

Lexan* Resin SP6400R

Americas: LIMITED USE

High flow, impact modified, SP polycarbonate copolymer. Izod Impact, notched (aged 85C/85% RH; 1 week - 12.1 ft-lb/in).

Property

TYPICAL PROPERTIES ⁽¹⁾			
MECHANICAL	Value	Unit	Standard
Tensile Stress, yld, Type I, 50 mm/min	53	MPa	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	53	MPa	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	100	%	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	79	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	1990	MPa	ASTM D 790
IMPACT	Value	Unit	Standard
Izod Impact, notched, 23°C	694	J/m	ASTM D 256
Izod Impact, notched, -40°C	640	J/m	ASTM D 256
Instrumented Impact Energy @ peak, 23°C	39	J	ASTM D 3763
Instrumented Impact Energy @ peak, -40°C	54	J	ASTM D 3763
THERMAL	Value	Unit	Standard
HDT, 1.82 MPa, 3.2mm, unannealed	95	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	107	°C	ASTM D 648
PHYSICAL	Value	Unit	Standard
Specific Gravity	1.17	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	0.5 - 0.7	%	SABIC Method
Melt Flow Rate, 300°C/1.2 kgf	28	g/10 min	ASTM D 1238

Source GMD, last updated:01/04/2000

Processing

Parameter	Value	Unit
Injection Molding		
Drying Temperature	105 - 110	°C
Drying Time	3 - 4	hrs
Drying Time (Cumulative)	24	hrs
Melt Temperature	260 - 305	°C
Nozzle Temperature	255 - 300	°C
Front - Zone 3 Temperature	260 - 305	°C
Middle - Zone 2 Temperature	250 - 295	°C
Rear - Zone 1 Temperature	240 - 280	°C
Mold Temperature	50 - 80	°C
Back Pressure	0.3 - 0.7	MPa
Screw Speed	35 - 75	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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