+135-3858-6433 (GuangDong)
+188-1699-6168 (ShangHai)
+852-6957-5415 (HongKong)

LEXAN™ Resin 3262R

Asia Pacific: COMMERCIAL

LEXAN 3262R Polycarbonate (PC) resin is a 20% glass fiber filled, injection moldable grade. This non-chlorinated, non-brominated flame retardant GF-PC has an UL-94 V2@1.5mm rating and is available in various opaque color options.

TYPICAL PROPERTIES[1]	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	910	kgf/cm²	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	880	kgf/cm²	ASTM D 638
Tensile Strain, yld, Type I, 5 mm/min	3.1	%	ASTM D 638
Tensile Modulus, 5 mm/min	56000	kgf/cm²	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	1590	kgf/cm²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	50900	kgf/cm²	ASTM D 790
IMPACT			
Izod Impact, notched, 23°C	11	cm-kgf/cm	ASTM D 256
Izod Impact, notched, -30°C	10	cm-kgf/cm	ASTM D 256
THERMAL			
HDT, 1.82 MPa, 3.2mm, unannealed	138	°C	ASTM D 648
PHYSICAL			
Specific Gravity	1.3	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm (5)	0.2 - 0.5	%	SABIC Method
Mold Shrinkage, xflow, 3.2 mm (5)	0.2 - 0.5	%	SABIC Method
Melt Flow Rate, 300°C/1.2 kgf	13	g/10 min	ASTM D 1238
Density	1.34	g/cm³	ISO 1183
Water Absorption, (23°C/sat)	0.29	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.12	%	ISO 62
Melt Volume Rate, MVR at 300°C/1.2 kg	11	cm³/10 min	ISO 1133
FLAME CHARACTERISTICS			
UL Recognized, 94V-2 Flame Class Rating (3)	1.5	mm	UL 94

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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	310 - 330	°C
Nozzle Temperature	305 - 325	°C
Front - Zone 3 Temperature	310 - 330	°C
Middle - Zone 2 Temperature	300 - 320	°C
Rear - Zone 1 Temperature	290 - 310	°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

• NOTE: Back Pressure, Screw Speed, Shot to Cylinder Size and Vent Depth are only mentioned as general guidelines. These may not apply or need adjustment in specific situations such as low shot sizes, thin wall molding and gas-assist molding.