

Lexan* Resin PK2640

Americas: COMMERCIAL

FDA. 7.0 MFR. Injection/injection blowmolding packaging applications. Good clarity, heat resistance, property retention, dimensional stability.

Property

TYPICAL PROPERTIES ⁽¹⁾			
MECHANICAL	Value	Unit	Standard
Tensile Stress, yld, Type I, 50 mm/min	62	MPa	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	65	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	93	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	2340	MPa	ASTM D 790
IMPACT	Value	Unit	Standard
Izod Impact, notched, 23°C	747	J/m	ASTM D 256
THERMAL	Value	Unit	Standard
Vicat Softening Temp, Rate B/50	154	°C	ASTM D 1525
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
PHYSICAL	Value	Unit	Standard
Specific Gravity	1.2	-	ASTM D 792
Melt Flow Rate, 300°C/1.2 kgf	7	g/10 min	ASTM D 1238

Source GMD, last updated:01/04/2000

Processing

- For typical injection blow molding conditions, please contact your technical service representative. Variables required for selection of proper resin and processing conditions include container size and weight, machine and plasticizer type/size, screw design, machine cavitation, and mold temperature control zones.

Parameter	Value	Unit
Injection Molding		
Drying Temperature	120	°C
Drying Time	3 - 5	hrs
Drying Time (Cumulative)	48	hrs
Melt Temperature	315 - 345	°C
Nozzle Temperature	305 - 330	°C
Front - Zone 3 Temperature	315 - 340	°C
Middle - Zone 2 Temperature	295 - 315	°C
Rear - Zone 1 Temperature	290 - 305	°C
Mold Temperature	80 - 115	°C
Back Pressure	0.3 - 1.4	MPa
Screw Speed	40 - 70	rpm
Shot to Cylinder Size	40 - 60	%
Vent Depth	0.038 - 0.076	mm

Source GMD, last updated:01/04/2000

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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