

LEXANTM RESIN OQ1022

REGION ASIA

DESCRIPTION

Standard Flow OQ Resin

TYPICAL PROPERTY VALUES

Revision 20190607

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	61	MPa	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	51	MPa	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	6	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	100	%	ASTM D 638
Tensile Modulus, 50 mm/min	2420	MPa	ASTM D 638
Flexural Stress, brk, 1.3 mm/min, 50 mm span	93	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	2460	MPa	ASTM D 790
Tensile Stress, yield, 50 mm/min	61	MPa	ISO 527
Tensile Stress, break, 50 mm/min	56	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	5.9	%	ISO 527
Tensile Strain, break, 50 mm/min	108	%	ISO 527
Tensile Modulus, 1 mm/min	2440	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	90	MPa	ISO 178
Flexural Modulus, 2 mm/min	2400	MPa	ISO 178
IMPACT			
Izod Impact, notched, 23°C	550	J/m	ASTM D 256
Izod Impact, notched, -30°C	NB	J/m	ASTM D 256
Instrumented Impact Total Energy, 23°C	46	J	ASTM D 3763
Izod Impact, unnotched 80*10*3 +23°C	NB	kJ/m ²	ISO 180/1U
Izod Impact, unnotched 80*10*3 -30°C	NB	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*3 +23°C	14	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*3 -30°C	11	kJ/m ²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*3 sp=62mm	40	kJ/m ²	ISO 179/1eA
Charpy -30°C, V-notch Edgew 80*10*3 sp=62mm	11	kJ/m ²	ISO 179/1eA
Charpy 23°C, Unnotch Edgew 80*10*3 sp=62mm	NB	kJ/m ²	ISO 179/1eU
Charpy -30°C, Unnotch Edgew 80*10*3 sp=62mm	NB	kJ/m ²	ISO 179/1eU
THERMAL			
Vicat Softening Temp, Rate B/50	140	°C	ASTM D 1525
HDT, 1.82 MPa, 3.2mm, unannealed	123	°C	ASTM D 648
CTE, -40°C to 40°C, flow	8.1E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	7.2E-05	1/°C	ASTM E 831
CTE, 23°C to 80°C, flow	7.E-05	1/°C	ISO 11359-2
CTE, 23°C to 80°C, xflow	7.E-05	1/°C	ISO 11359-2
Ball Pressure Test, 75°C +/- 2°C	NB	-	IEC 60695-10-2
Vicat Softening Temp, Rate B/50	140	°C	ISO 306

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Vicat Softening Temp, Rate B/120	141	°C	ISO 306
HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm	121	°C	ISO 75/Ae
PHYSICAL			
Specific Gravity	1.19	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	0.6 – 0.8	%	SABIC method
Mold Shrinkage, xflow, 3.2 mm	-0.1 - 0	%	SABIC method
Melt Flow Rate, 250°C/1.2 kgf	11	g/10 min	ASTM D 1238
Density	1.19	g/cm ³	ISO 1183
Water Absorption, (23°C/sat)	0.2	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.2	%	ISO 62
Melt Volume Rate, MVR at 250°C/1.2 kg	10	cm ³ /10 min	ISO 1133
INJECTION MOLDING			
Drying Temperature	120	°C	
Drying Time	3 – 4	hrs	
Drying Time (Cumulative)	48	hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	305 – 330	°C	
Nozzle Temperature	305 – 330	°C	
Front - Zone 3 Temperature	305 – 330	°C	
Middle - Zone 2 Temperature	295 – 320	°C	
Rear - Zone 1 Temperature	280 – 310	°C	
Mold Temperature	65 – 95	°C	
Back Pressure	0.3 – 0.7	MPa	
Screw Speed	60 – 200	rpm	

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