MPa ISO 178 Flexural Modulus, 2 mm/min 2300 MPa ISO 178 Ball Indentation Hardness, H358/30 95 MPa ISO 2039-1 IMPACT (1) Lizod Impact, unnotched 80°10°3 +23°C NB M/ Im² ISO 180/1U Izod Impact, unnotched 80°10°3 +23°C NB M/ Im² ISO 180/1U Izod Impact, untoched 80°10°3 +23°C 11 M/ Im² ISO 180/1A Izod Impact, untoched 80°10°3 +23°C 10 M/ Im² ISO 180/1A Izod Impact, untoched 80°10°3 +23°C 11 M/ Im² ISO 180/1A Izod Impact, untoched 80°10°3 +23°C 11 M/ Im² ISO 180/1A Izod Impact, untoched 80°10°3 +23°C 12 M/ Im² ISO 180/1A Charpy 30°C, Unnotch Edgew 80°10°3 sp=62mm 18 M/ Im² ISO 179/1eA Charpy 30°C, Unnotch Edgew 80°10°3 sp=62mm NB M/ Im² ISO 179/1eA Charpy 30°C, Unnotch Edgew 80°10°3 sp=62mm 76 ISO 179/1eA ISO 179/1eA Charpy 30°C, Unnotch Edgew 80°10°3 sp=62mm 76 ISO 180/1eA	•			
Flexural Modulus, 2 mm/min 2300 MPa ISO 178 Ball Indentation Hardness, H358/30 95 MPa ISO 2039-1 IMPACT ⁽¹⁾ IMPACT ⁽¹⁾ ISO 180/1U Izod Impact, unnotched 80*10*3 +23*°C NB kl/m² ISO 180/1U Izod Impact, unnotched 80*10*3 +23*°C 60 kl/m² ISO 180/1A Load Impact, notched 80*10*3 +39*°C 11 kl/m² ISO 180/1A Charpy 23*°C, V-notch Edgew 80*10*3 sp=62mm 60 kl/m² ISO 179/1eA Charpy 23*°C, V-notch Edgew 80*10*3 sp=62mm 12 kl/m² ISO 179/1eA Charpy 23*°C, Unnotch Edgew 80*10*3 sp=62mm NB kl/m² ISO 179/1eA Charpy 30*°C, Unnotch Edgew 80*10*3 sp=62mm NB kl/m² ISO 179/1eA Charpy 30*°C, Unnotch Edgew 80*10*3 sp=62mm NB kl/m² ISO 179/1eA Charpy 30*°C, Unnotch Edgew 80*10*3 sp=62mm NB kl/m² ISO 179/1eA Charpy 30*°C, How S0 *1359-2 ISO 179/1eA ISO 179/1eA HEKEMAL (**) *** IEC 60695-10-2 IEC 60695-10-2 IEC 60695-10-2 IEC 60695-10				
Ball Indentation Hardness, H358/30 95 MPa ISO 2039-1 IMPACT (1) IMPACT	, ,			
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Charpy-30°C, V-notch Edgew 80°10°3 sp=62mm 12 kJ/m² ISO 179/1eA Charpy-30°C, Unnotch Edgew 80°10°3 sp=62mm NB kJ/m² ISO 179/1eU Charpy-30°C, Unnotch Edgew 80°10°3 sp=62mm NB kJ/m² ISO 179/1eU THERMAL (1) THERMAL (23°C to 80°C, flow 7.E-05 1/°C ISO 11359-2 Ball Pressure Test, 125°C +/- 2°C PASSES - IEC 60695-10-2 Vicat Softening Temp, Rate B/50 139 °C ISO 306 Vicat Softening Temp, Rate B/120 140 °C ISO 306 HDT/Be, 0.45MPa Edgew 120°10°4 sp=100mm 133 °C ISO 75/Be HDT/Ae, 1.8 MPa Edgew 120°10°4 sp=100mm 121 °C ISO 75/Ae Relative Temp Index, Elec (2) 80 °C UL 746B Relative Temp Index, Mech w/o impact (2) 80 °C UL 746B PHYSICAL (1) SABIC method Density 5.C ABIC method				,
Charpy 23°C, Unnotch Edgew 80°10°3 sp=62mm NB kJ/m² ISO 179/1eU Charpy -30°C, Unnotch Edgew 80°10°3 sp=62mm NB kJ/m² ISO 179/1eU THERMAL (1) CTE, 23°C to 80°C, flow 7.E-05 1/°C ISO 11359-2 Ball Pressure Test, 125°C +/- 2°C PASSES - IEC 60695-10-2 Vicat Softening Temp, Rate B/50 139 °C ISO 306 Vicat Softening Temp, Rate B/120 140 °C ISO 306 HDT/Be, 0.45MPa Edgew 120°10°4 sp=100mm 133 °C ISO 75/Be HDT/Ae, 1.8 MPa Edgew 120°10°4 sp=100mm 121 °C ISO 75/Ae Relative Temp Index, Elec (2) 80 °C UL 746B Relative Temp Index, Mech w/o impact (2) 80 °C UL 746B Relative Temp Index, Mech w/o impact (2) 80 °C UL 746B PHYSICAL (1) Wold Shrinkage on Tensile Bar, flow (3) 0.5 – 0.7 % SABIC method Density 1.2 9/cm³ ISO 1183			,	•
Charpy -30°C, Unnotch Edgew 80°10°3 sp=62mm NB kJ/m² ISO 179/1eU THERMAL (¹) CTE, 23°C to 80°C, flow 7.E·05 1/°C ISO 11359-2 Ball Pressure Test, 125°C +/- 2°C PASSES - IEC 60695-10-2 Vicat Softening Temp, Rate B/50 139 °C ISO 306 Vicat Softening Temp, Rate B/120 140 °C ISO 306 HDT/Be, 0.45MPa Edgew 120°10°4 sp=100mm 133 °C ISO 75/Be HDT/Ae, 1.8 MPa Edgew 120°10°4 sp=100mm 121 °C ISO 75/Ae Relative Temp Index, Elec (²) 80 °C UL 746B Relative Temp Index, Mech w/impact (²) 80 °C UL 746B Relative Temp Index, Mech w/o impact (²) 80 °C UL 746B PHYSICAL (¹) UL 746B VIC VIC PHYSICAL (¹) SABIC method SABIC method Density 1.2 g/cm³ ISO 1183	Charpy -30°C, V-notch Edgew 80*10*3 sp=62mm		kJ/m²	ISO 179/1eA
THERMAL (1) CTE, 23°C to 80°C, flow 7.E-05 ROSSES - IEC 60695-10-2 Vicat Softening Temp, Rate B/50 Vicat Softening Temp, Rate B/120 HDT/Be, 0.45MPa Edgew 120*10*4 sp=100mm 133 *C Relative Temp Index, Elec (2) Relative Temp Index, Mech w/impact (2) Relative Temp Index, Mech w/o impact (2) Relative Temp Index, Mech w/o impact (2) Relative Temp Index, Mech w/o impact (2) Roll O.5 – 0.7 *S *ABIC method *A				
CTE, 23°C to 80°C, flow 7.E-05 1/°C ISO 11359-2 Ball Pressure Test, 125°C +/- 2°C PASSES - IEC 60695-10-2 Vicat Softening Temp, Rate B/50 139 °C ISO 306 Vicat Softening Temp, Rate B/120 140 °C ISO 75/Be HDT/Be, 0.45MPa Edgew 120*10*4 sp=100mm 133 °C ISO 75/Be HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm 121 °C ISO 75/Ae Relative Temp Index, Elec (2) 80 °C UL 746B Relative Temp Index, Mech w/o impact (2) 80 °C UL 746B Relative Temp Index, Mech w/o impact (2) 80 °C UL 746B PHYSICAL (1) V V ABIC method Mold Shrinkage on Tensile Bar, flow (3) 0.5 – 0.7 % SABIC method Density 1,2 g/cm³ ISO 1183	Charpy -30°C, Unnotch Edgew 80*10*3 sp=62mm	NB	kJ/m²	ISO 179/1eU
Vicat Softening Temp, Rate B/50 Vicat Softening Temp, Rate B/120 V	THERMAL (1)			
Vicat Softening Temp, Rate B/50 139 °C ISO 306 Vicat Softening Temp, Rate B/120 140 °C ISO 306 HDT/Be, 0.45MPa Edgew 120*10*4 sp=100mm 133 °C ISO 75/Be HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm 121 °C ISO 75/Ae Relative Temp Index, Elec (2) 80 °C UL 746B Relative Temp Index, Mech w/impact (2) 80 °C UL 746B Relative Temp Index, Mech w/o impact (2) 80 °C UL 746B PHYSICAL (1) UL 746B C UL 746B Mold Shrinkage on Tensile Bar, flow (3) 0.5 – 0.7 % SABIC method Density 1.2 g/cm³ ISO 1183	CTE, 23°C to 80°C, flow	7.E-05	1/°C	ISO 11359-2
Vicat Softening Temp, Rate B/120 140 °C ISO 306 HDT/Be, 0.45MPa Edgew 120*10*4 sp=100mm 133 °C ISO 75/Be HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm 121 °C ISO 75/Ae Relative Temp Index, Elec (2) 80 °C UL 746B Relative Temp Index, Mech w/nimpact (2) 80 °C UL 746B Relative Temp Index, Mech w/o impact (2) 80 °C UL 746B PHYSICAL (1) V V V ABIC method Mold Shrinkage on Tensile Bar, flow (3) 0.5 – 0.7 % SABIC method Density 1.2 g/cm³ ISO 1183	Ball Pressure Test, 125°C +/- 2°C	PASSES	-	IEC 60695-10-2
HDT/Be, 0.45MPa Edgew 120*10*4 sp=100mm 133 °C ISO 75/Be HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm 121 °C ISO 75/Ae Relative Temp Index, Elec (2) 80 °C UL 746B Relative Temp Index, Mech w/impact (2) 80 °C UL 746B Relative Temp Index, Mech w/o impact (2) 80 °C UL 746B PHYSICAL (1) Wold Shrinkage on Tensile Bar, flow (3) 0.5 – 0.7 % SABIC method Density 1.2 g/cm³ ISO 1183	Vicat Softening Temp, Rate B/50	139	°C	ISO 306
HDT / Ae, 1.8 MPa Edgew 120*10*4 sp=100mm 121 °C ISO 75 / Ae Relative Temp Index, Elec (2) 80 °C UL 746B Relative Temp Index, Mech w/impact (2) 80 °C UL 746B Relative Temp Index, Mech w/o impact (2) 80 °C UL 746B PHYSICAL (1) Wold Shrinkage on Tensile Bar, flow (3) 0.5 – 0.7 % SABIC method Density 1.2 g/cm³ ISO 1183	Vicat Softening Temp, Rate B/120	140	°C	ISO 306
Relative Temp Index, Elec (2) Relative Temp Index, Mech w/impact (2) Relative Temp Index, Mech w/o impact (2) R	HDT/Be, 0.45MPa Edgew 120*10*4 sp=100mm	133	°C	ISO 75/Be
Relative Temp Index, Mech w/impact (2) 80 °C UL 746B Relative Temp Index, Mech w/o impact (2) 80 °C UL 746B PHYSICAL (1) Mold Shrinkage on Tensile Bar, flow (3) 0.5 – 0.7 % SABIC method Density 1.2 g/cm³ ISO 1183	HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm	121	°C	ISO 75/Ae
Relative Temp Index, Mech w/o impact (2) 80 °C UL 746B PHYSICAL (1) Mold Shrinkage on Tensile Bar, flow (3) 0.5 – 0.7 % SABIC method Density 1.2 g/cm³ ISO 1183	Relative Temp Index, Elec ⁽²⁾	80	°C	UL 746B
PHYSICAL (1) Mold Shrinkage on Tensile Bar, flow (3) 0.5 – 0.7 % SABIC method Density 1.2 g/cm³ ISO 1183	Relative Temp Index, Mech w/impact (2)	80	°C	UL 746B
Mold Shrinkage on Tensile Bar, flow (3) 0.5 – 0.7 % SABIC method Density 1.2 g/cm³ ISO 1183	Relative Temp Index, Mech w/o impact (2)	80	°C	UL 746B
Density 1.2 g/cm³ ISO 1183	PHYSICAL (1)			
Density 1.2 g/cm³ ISO 1183	Mold Shrinkage on Tensile Bar, flow (3)	0.5 – 0.7	%	SABIC method
		1.2	g/cm³	ISO 1183
value (100 in 120 in 12	Water Absorption, (23°C/saturated)	0.35	%	ISO 62-1
Moisture Absorption (23°C / 50% RH) 0.15 % ISO 62	Moisture Absorption (23°C / 50% RH)	0.15	%	ISO 62
Melt Volume Rate, MVR at 300°C/1.2 kg 26 cm³/10 min ISO 1133		26	cm³/10 min	ISO 1133
FLAME CHARACTERISTICS (2)				



PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
UL Yellow Card Link	E45329-541344	-	
UL Recognized, 94V-2 Flame Class Rating	≥1.2	mm	UL 94
INJECTION MOLDING (4)			
Drying Temperature	120	°C	
Drying Time	2 – 4	Hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	280 – 300	°C	
Nozzle Temperature	270 – 290	°C	
Front - Zone 3 Temperature	280 – 300	°C	
Middle - Zone 2 Temperature	270 – 290	°C	
Rear - Zone 1 Temperature	260 – 280	°C	
Hopper Temperature	60 – 80	°C	
Mold Temperature	80 – 100	°C	

- (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) 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.
- (3) 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.
- (4) 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.

ADDITIONAL PRODUCT NOTES

No PFAS intentionally added: The grade listed in this document does not contain PFAS intentionally added during Seller's manufacturing process and is not expected to contain unintentional PFAS impurities. Each user is responsible for evaluating the presence of unintentional PFAS impurities.

DISCLAIMER

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