

LEXAN™ FR RESINS BY2710X

REGION ASIA

DESCRIPTION

LEXAN BY2710X Polycarbonate (PC) is an injection moldable non-chlorinated/brominated, unfilled, flame retardant grade with good flow and impact performance. It has an MVR of 15 (300°C/1.2kg), UL94 V0@1.5mm, is available in various opaque color options.

TYPICAL PROPERTY VALUES

Revision 20190424

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	60	MPa	ASTM D638
Tensile Stress, brk, Type I, 50 mm/min	61	MPa	ASTM D638
Tensile Strain, yld, Type I, 50 mm/min	6	%	ASTM D638
Tensile Strain, brk, Type I, 50 mm/min	100	%	ASTM D638
Tensile Modulus, 50 mm/min	2220	MPa	ASTM D638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	90	MPa	ASTM D790
Flexural Modulus, 1.3 mm/min, 50 mm span	2070	MPa	ASTM D790
IMPACT			
Izod Impact, notched, 23°C	800	J/m	ASTM D256
Izod Impact, notched, 0°C	740	J/m	ASTM D256
Instrumented Dart Impact Total Energy, 23°C	72	J	ASTM D3763
THERMAL			
Vicat Softening Temp, Rate B/50	139	°C	ASTM D1525
Ball Pressure Test, 125°C +/- 2°C	125	-	IEC 60695-10-2
Relative Temp Index, Elec	130	°C	UL 746B
Relative Temp Index, Mech w/impact	115	°C	UL 746B
Relative Temp Index, Mech w/o impact	125	°C	UL 746B
PHYSICAL			
Specific Gravity	1.19	-	ASTM D792
Mold Shrinkage, flow, 3.2 mm	0.6 – 0.8	%	SABIC method
Melt Flow Rate, 300°C/1.2 kgf	15	g/10 min	ASTM D1238
FLAME CHARACTERISTICS			
UL Recognized, 94V-0 Flame Class Rating	1.5	mm	UL 94
INJECTION MOLDING			
Drying Temperature	120	°C	
Drying Time	3 – 4	Hrs	
Drying Time (Cumulative)	48	Hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	295 – 315	°C	
Nozzle Temperature	290 – 310	°C	
Front - Zone 3 Temperature	295 – 315	°C	
Middle - Zone 2 Temperature	280 – 305	°C	
Rear - Zone 1 Temperature	270 – 295	°C	
Mold Temperature	70 – 95	°C	

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
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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