



LEXAN™ Resin GF1311R

Asia Pacific: COMMERCIAL

Lexan® GF1311R Polycarbonate (PC) resin is a 15% glass fiber filled, injection moldable grade.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	740	kgf/cm ²	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	610	kgf/cm ²	ASTM D 638
Tensile Strain, yld, Type I, 5 mm/min	3.7	%	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	5.9	%	ASTM D 638
Tensile Modulus, 5 mm/min	42500	kgf/cm ²	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	1310	kgf/cm ²	ASTM D 790
Flexural Stress, brk, 1.3 mm/min, 50 mm span	1290	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	40300	kgf/cm ²	ASTM D 790
IMPACT			
Izod Impact, notched, 23°C	9	cm-kgf/cm	ASTM D 256
THERMAL			
HDT, 1.82 MPa, 3.2mm, unannealed	138	°C	ASTM D 648
PHYSICAL			
Specific Gravity	1.29	-	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 Volume Rate, MVR at 300°C/1.2 kg	5	cm ³ /10 min	ASTM D 1238



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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	120	°C
Drying Time	2 - 4	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	290 - 320	°C
Nozzle Temperature	280 - 310	°C
Front - Zone 3 Temperature	290 - 320	°C
Middle - Zone 2 Temperature	280 - 310	°C
Rear - Zone 1 Temperature	270 - 300	°C
Hopper Temperature	60 - 80	°C
Mold Temperature	80 - 120	°C