



LEXAN® LGK3020
Americas: **COMMERCIAL**

CUSTOM ENGINEERED PRODUCTS from GENERAL ELECTRIC PLASTICS. Glass reinforced. Flame retardant.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
MECHANICAL			
Tensile Stress, brk, Type I, 50 mm/min	118	MPa	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	4	%	ASTM D 638
Flexural Stress, brk, 1.3 mm/min, 50 mm span	148	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	6580	MPa	ASTM D 790
IMPACT			
Izod Impact, notched, 23°C	123	J/m	ASTM D 256
THERMAL			
HDT, 1.82 MPa, 6.4 mm, unannealed	146	°C	ASTM D 648
CTE, -30°C to 30°C, flow	2.7E-05	1/°C	ASTM D 696
CTE, -30°C to 30°C, xflow	4.68E-05	1/°C	ASTM D 696
PHYSICAL			
Specific Gravity	1.43	-	ASTM D 792
Water Absorption, 24 hours	0.13	%	ASTM D 570
Mold Shrinkage, flow, 3.2 mm	0.1 - 0.2	%	GE Method
Mold Shrinkage, xflow, 3.2 mm	0.2 - 0.3	%	GE Method
ELECTRICAL			
Dielectric Strength, in oil, 3.2 mm	17.7	kV/mm	ASTM D 149
FLAME CHARACTERISTICS			
UL Recognized, 94V-0 Flame Class Rating (3)	1.6	mm	UL 94

1) Typical values only. Variations within normal tolerances are possible for various colours. All values are measured at least after 48 hours storage at 23°C/50% relative humidity.
All properties, except the melt volume rate are measured on injection moulded samples.
All samples are prepared according to ISO 294.

2) Only typical data for material selection purpose. Not to be used for part or tool design.
3) This rating is not intended to reflect hazards presented by this or any other material under actual fire conditions.
4) Own measurement according to UL.





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GE Plastics

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PROCESSING PARAMETERS	TYPICAL VALUE	UNIT
Injection Molding		
Drying Temperature	120	°C
Drying Time	3 - 4	hrs
Drying Time (Cumulative)	48	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	315 - 340	°C
Nozzle Temperature	310 - 330	°C
Front - Zone 3 Temperature	315 - 340	°C
Middle - Zone 2 Temperature	305 - 325	°C
Rear - Zone 1 Temperature	295 - 315	°C
Mold Temperature	80 - 115	°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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