



Lexan* Resin 121

Europe-Africa-Middle East: COMMERCIAL

LEXAN 121 is a low viscosity multi purpose grade available in transparent, translucent and opaque colours.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
MECHANICAL			
Taber Abrasion, CS-17, 1 kg	10	mg/1000cy	SABIC Method
Tensile Stress, yield, 50 mm/min	63	MPa	ISO 527
Tensile Stress, break, 50 mm/min	65	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	6	%	ISO 527
Tensile Strain, break, 50 mm/min	100	%	ISO 527
Tensile Modulus, 1 mm/min	2350	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	90	MPa	ISO 178
Flexural Modulus, 2 mm/min	2300	MPa	ISO 178
Hardness, H358/30	95	MPa	ISO 2039-1
IMPACT			
Izod Impact, unnotched 80*10*3 +23°C	NB	kJ/m ²	ISO 180/1U
Izod Impact, unnotched 80*10*3 -30°C	NB	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*3 +23°C	65	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*3 -30°C	11	kJ/m ²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*3 sp=62mm	65	kJ/m ²	ISO 179/1eA
Charpy -30°C, V-notch Edgew 80*10*3 sp=62mm	12	kJ/m ²	ISO 179/1eA
Charpy 23°C, Unnotch Edgew 80*10*3 sp=62mm	NB	kJ/m ²	ISO 179/1eU
Charpy -30°C, Unnotch Edgew 80*10*3 sp=62mm	NB	kJ/m ²	ISO 179/1eU
Charpy Impact, notched, 23°C	35	kJ/m ²	ISO 179/2C
THERMAL			
Thermal Conductivity	0.2	W/m-°C	ISO 8302
CTE, 23°C to 80°C, flow	7.E-05	1/°C	ISO 11359-2
Ball Pressure Test, 125°C +/- 2°C	PASSES	-	IEC 60695-10-2



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THERMAL			
Ball Pressure Test, approximate maximum	140	°C	IEC 60695-10-2
Vicat Softening Temp, Rate B/50	140	°C	ISO 306
Vicat Softening Temp, Rate B/120	141	°C	ISO 306
HDT/Be, 0.45MPa Edgew 120*10*4 sp=100mm	133	°C	ISO 75/Be
HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm	122	°C	ISO 75/Ae
Relative Temp Index, Elec	130	°C	UL 746B
Relative Temp Index, Mech w/impact	125	°C	UL 746B
Relative Temp Index, Mech w/o impact	125	°C	UL 746B
PHYSICAL			
Mold Shrinkage on Tensile Bar, flow (2)	0.5 - 0.7	%	SABIC Method
Density	1.2	g/cm ³	ISO 1183
Water Absorption, (23°C/sat)	0.35	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.15	%	ISO 62
Melt Volume Rate, MVR at 300°C/1.2 kg	21	cm ³ /10 min	ISO 1133
OPTICAL			
Light Transmission	88 - 90	%	ASTM D 1003
Haze	<0.8	%	ASTM D 1003
Refractive Index	1.586	-	ISO 489
ELECTRICAL			
Volume Resistivity	>1.E+15	Ohm-cm	IEC 60093
Surface Resistivity, ROA	>1.E+15	Ohm	IEC 60093
Dielectric Strength, in oil, 3.2 mm	17	kV/mm	IEC 60243-1
Relative Permittivity, 50/60 Hz	2.7	-	IEC 60250
Relative Permittivity, 1 MHz	2.7	-	IEC 60250
Dissipation Factor, 50/60 Hz	0.001	-	IEC 60250
Dissipation Factor, 1 MHz	0.01	-	IEC 60250



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FLAME CHARACTERISTICS			
UL Recognized, 94HB Flame Class Rating (3)	0.7	mm	UL 94
UL Recognized, 94HB Flame Class Rating 2nd value (3)	3	mm	UL 94
Glow Wire Flammability Index 850°C, passes at	1	mm	IEC 60695-2-12
Oxygen Index (LOI)	25	%	ISO 4589



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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	280 - 300	°C
Nozzle Temperature	270 - 290	°C
Front - Zone 3 Temperature	280 - 300	°C
Middle - Zone 2 Temperature	270 - 290	°C
Rear - Zone 1 Temperature	260 - 280	°C
Hopper Temperature	60 - 80	°C
Mold Temperature	80 - 100	°C

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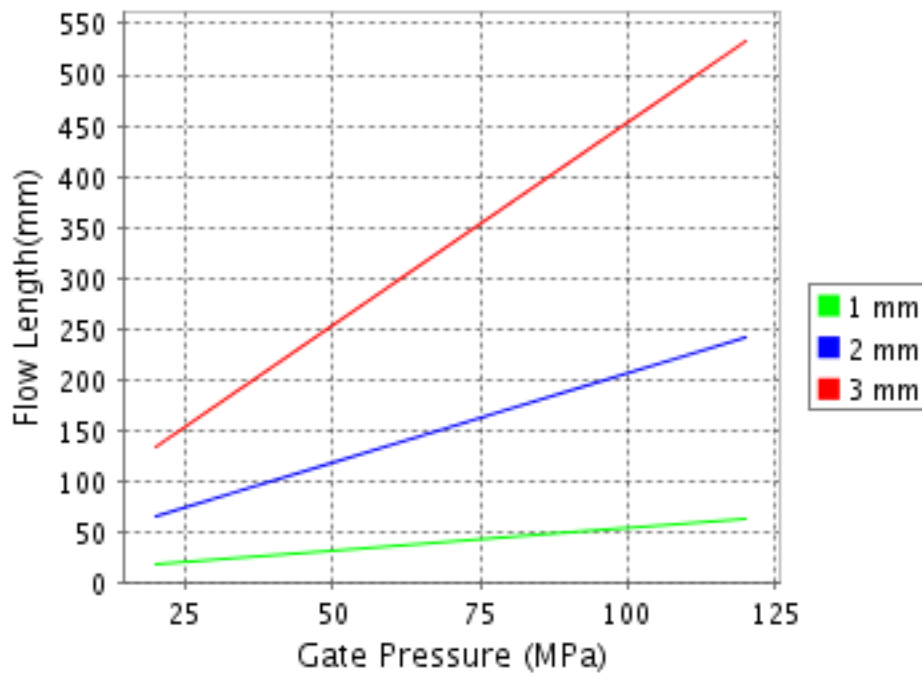
CALCULATED FLOW LENGTH INDICATION

Moldflow® Radial Flow Analysis

Lexan* 121

Melt Temperature : 290°C

Mold Temperature : 90°C



Note: Technical support is recommended if Gate Pressure is greater than 80 MPa. Contact your local representative.

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