



LEXAN™ Resin SLD3000
Asia Pacific: COMMERCIAL

Antistatic colorable/opaque FR PC grade

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yield, 50 mm/min	530	kgf/cm ²	ASTM D 638
Flexural Stress, yield, 6.4 mm	810	kgf/cm ²	ASTM D 790
Flexural Modulus	20700	kgf/cm ²	ASTM D 790
Tensile Strain, break, 50 mm/min	200	%	ISO 527
IMPACT			
Izod Impact, notched, 23°C	71	cm-kgf/cm	ASTM D 256
THERMAL			
HDT, 1.82 MPa, 6.4 mm, unannealed	100	°C	ASTM D 648
PHYSICAL			
Specific Gravity	1.21	-	ASTM D 792
Mold Shrinkage, flow, 1.5-3.2 mm (5)	0.4	%	SABIC Method
Mold Shrinkage, xflow, 1.5-3.2 mm (5)	0.5	%	SABIC Method
Melt Flow Rate, 260°C/2.16 kgf	19	g/10 min	ASTM D 1238
ELECTRICAL			
Surface Resistivity	1.2E+12	Ohm	ASTM D 257
FLAME CHARACTERISTICS			
UL Recognized, 94HB Flame Class Rating (3)	0.5	mm	UL 94
UL Recognized, 94V-2 Flame Class Rating (3)	1	mm	UL 94



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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	90 - 100	°C
Drying Time	4 - 6	hrs
Drying Time (Cumulative)	8	hrs
Maximum Moisture Content	0.04	%
Melt Temperature	240 - 260	°C
Nozzle Temperature	230 - 260	°C
Front - Zone 3 Temperature	230 - 260	°C
Middle - Zone 2 Temperature	220 - 255	°C
Rear - Zone 1 Temperature	220 - 245	°C
Mold Temperature	30 - 70	°C
Back Pressure	0.3 - 0.7	MPa
Screw Speed	40 - 70	rpm
Shot to Cylinder Size	30 - 80	%
Vent Depth	0.38 - 0.76	mm