

LEXAN™ SLD3000 resin

Polycarbonate

SABIC Innovative Plastics Asia Pacific

Message:

Antistatic colorable/opaque FR PC grade

General Information			
UL YellowCard	E207780-228454		
Additive	Antistatic		
Features	Antistatic		
	Flame Retardant		
Appearance	Opaque		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.21	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (260°C/2.16 kg)	19	g/10 min	ASTM D1238
Molding Shrinkage ¹			Internal Method
Flow	0.40	%	
Across Flow	0.50	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ² (Yield)	52.0	MPa	ASTM D638
Tensile Strain (Break)	200	%	ISO 527-2/50
Flexural Modulus	2040	MPa	ASTM D790
Flexural Strength (Yield, 6.40 mm)	80.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	700	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 6.40 mm)	100	°C	ASTM D648
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.2E+12	ohms	ASTM D257
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
0.500 mm	HB		
1.00 mm	V-2		
Injection	Nominal Value	Unit	
Drying Temperature	90.0 to 100	°C	
Drying Time	4.0 to 6.0	hr	
Drying Time, Maximum	8.0	hr	

Suggested Max Moisture	0.040	%
Suggested Shot Size	30 to 80	%
Rear Temperature	220 to 245	°C
Middle Temperature	220 to 255	°C
Front Temperature	230 to 260	°C
Nozzle Temperature	230 to 260	°C
Processing (Melt) Temp	240 to 260	°C
Mold Temperature	30.0 to 70.0	°C
Back Pressure	0.300 to 0.700	MPa
Screw Speed	40 to 70	rpm
Vent Depth	0.38 to 0.76	mm

NOTE

1. 1.5 to 3.2 mm
2. 50 mm/min

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