

Lexan* Resin 503R

Europe-Africa-Middle East: COMMERCIAL

LEXAN 503R is a medium viscosity, 10% glass reinforced, flame retardant grade, especially designed for applications requiring high rigidity together with high heat resistance and excellent impact performance.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
MECHANICAL			
Taber Abrasion, CS-17, 1 kg	11	mg/1000cy	SABIC Method
Tensile Stress, yield, 5 mm/min	60	MPa	ISO 527
Tensile Stress, break, 5 mm/min	45	MPa	ISO 527
Tensile Strain, yield, 5 mm/min	5	%	ISO 527
Tensile Strain, break, 5 mm/min	7	%	ISO 527
Tensile Modulus, 1 mm/min	3300	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	95	MPa	ISO 178
Flexural Modulus, 2 mm/min	3400	MPa	ISO 178
Hardness, H358/30	110	MPa	ISO 2039-1
IMPACT			
Izod Impact, unnotched 80*10*3 +23°C	NB	kJ/m ²	ISO 180/1U
Izod Impact, unnotched 80*10*3 -30°C	130	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*3 +23°C	10	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*3 -30°C	8	kJ/m ²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*3 sp=62mm	10	kJ/m ²	ISO 179/1eA
Charpy -30°C, V-notch Edgew 80*10*3 sp=62mm	9	kJ/m ²	ISO 179/1eA
Charpy 23°C, Unnotch Edgew 80*10*3 sp=62mm	NB	kJ/m ²	ISO 179/1eU
Charpy -30°C, Unnotch Edgew 80*10*3 sp=62mm	NB	kJ/m ²	ISO 179/1eU
Charpy Impact, notched, 23°C	15	kJ/m ²	ISO 179/2C
THERMAL			
Thermal Conductivity	0.21	W/m-°C	ISO 8302
CTE, 23°C to 80°C, flow	4.E-05	1/°C	ISO 11359-2
Ball Pressure Test, 125°C +/- 2°C	PASSES	-	IEC 60695-10-2

1) Typical values only. Variations within normal tolerances are possible for various colours. All values are measured at least after 48 hours storage at 23°C/50% relative humidity.
All properties, except the melt volume rate are measured on injection moulded samples.
All samples are prepared according to ISO 294.

2) Only typical data for material selection purpose. 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) Own measurement according to UL.

Source, GMD, Last Update: 03/14/2008

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TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
THERMAL			
Vicat Softening Temp, Rate A/50	150	°C	ISO 306
Vicat Softening Temp, Rate B/50	141	°C	ISO 306
Vicat Softening Temp, Rate B/120	143	°C	ISO 306
HDT/Be, 0.45MPa Edgew 120*10*4 sp=100mm	140	°C	ISO 75/Be
HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm	132	°C	ISO 75/Ae
Relative Temp Index, Elec	120	°C	UL 746B
Relative Temp Index, Mech w/impact	110	°C	UL 746B
Relative Temp Index, Mech w/o impact	120	°C	UL 746B
PHYSICAL			
Mold Shrinkage on Tensile Bar, flow (2)	0.2 - 0.6	%	SABIC Method
Density	1.25	g/cm ³	ISO 1183
Water Absorption, (23°C/sat)	0.31	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.13	%	ISO 62
Melt Volume Rate, MVR at 300°C/1.2 kg	8	cm ³ /10 min	ISO 1133
OPTICAL			
Haze	NA	%	ASTM D 1003
Refractive Index	NA	-	ISO 489
ELECTRICAL			
Volume Resistivity	>1.E+15	Ohm-cm	IEC 60093
Surface Resistivity, ROA	>1.E+15	Ohm	IEC 60093
Dielectric Strength, shorttime, 1.0mm	18	kV/mm	IEC 60243-1
Dielectric Strength, in oil, 3.2 mm	16	kV/mm	IEC 60243-1
Relative Permittivity, 50/60 Hz	2.9	-	IEC 60250
Relative Permittivity, 1 MHz	2.8	-	IEC 60250
Dissipation Factor, 50/60 Hz	0.001	-	IEC 60250
Dissipation Factor, 1 MHz	0.01	-	IEC 60250

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TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
ELECTRICAL			
Comparative Tracking Index	175	V	IEC 60112
Comparative Tracking Index, M	100	V	IEC 60112
FLAME CHARACTERISTICS			
UL Recognized, 94V-0 Flame Class Rating (3)	1.5	mm	UL 94
UL Recognized, 94-5VA Rating (3)	3	mm	UL 94
Glow Wire Flammability Index 960°C, passes at	1	mm	IEC 60695-2-12
Oxygen Index (LOI)	36	%	ISO 4589

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PROCESSING PARAMETERS	TYPICAL VALUE	UNIT
Injection Molding		
Drying Temperature	120	°C
Drying Time	2 - 4	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	290 - 320	°C
Nozzle Temperature	280 - 310	°C
Front - Zone 3 Temperature	290 - 320	°C
Middle - Zone 2 Temperature	280 - 310	°C
Rear - Zone 1 Temperature	270 - 300	°C
Hopper Temperature	60 - 80	°C
Mold Temperature	80 - 120	°C

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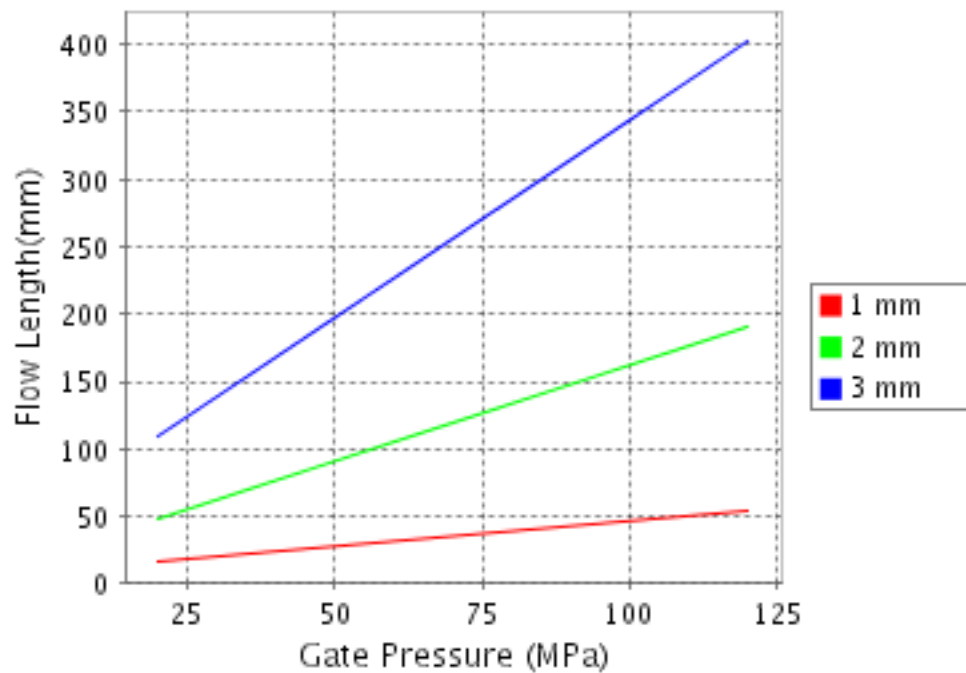
CALCULATED FLOW LENGTH INDICATION

Moldflow® Radial Flow Analysis

Lexan® 503R

Melt Temperature : 300°C

Mold Temperature : 100°C



Note: Technical support is recommended if Gate Pressure is greater than 80 MPa. Contact your local representative.

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