



LEXAN™ Resin 4501

Europe-Africa-Middle East: COMMERCIAL

LEXAN 4501 is a copolymer of polyphtalate carbonate resin for applications requiring high heat resistance.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yield, 50 mm/min	65	MPa	ISO 527
Tensile Stress, break, 50 mm/min	55	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	7	%	ISO 527
Tensile Strain, break, 50 mm/min	>50	%	ISO 527
Tensile Modulus, 1 mm/min	2300	MPa	ISO 527
Flexural Modulus, 2 mm/min	2300	MPa	ISO 178
Hardness, Rockwell R	122	-	ISO 2039-2
IMPACT			
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	50	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	59	kJ/m ²	ISO 179/1eA
Charpy -30°C, V-notch Edgew 80*10*3 sp=62mm	13	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			
Thermal Conductivity	0.21	W/m-°C	ISO 8302
Ball Pressure Test, 125°C +/- 2°C	PASSES	-	IEC 60695-10-2
Vicat Softening Temp, Rate B/120	160	°C	ISO 306
PHYSICAL			
Mold Shrinkage on Tensile Bar, flow (2) (5)	0.7	%	SABIC Method
Density	1.2	g/cm ³	ISO 1183
Melt Volume Rate, MVR at 300°C/5.0 kg	10	cm ³ /10 min	ISO 1133



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TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
ELECTRICAL			
Relative Permittivity, 1 MHz	3	-	IEC 60250
Dissipation Factor, 100 Hz	0.024	-	IEC 60250
FLAME CHARACTERISTICS			
UL Compliant, 94V-2 Flame Class Rating (3)(4)	1.6	mm	UL 94 by SABIC-IP



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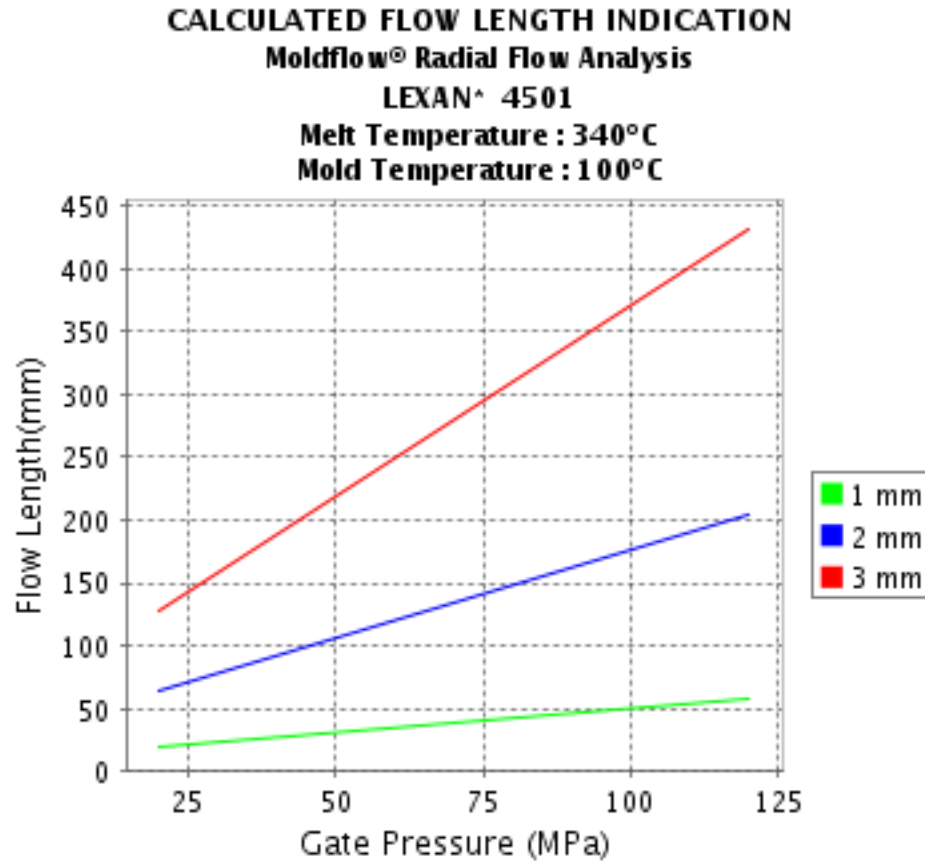
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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	125 - 135	°C
Drying Time	3 - 4	hrs
Melt Temperature	325 - 360	°C
Nozzle Temperature	320 - 340	°C
Front - Zone 3 Temperature	320 - 340	°C
Middle - Zone 2 Temperature	310 - 330	°C
Rear - Zone 1 Temperature	300 - 320	°C
Hopper Temperature	60 - 80	°C
Mold Temperature	100 - 125	°C



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Note: Technical support is recommended if Gate Pressure is greater than 80 MPa. Contact your local representative.

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