

LEXANTM FR RESINS LUX7169

REGION ASIA

DESCRIPTION

LEXAN LUX7169 is an injection moldable polycarbonate (PC). It contains non-brominated, non-chlorinated flame retardant systems with UL-94 V0@0.9mm rating. It is designed for high light reflectance and shielding applications with good weathering capability.

TYPICAL PROPERTY VALUES

Revision 20191031

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	60	MPa	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	45	MPa	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	11	%	ASTM D 638
Tensile Modulus, 50 mm/min	2800	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	85	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	2600	MPa	ASTM D 790
IMPACT			
Izod Impact, notched, 23°C	90	J/m	ASTM D 256
THERMAL			
Vicat Softening Temp, Rate B/50	142	°C	ASTM D 1525
HDT, 1.82 MPa, 3.2mm, annealed	115	°C	ASTM D 648
HDT, 0.45 MPa, 6.4 mm, unannealed	134	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	124	°C	ASTM D 648
CTE, -40°C to 40°C, flow	7.5E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	7.5E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, flow	7.5E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	7.5E-05	1/°C	ISO 11359-2
Ball Pressure Test, approximate maximum	135	°C	IEC 60695-10-2
Vicat Softening Temp, Rate B/120	143	°C	ISO 306
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	130	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	115	°C	ISO 75/Af
PHYSICAL			
Specific Gravity	1.38	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	0.5 – 0.7	%	SABIC method
Melt Flow Rate, 300°C/1.2 kgf	22	g/10 min	ASTM D 1238
Density	1.38	g/cm ³	ISO 1183
Water Absorption, (23°C/sat)	0.35	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.15	%	ISO 62
Melt Volume Rate, MVR at 300°C/1.2 kgf	22	cm ³ /10 min	ISO 1133
FLAME CHARACTERISTICS			
UL Recognized, 94V-0 Flame Class Rating	0.9	mm	UL 94
INJECTION MOLDING			
Drying Temperature	120	°C	
Drying Time	3 – 4	hrs	

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Drying Time (Cumulative)	48	hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	270 – 295	°C	
Nozzle Temperature	265 – 290	°C	
Front - Zone 3 Temperature	270 – 295	°C	
Middle - Zone 2 Temperature	260 – 280	°C	
Rear - Zone 1 Temperature	250 – 270	°C	
Mold Temperature	70 – 95	°C	
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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