



LEXAN® OQ4620R
Americas: **COMMERCIAL**

Optical grade with UV cut-off up to 400 nm, greater optical purity than standard grades. For needs of sunglass and sunvisor markets.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	62	MPa	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	130	%	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	98	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	2340	MPa	ASTM D 790
IMPACT			
Izod Impact, notched, 23°C	748	J/m	ASTM D 256
Falling Dart Impact (D 3029), 23°C	169	J	ASTM D 3029
THERMAL			
HDT, 1.82 MPa, 6.4 mm, unannealed	132	°C	ASTM D 648
PHYSICAL			
Specific Gravity	1.2	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	0.5 - 0.7	%	GE Method
Melt Flow Rate, 300°C/1.2 kgf	8.5	g/10 min	ASTM D 1238



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+188-1699-6168 (ShangHai)
+852-6957-5415 (HongKong)

GE Plastics

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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