

# LEXAN™ COPOLYMER FXE4271L

REGION ASIA

## DESCRIPTION

LEXAN FXE4271L is a 10% glass filled, impact modified polycarbonate with excellent light-shield capability. It is designed for high flow, superior surface appearance, enhance release and good impact ductility. FXE4271L is available in white color only and ideal for light-shield applications.

## TYPICAL PROPERTY VALUES

Revision 20170913

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
<b>MECHANICAL</b>			
Tensile Stress, yld, Type I, 5 mm/min	48	MPa	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	37	MPa	ASTM D 638
Tensile Strain, yld, Type I, 5 mm/min	4	%	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	11	%	ASTM D 638
Tensile Modulus, 5 mm/min	3850	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	87	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	3600	MPa	ASTM D 790
<b>IMPACT</b>			
Izod Impact, unnotched, 23°C	1880	J/m	ASTM D 4812
Izod Impact, notched, 23°C	205	J/m	ASTM D 256
Instrumented Impact Total Energy, 23°C	36	J	ASTM D 3763
<b>THERMAL</b>			
HDT, 0.45 MPa, 3.2 mm, unannealed	127	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	120	°C	ASTM D 648
Vicat Softening Temp, Rate B/120	132	°C	ISO 306
Relative Temp Index, Elec	80	°C	UL 746B
Relative Temp Index, Mech w/impact	80	°C	UL 746B
Relative Temp Index, Mech w/o impact	80	°C	UL 746B
<b>PHYSICAL</b>			
Specific Gravity	1.25	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm (5)	0.2 – 0.3	%	SABIC method
Mold Shrinkage, xflow, 3.2 mm (5)	0.4 – 0.5	%	SABIC method
Melt Flow Rate, 300°C/1.2 kgf	15	g/10 min	ASTM D 1238
Density	1.25	g/cm <sup>3</sup>	ISO 1183

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Water Absorption, (23°C/sat)	0.13	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.04	%	ISO 62
Melt Volume Rate, MVR at 300°C/1.2 kg	14	cm <sup>3</sup> /10 min	ISO 1133
<b>OPTICAL</b>			
Light Transmission at 0.4 mm	<- 2.5	%	SABIC method
<b>INJECTION MOLDING</b>			
Drying Temperature	120	°C	
Drying Time	3 – 4	hrs	
Drying Time (Cumulative)	48	hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	290 – 310	°C	
Nozzle Temperature	280 – 305	°C	
Front - Zone 3 Temperature	290 – 310	°C	
Middle - Zone 2 Temperature	275 – 300	°C	
Rear - Zone 1 Temperature	265 – 290	°C	
Mold Temperature	70 – 95	°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	

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