



LEXAN™ Resin FL2000

Americas: COMMERCIAL

LEXAN FL2000 is a medium flow specialty polycarbonate (PC) resin for structural foam molding, allowing for various weight reductions at 0.24" (6.0mm) wall. This product offers low temperature impact strength and high heat resistance in combination with LEXAN FL2000 resin is available in opaque colors only.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
FOAM - MECHANICAL 6.4 mm Wt Reduction	10	%	-
Tensile Stress, yield, 6.35 mm	540	kgf/cm ²	ASTM D 638
Tensile Strain, break, 6.35 mm	7.8	%	ASTM D 638
Tensile Modulus, 6.4 mm	23500	kgf/cm ²	ASTM D 638
Flexural Stress, yield, 6.4 mm	770	kgf/cm ²	ASTM D 790
Flexural Modulus, 6.4 mm	19600	kgf/cm ²	ASTM D 790
IMPACT			
FOAM - IMPACT 6.4 mm Wt Reduction	10	%	-
Izod Impact, unnotched, 23°C, 6.4mm	272	cm-kgf/cm	ASTM D 4812
Falling Dart Impact, 23°C	1244	cm-kgf	SABIC Method
Instrumented Impact Total Energy, -20°C	691	cm-kgf	ASTM D 3763
Instrumented Impact Total Energy, -40°C	82	cm-kgf	ASTM D 3763
THERMAL			
FOAM - THERMAL 6.4mm Wt Reduction	10	%	-
HDT, 0.45 MPa, 6.4 mm, unannealed	137	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	126	°C	ASTM D 648
CTE, -40°C to 95°C, flow	5.58E-05	1/°C	ASTM E 831
Specific Heat	1.18	J/g-°C	ASTM C 351
Relative Temp Index, Elec	80	°C	UL 746B
Relative Temp Index, Mech w/impact	80	°C	UL 746B
Relative Temp Index, Mech w/o impact	80	°C	UL 746B
PHYSICAL			
FOAM - PHYSICAL 6.4mm Wt Reduction	10	%	-
Specific Gravity	1.21	-	ASTM D 792



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TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
PHYSICAL			
Specific Gravity, foam molded	1.09	-	ASTM D 792
Water Absorption, 24 hours	0.13	%	ASTM D 570
Water Absorption, equilibrium, 23C	0.34	%	ASTM D 570
Mold Shrinkage, flow, 6.4 mm (5)	0.6 - 0.8	%	SABIC Method
Melt Flow Rate, 300°C/1.2 kgf	10.3	g/10 min	ASTM D 1238
ELECTRICAL			
FOAM - ELECTRICAL 6.4 mm Wt Reduction	20	%	-
Volume Resistivity	3.6E+16	Ohm-cm	ASTM D 257
Surface Resistivity	>1.1E+17	Ohm	ASTM D 257
Relative Permittivity, 100 Hz	2.47	-	ASTM D 150
Relative Permittivity, 1 MHz	2.68	-	ASTM D 150
Dissipation Factor, 100 Hz	0.0037	-	ASTM D 150
Dissipation Factor, 1 MHz	0.0039	-	ASTM D 150
Arc Resistance, Tungsten {PLC}	6	PLC Code	ASTM D 495
Hot Wire Ignition {PLC}	0	PLC Code	UL 746A
High Voltage Arc Track Rate {PLC}	3	PLC Code	UL 746A
High Ampere Arc Ign, surface {PLC}	0	PLC Code	UL 746A
Comparative Tracking Index (UL) {PLC}	4	PLC Code	UL 746A
FLAME CHARACTERISTICS			
FOAM - Flame Class Minimum Density	0.94	g/cm ³	-
UL Recognized, 94HB Flame Class Rating (3)	3.91	mm	UL 94
UL Recognized, 94V-1 Flame Class Rating (3)	5.99	mm	UL 94
Oxygen Index (LOI)	28.2	%	ASTM D 2863



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• MOLD SHRINKAGE - 0.6% - 0.8% (NOTE: Shrink values as high as 1.0% can occur under extreme weight reduction and/or low cavity pressure conditions.)

PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Structural Foam Molding		
Blowing Agent, Physical System	Nitrogen Gas	-
Blowing Agent, Chemical System	FLC298	-
Drying Time (Blowing Agent)	4	hrs
Drying Temperature (Blowing Agent)	105	°C
Concentration Range (Blowing Agent)	3 - 5	%
Recommended Concentration (Blowing Agent)	1.5	%
Drying Temperature (Resin)	120	°C
Drying Time (Resin)	3 - 4	hrs
Drying Time (Resin, Cumulative)	48	hrs
Melt Temperature	290 - 310	°C
Nozzle Temperature	280 - 305	°C
Front Temperature	295 - 315	°C
Middle Temperature	295 - 315	°C
Rear Temperature	240 - 260	°C
Mold Temperature	70 - 95	°C