

Revision 20190809

LEXAN[™] FR RESIN FXD153

REGION EUROPE

DESCRIPTION

FXD153 is an Extrusion / Blow molding grade in a Diffusion effect, which is part of the VisualFX family. These effects have been developed to meet increasing Aesthetic demands in the Marketplace. Color Package may affect properties, Application testing always reccomended.

TYPICAL PROPERTY VALUES

PROPERITIESUNITSTEST METHODSMECHANICALMECHANICALTensile Stress, yid, Type I, SD mm/min62Besile Stress, yid, Type I, SD mm/min66MPAASH D 638Tensile Stress, yid, Type I, SD mm/min7Tensile Modules, Smm/min340Tensile Modules, Smm/min340Tensile Modules, Smm/min340Mexanal Modules, S mm Jimin, SD mm span93Beaural Modules, 1.3 mm/min, SD mm span3204MPAASTM D 780Pleaural Modules, 1.3 mm/min, SD mm span3204Jue Impact, unotched, 23°C3204Jue Impact, unotched, 23°C3504Jue Impact, unotched, 23°C </th <th></th> <th></th> <th></th> <th></th>				
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Tenile Strain, brk, Type I, So Tm/min110%ASTM D 638Tensile Modulus, S mm/min, So mm span9340MPaASTM D 638Hexaral Modulus, 1.3 mm/min, So mm span9340MPaASTM D 790Hexaral Modulus, 1.3 mm/min, So mm span2340MPaASTM D 790IMPACT2340MPaASTM D 780Inspect, unnotched, 23°C3204J/mASTM D 4812Izod Impact, notched, 23°C3204J/mASTM D 4812Izod Impact, notched, 23°C3204J/mASTM D 4812Izod Impact, notched, 23°C350°CASTM D 525HTFRMALVVSTM D 548HTF, AS, Ma, 3.2 mm, unannealed138°CASTM D 648HDT, 142 MPa, 3.2 mm, unannealed6860 S°CASTM D 648HDT, 142 MPa, 3.2 mm, unannealed1.2ASTM D 792Mold Shrikage, flow, 3.2 mm0.5 - 0.7g10 minASTM D 792Mold Shrikage, flow, 3.2 mm0.5 - 0.7g10 minASTM D 792Mold Shrikage, flow, 3.2 mm0.5 - 0.7g10 minASTM D 1238Mold Findage, flow, 3.2 mm0.2g10 minSAIN D 1238Mold Thinkage, flow, 3.2 mm0.2g10 minSAIN D 1238Mold Thinkage, flow, 3.2 mm0.2g2 - 345CMold Thinkage, flow, 3.2 mm3.0%C-Mold Thinkage, flow, 3.2 mm3.0%C-Mold Thinkage, flow, 3.2 mm3.0%C-Mold Thinkage, flow, 3.2 mm3.0%C-Mold Thi	Tensile Stress, brk, Type I, 50 mm/min	66	MPa	ASTM D 638
Tensile Modula, Sam/min2340MPaASTM D 638Flexural Stress, yid, 1.3 mm/min, 50 mm span93MPaASTM D 790Flexural Modulas, 1.3 mm/min, 50 mm span2340.00MPaASTM D 780IMPACTVVVIzed Impact, unnotched, 23°C748.00J/mASTM D 4812Ized Impact, unnotched, 23°C748.00J/mASTM D 565THERMALVVVVVicat Softening Tenn, Rate BJ50157.00°CASTM D 648DT1, 1.82 MPa, 3.2mm, unannealed132°CASTM D 648DT1, 42 MPa, 3.2mm, unannealed122°CASTM D 792DYIGTG TAGNANGANGAN125SERICHONSERICHONDYIGTG TAGNANGANGANGAN124SERICHONSERICHONDYIGTG TAGNANGANGANGAN124SERICHONSERICHONDYIGTG TAGNANGANGANGANGANGANGANGANGANGANGANGANGA	Tensile Strain, yld, Type I, 50 mm/min	7	%	ASTM D 638
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Hearral Modulus 1.3 mm runnin 50 mm span2340MPaASTM D 790IMPACTJona 100Min 200Min 200Izod Impact, nontched, 23°C3204J/mASTM D 4812Izod Impact, notched, 23°C70Min D 525Min D 525HERMALVVVicit Softening Temp, Rate B/5015770ASTM D 1525HDT, 0.45 MPa, 3.2 mm, unannealed138°CASTM D 648HDT, 1.82 MPa, 3.2 mm, unannealed132°CASTM D 648HDT, 1.82 MPa, 3.2 mm, unannealed132°CSABIC methodHDT, 1.82 MPa, 3.2 mm, unannealed132°CSABIC methodHDT, 1.82 MPa, 3.2 mm, unannealed120°CSABIC methodHDT, 1.82 MPa, 3.2 mm, unannealed120°CSABIC methodHDT, 1.82 MPa, 3.2 mm, unannealed120°CSABIC methodHDT, 1.82 MPa, 3.2 mm, unannealed120SABIC methodSABIC methodHDT, 1.82 MPa, 3.2 mm, unannealed120SABIC methodSABIC methodDying Time (Canvilla E, Canvilla E, C	Tensile Modulus, 5 mm/min	2340	MPa	ASTM D 638
MARCTIzod Impact.3204//mASTM D 4812Izod Impact.748//mASTM D 4512THERNALXSTM D 1525HDT. 0.45 MPa.3.2 mm, unannealed136°CASTM D 648HDT. 1.82 MPa.3.2 mm, unannealed132°CASTM D 648HDT. 1.82 MPa.3.2 mm, unannealed132°CSABIC methodMold Shrinkage, flow, 3.2 mm0.5 - 0.7% SABIC methodSABIC methodMult Row Rate, 300°C / 1.2 kg ft3-4NsSABIC methodDrying Time (Lumulative)30-4NsSABIC methodSABIC methodMold Temperature30-345°CSABIC methodSABIC methodMold Temperature30-345°CSABIC methodSABIC methodMold Temperature30-300°CSABIC method </td <td>Flexural Stress, yld, 1.3 mm/min, 50 mm span</td> <td>93</td> <td>MPa</td> <td>ASTM D 790</td>	Flexural Stress, yld, 1.3 mm/min, 50 mm span	93	MPa	ASTM D 790
Ized Inpact, unotched, 23°C3244J/mASTM 04812Ized Inpact, notched, 23°C748J/mASTM 04812IterRNALVVVict Softening Temp, Rate 8/50157°CASTM 04812HDT, 1.82 Ma, 3.2mm, unannealed132°CASTM 0484HDT, 1.82 Ma, 3.2mm, unannealed182°CASTM 0484HDT, 1.82 Ma, 3.2mm, unannealed182°CASTM 0484HDT, 1.82 Ma, 3.2mm, unannealed182°CASTM 0484HDT, 1.82 Ma, 3.2mm, unannealed182NASTM 0484HDT, 1.82 Ma, 3.2mm, unannealed182NNHDT, 1.82 Ma, 3.2mm, unannealed182NN<	Flexural Modulus, 1.3 mm/min, 50 mm span	2340	MPa	ASTM D 790
Icod Impact. notched. 23°C748//mASIM D 256THERMALVicat Softening Temp. Rate B/50157°CASIM D 1525HDT, 0.45 MPa, 3.2 mn, unamealed138°CASIM D 648HDT, 1.82 MPa, 3.2 mn, unamealed0.86.050'CASIM D 648HDT, 1.82 MPa, 3.2 mn, unamealed0.86.050'CASIM D 52Physick5252Sime BillSime BillPysick5252Sime BillSime BillPhysick5252Sime BillSime BillNod Shrinkage, flow, 3.2 mm0.5 - 0.7%Sime BillSime BillMold Shrinkage, flow, 3.2 mm0.5 - 0.7%%Sime BillMold Shrinkage, flow, 3.2 mm0.5 - 0.7%%Sime BillMold Shrinkage, flow, 3.2 mm0.5 - 0.7%%Sime BillMold Shrinkage, flow, 3.2 mm0.5 - 0.7%%%%Mold Shrinkage, flow, 3.2 mm0.5 - 0.7%%%%Mold Shrinkage, flow, 3.2 mm0.5 - 0.7%%%%Mold Shrinkage, flow, 3.2 mm0.02%%%%Maximum Moisture Content0.02%%%%Maximum Moisture Content30 - 3.0%	IMPACT			
THERNALVicat Softening Temp, Rate B/50157°CASTM D 1525HDT, 0.45 MPa, 3.2 mm, unannealed138°CASTM D 648HDT, 1.82 MPa, 3.2 mm, unannealed132°CASTM D 648CTE, 40°C to 40°C, xflow6.8E051/°CASTM D 648PHYSICALVVSpecific Gravity0.5 - 0.7% 0ASTM D 792Mold Shrinkage, flow, 3.2 mm0.5 - 0.7% 10ASTM D 792Mold Shrinkage, flow, 3.2 mm0.5 - 0.7% 0SABIC methodDying Temperature12···Drying Temperature120% CSABIC methodDrying Time (Cumulative)30-4hrs··Maximum Moisture Content0.02%··Nozzle Temperature320-345°C··Nozzle Temperature320-345°C··Moid Temperature320-345°C··Moid Temperature320-345°C··Model Zone 1 Temperature320-345°C··Model Temperature320-345°C··Model Zone 2 Temperature300-300°C··Model Temperature30-300°C··Model Zone 3 Temperature30-300°C··Model Temperature30-15····Sters Speed30-07Mif···Sters Speed30-07Mif·	Izod Impact, unnotched, 23°C	3204	J/m	ASTM D 4812
Vicat Softening Temp, Rate B/50157°CASTN D 1525HDT, 0.45 MPa, 3.2 mm, unannealed138°CASTN D 648HDT, 1.82 MPa, 3.2 mm, unannealed132°CASTN D 648GTE, 40°C to 40°C, xflow6.8c051/°CASTN D 648PHYSICALYASTN D 792Mold Srinkage, flow, 3.2 mm0.5 - 0.7%CASTN D 792Mold Srinkage, flow, 3.2 mm0.5 - 0.7%CASTN D 1238Met Flow Rate, 300°C 1.2 kgf0.5 - 0.7%CSABIC methodMold Srinkage, flow, 3.2 mm0.5 - 0.7%CSABIC methodMold Srinkage, flow, 3.2 mm0.5 - 0.7%CSABIC methodMold Srinkage, flow, 3.2 mm0.5 - 0.7%ISABIC methodMold Srinkage, flow, 3.2 mm0.5 - 0.7%ISABIC methodMold Srinkage, flow, 3.2 mm0.5 - 0.7%ISABIC methodMold Srinkage, flow, 3.2 mm0.2%ISABIC methodMight Flow Rate, 300°C 1.2 kgf0.2%ISABIC methodMyrig Time (Cumulative)48NsSAIC SCMold Temperature0.2%CSAIC SCNozzle Temperature30-0.30%CSAIC SCMold Comperature0.3-0.7%CSAIC SCMold Temperature0.3-0.7%CSAIC SCMold Temperature0.3-0.7%PASAIC SCMold Temperature0.3-0.7%PASAIC SCMold Temperature0.3-0.7%PASAIC SCMold Temperature0.3-0.7	Izod Impact, notched, 23°C	748	J/m	ASTM D 256
HOT, 0.4.5 Mr, mannealed138°CASTM D 648HDT, 0.4.5 MR, 3.2 mm, mannealed132°CASTM D 648HDT, 0.4.5 MR, 3.2 mm, mannealed6.86-051/°CASTM D 648CTE, 40°C to 40°C, xflow6.86-051/°CASTM D 792PhysicAL	THERMAL			
HDT, 1.32 MPa, 3.2mm, nannealed132°CASTM D 648CTE, 40°C to 40°C, xflow6.86051/°CASTM D 648CTE, 40°C to 40°C, xflow6.86051/°CASTM D 792PhysicALASTM D 792Specific Gravity1.2.SABC methodMold Shrinkage, flow, 3.2 mm0.5 - 0.7%SABC methodMet Flow Rate, 300°C/1.2 kgf2.5g/10 minASTM D 1238NIECTION MOLDINGDrying Time3-4msDrying Time (Cumulative)0.02%Maximum Moisture Content0.02%Nozzle Temperature300-330°CNotzle Temperature300-330°CMiddle Temperature300-320°CMiddle Temperature300-320°CMiddle Temperature300-320°CMiddle Temperature300-320°CMiddle Temperature300-320°CMiddle Temperature300-320°CMiddle Temperature300-320°CMiddle Temperature30-300°CMiddle Temperature30-07MPAMiddle Temperature30-07MPAMiddle Temperature30-07MPAMiddle Temperature30-07 <td< td=""><td>Vicat Softening Temp, Rate B/50</td><td>157</td><td>°C</td><td>ASTM D 1525</td></td<>	Vicat Softening Temp, Rate B/50	157	°C	ASTM D 1525
CTL, 40°Ct x40°C, x4068E051/°CASTM E 831PHYSICALSpecific avity1.2Mold Shrinkage, flow, 3.2 mm0.5 - 0.7%SAIC methodMold Shrinkage, flow, 3.2 mm0.3 - 0.4%SAIC methodDying Time (Lumulative)30 - 0.2%SAIC methodMaximum Moisture Content0.02%SAIC methodMozel Temperature30 - 0.3°CSAIC methodNozel Temperature30 - 0.3°CSAIC methodMiddle - Zone 3 Temperature30 - 0.3°CSAIC methodMold Temperature0.0 - 0.3°CSAIC methodMold Temperature0.3 - 0.7MHaSAIC methodBack Pressure0.3 - 0.7MPaSAIC methodStott o Cylinder Size40 - 0.0%SAIC methodStott o Cylinder Size40 - 0.0%SAIC method	HDT, 0.45 MPa, 3.2 mm, unannealed	138	°C	ASTM D 648
PHYSICALSpecific Gravity1.2ATD 792Mold Shrinkage, flow, 3.2 mm0.5 - 0.7% 0Mold Shrinkage, flow, 3.2 mm2.5y10 minMet Flow Rate, 300°C/1.2 kgf2.5y10 minDying Tomperature120°CDrying Time3-4hsDrying Time (Cumulative)48hrsMaximum Moisture Content30-345°CMozel Temperature30-345°CNozel Temperature30-345°CMiddle - Zone J Temperature30-30.30°CMiddle - Zone J Temperature30-30.30°CMold Temperature30-30.30°CMold Temperature0.3 - 0.7MPaSterw Speed0.3 - 0.7MPaSterw Speed40-70pmStot to Cylinder Size40-60%	HDT, 1.82 MPa, 3.2mm, unannealed	132	°C	ASTM D 648
Specific Cravity1.2- · · · · · · ASTN D 792Mold Shrinkage, flow, 3.2 mm0.5 - 0.78 (0.10 mm)ABIC methodMeth Flow Rate, 300°C/1.2 kgf2.5 - 0.79.10 mm0.10 mmSTM D 123NECTION MOLDING	CTE, -40°C to 40°C, xflow	6.8E-05	1/°C	ASTM E 831
Mold Shrinkage, flow, 3.2 mm0.5–0.7%SABC methodMelt Flow Rate, 300°C/1.2 kgf2.5g/10 minASTM D 1238INECTION MOLDINGDrying Temperature120°CDrying Time (cumulative)3–4hrsMaximum Moisture Content0.02%Maximum Moisture Content320-345°CNozzle Temperature310-330°CMiddle-Zone 3 Temperature300-320°CMold Temperature300-320°CMold Temperature300-320°CMold Temperature80-115°CMold Temperature0.3–0.7MPaStote Offmer Size40-70mpaMold Stressene0.3–0.7MPaStote Offmer Size40-60%	PHYSICAL			
Melt Flow Rate, 300°C/1.2 kgf2.5g/10 minASTM D 1238INJECTION MOLDINGDrying Temperature120°CDrying Time3 - 4hrsDrying Time (Cumulative)48hrsMaximum Moisture Content0.02%Melt Temperature320 - 345°CNozzle Temperature310 - 330°CMiddle - Zone 2 Temperature300 - 320°CMold Temperature0.3 - 0.7MPaSterew Speed0.3 - 0.7MPaStot C Lylinder Size40 - 60%	Specific Gravity	1.2	-	ASTM D 792
INJECTION MOLDICGDrying Temperature120°CDrying Time3 - 4MrsDrying Time (Cumulative)48MrsMaximum Moisture Content0.02%Melt Temperature320 - 345°CNozzle Temperature315 - 340°CMiddle - Zone 3 Temperature300 - 320°CMiddle - Zone 1 Temperature300 - 320°CMold Temperature000 - 320°CStote 9 Eeged0.3 - 0.7MPaStote Office Size40 - 60%	Mold Shrinkage, flow, 3.2 mm	0.5 – 0.7	%	SABIC method
Drying Temperature120°CDrying Time3–4hrsDrying Time (Cumulative)48hrsMaximum Moisture Content0.02%Melt Temperature320–345°CNozzle Temperature315–340°CMiddle-Zone 3 Temperature300–320°CMiddle 4 Cone 9 Temperature300–320°CMod Temperature80–115°CMod Temperature0.3–0.7MPaSterew Speed0.3–0.7PmaShot to Cylinder Size40–60%	Melt Flow Rate, 300°C/1.2 kgf	2.5	g/10 min	ASTM D 1238
Drying Time3-4hrsDrying Time (Cumulative)48hrsMaximum Moisture Content0.02%Melt Temperature320-345°CNozzle Temperature310-330°CMiddle-Zone 3 Temperature310-330°CMiddle Temperature300-320°CMod Temperature80-115°CScrew Speed0.3-0.7MPaStot to Cylinder Size40-60%	INJECTION MOLDING			
Drying Time (Cumulative)48hrsDrying Time (Cumulative)48hrsMaximum Moisture Content0.02%Melt Temperature320-345°CNozzle Temperature315-340°CNozzle Temperature320-345°CMiddle - Zone 3 Temperature300-330°CRear - Zone 1 Temperature300-320°CMold Temperature03-0.7MPaBack Pressure0.3-0.7MPaStrew Speed40-70rpmMot to Cylinder Size40-60%	Drying Temperature	120	°C	
Maximum Moisture Content0.02%Maximum Moisture Content0.02%Melt Temperature320-345°CNozzle Temperature320-345°CFront - Zone 3 Temperature320-345°CMiddle - Zone 2 Temperature310-330°CRear - Zone 1 Temperature80-320°CMold Temperature80-115°CBack Pressure0.3-0.7MPaScrew Speed40-70pmShot to Cylinder Size40-60%	Drying Time	3 – 4	hrs	
Melt Temperature320 - 345°CNozzle Temperature315 - 340°CFront - Zone 3 Temperature320 - 345°CMiddle - Zone 2 Temperature310 - 330°CRear - Zone 1 Temperature300 - 320°CMold Temperature80 - 115°CBack Pressure0.3 - 0.7MPaStrew Speed40 - 70pmShot to Cylinder Size40 - 60%	Drying Time (Cumulative)	48	hrs	
Nozzle Temperature 315 - 340 °C Front - Zone 3 Temperature 320 - 345 °C Middle - Zone 2 Temperature 310 - 330 °C Rear - Zone 1 Temperature 300 - 320 °C Mold Temperature 80 - 115 °C Back Pressure 0.3 - 0.7 MPa Screw Speed 40 - 70 pm Shot to Cylinder Size 40 - 60 %	Maximum Moisture Content	0.02	%	
Front - Zone 3 Temperature 320 - 345 °C Middle - Zone 2 Temperature 310 - 330 °C Rear - Zone 1 Temperature 300 - 320 °C Mold Temperature 80 - 115 °C Back Pressure 0.3 - 0.7 MPa Screw Speed 40 - 70 pm Shot to Cylinder Size 40 - 60 %	Melt Temperature	320 – 345	°C	
Middle - Zone 2 Temperature 310 – 330 °C Rear - Zone 1 Temperature 300 – 320 °C Mold Temperature 80 – 115 °C Back Pressure 0.3 – 0.7 MPa Screw Speed 40 – 70 rpm Shot to Cylinder Size 40 – 60 %	Nozzle Temperature	315 - 340	°C	
Rear - Zone 1 Temperature 300 – 320 °C Mold Temperature 80 – 115 °C Back Pressure 0.3 – 0.7 MPa Screw Speed 40 – 70 pm Shot to Cylinder Size 40 – 60 %	Front - Zone 3 Temperature	320 - 345	°C	
Mold Temperature 80 - 115 °C Back Pressure 0.3 - 0.7 MPa Screw Speed 40 - 70 rpm Shot to Cylinder Size 40 - 60 %	Middle - Zone 2 Temperature	310 - 330	°C	
Back Pressure 0.3 - 0.7 MPa Screw Speed 40 - 70 rpm Shot to Cylinder Size 40 - 60 %	Rear - Zone 1 Temperature	300 - 320	°C	
Screw Speed 40 – 70 rpm Shot to Cylinder Size 40 – 60 %	Mold Temperature	80 – 115	°C	
Shot to Cylinder Size 40 – 60 %	Back Pressure	0.3 – 0.7	MPa	
•	Screw Speed	40 – 70	rpm	
Vent Depth 0.025 – 0.076 mm	Shot to Cylinder Size	40 - 60	%	
	Vent Depth	0.025 – 0.076	mm	

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CHEMISTRY THAT MATTERS



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