

## Lexan\* Resin FL410

Americas: COMMERCIAL

Various weight reductions at 0.250: (6.38 mm) wall. Thin wall capability high flexural mod, strength and creep resistant. V-0/5V - 0.157"(3.98 mm).

### Property

TYPICAL PROPERTIES <sup>(1)</sup>			
	Value	Unit	Standard
<b>MECHANICAL</b>			
FOAM - MECHANICAL 6.4 mm Wt Reduction	10	%	-
Tensile Stress, yield, 6.35 mm	50	MPa	ASTM D 638
Tensile Strain, break, 6.35 mm	4.8	%	ASTM D 638
Tensile Modulus, 6.4 mm	3170	MPa	ASTM D 638
Flexural Stress, yield, 6.4 mm	93	MPa	ASTM D 790
Flexural Modulus, 6.4 mm	3820	MPa	ASTM D 790
<b>IMPACT</b>			
FOAM - IMPACT 6.4 mm Wt Reduction	10	%	-
Izod Impact, unnotched, 23°C	854	J/m	ASTM D 4812
Falling Dart Impact, 23°C	46	J	SABIC Method
<b>THERMAL</b>			
FOAM - THERMAL 6.4mm Wt Reduction	10	%	-
HDT, 0.45 MPa, 6.4 mm, unannealed	137	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	132	°C	ASTM D 648
CTE, -40°C to 95°C, flow	3.24E-05	1/°C	ASTM E 831
Specific Heat	1.15	J/g-°C	ASTM C 351
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>			
FOAM - PHYSICAL 6.4mm Wt Reduction	10	%	-
Specific Gravity	1.25	-	ASTM D 792
Specific Gravity, foam molded	1.13	-	ASTM D 792
Water Absorption, 24 hours	0.14	%	ASTM D 570
Water Absorption, equilibrium, 23C	0.31	%	ASTM D 570
Mold Shrinkage, flow, 6.4 mm	0.4 - 0.6	%	SABIC Method
<b>ELECTRICAL</b>			
FOAM - ELECTRICAL 6.4 mm Wt Reduction	20	%	-
Volume Resistivity	2.4E+17	Ohm-cm	ASTM D 257
Surface Resistivity	>1.1E+17	Ohm	ASTM D 257
Relative Permittivity, 100 Hz	2.4	-	ASTM D 150
Relative Permittivity, 1 MHz	2.32	-	ASTM D 150
Dissipation Factor, 100 Hz	0.0028	-	ASTM D 150
Dissipation Factor, 1 MHz	0.0081	-	ASTM D 150
Arc Resistance, Tungsten {PLC}	7	PLC Code	ASTM D 495
High Voltage Arc Track Rate {PLC}	4	PLC Code	UL 746A
Comparative Tracking Index (UL) {PLC}	4	PLC Code	UL 746A
<b>FLAME CHARACTERISTICS</b>			
	Value	Unit	Standard

FOAM - Flame Class Minimum Density	1	g/cm <sup>3</sup>	-
UL Recognized, 94V-0 Flame Class Rating (3)	2.99	mm	UL 94
UL Recognized, 94-5VA Rating (3)	3.81	mm	UL 94
CSA (See File for complete listing)	LS88480	File No.	CSA LISTED

Source GMD, last updated:08/07/1989

## Processing

Parameter	Value	Unit
Structural Foam Molding		
Blowing Agent, Physical System	Nitrogen Gas	-
Blowing Agent, Chemical System	FLC298	-
Drying Time (Blowing Agent)	4	hrs
Drying Temperature (Blowing Agent)	105	°C
Concentration Range (Blowing Agent)	3 - 5	%
Recommended Concentration (Blowing Agent)	1.5	%
Drying Temperature (Resin)	120	°C
Drying Time (Resin)	3 - 4	hrs
Drying Time (Resin, Cumulative)	48	hrs
Melt Temperature	290 - 310	°C
Nozzle Temperature	265 - 290	°C
Front Temperature	300 - 305	°C
Middle Temperature	300 - 305	°C
Rear Temperature	255 - 265	°C
Mold Temperature	70 - 95	°C

Source GMD, last updated:08/07/1989

THESE PROPERTY VALUES ARE NOT INTENDED FOR SPECIFICATION PURPOSES.

PLEASE CHECK WITH YOUR [\(LOCAL SALES OFFICE\)](#) FOR AVAILABILITY IN YOUR REGION

(1) Typical values only. Variations within normal tolerances are possible for various colors. All values are measured after at least 48 hours storage at 23°C/50% relative humidity. All properties, except the melt volume and melt flow rates, are measured on injection molded samples. All samples tested under ISO test standards are prepared according to ISO 294.

(2) Only typical data for selection purposes. Not to be used for part or tool design.

(3) This rating is not intended to reflect hazards presented by this or any other material under actual fire conditions.

(4) Internal measurements according to UL standards.

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