

LEXAN™ LGK3020 resin

Polycarbonate

SABIC Innovative Plastics Asia Pacific

Message:

Glass reinforced. Flame retardant.

General Information			
UL YellowCard	E45587-236909	E207780-228440	
Filler / Reinforcement	Glass Fiber		
Additive	Flame Retardant		
Features	Flame Retardant		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.43	g/cm ³	ASTM D792
Molding Shrinkage			Internal Method
Flow : 3.20 mm	0.050 to 0.25	%	
Across Flow : 3.20 mm	0.15 to 0.35	%	
Water Absorption (24 hr)	0.13	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Break)	118	MPa	ASTM D638
Tensile Elongation ² (Break)	4.0	%	ASTM D638
Flexural Modulus ³ (50.0 mm Span)	6580	MPa	ASTM D790
Flexural Strength ⁴ (Break, 50.0 mm Span)	148	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	120	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 6.40 mm)	146	°C	ASTM D648
CLTE			ASTM D696
Flow : -30 to 30°C	2.7E-5	cm/cm/°C	
Transverse : -30 to 30°C	4.7E-5	cm/cm/°C	
Electrical	Nominal Value	Unit	Test Method
Dielectric Strength (3.20 mm, in Oil)	18	kV/mm	ASTM D149
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.60 mm)	V-0		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	121	°C	
Drying Time	3.0 to 4.0	hr	
Drying Time, Maximum	48	hr	
Suggested Max Moisture	0.020	%	

Suggested Shot Size	40 to 60	%
Rear Temperature	293 to 316	°C
Middle Temperature	304 to 327	°C
Front Temperature	316 to 338	°C
Nozzle Temperature	310 to 332	°C
Processing (Melt) Temp	316 to 338	°C
Mold Temperature	82.2 to 116	°C
Back Pressure	0.345 to 0.689	MPa
Screw Speed	40 to 70	rpm
Vent Depth	0.025 to 0.076	mm

NOTE

- | | |
|----|-------------------|
| 1. | Type I, 50 mm/min |
| 2. | Type I, 50 mm/min |
| 3. | 1.3 mm/min |
| 4. | 1.3 mm/min |

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Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China



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