



LEXAN™ Resin LGK3020
Asia Pacific: COMMERCIAL

Glass reinforced. Flame retardant.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, brk, Type I, 50 mm/min	1200	kgf/cm ²	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	1500	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	67000	kgf/cm ²	ASTM D 790
IMPACT			
Izod Impact, notched, 23°C	12	cm-kgf/cm	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 (5)	0.05 - 0.25	%	SABIC Method
Mold Shrinkage, xflow, 3.2 mm (5)	0.15 - 0.35	%	SABIC 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



LEXAN™ Resin LGK3020
Asia Pacific: COMMERCIAL

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