

## Lexan\* Resin EXRL0303 Europe-Africa-Middle East: DEVELOPMENTAL

LEXAN EXRL0303 is an optical quality, high purity PC resin optimized for the demanding short cycle times used in CD and DVD production. Advances in technology further enhanced the processability while maintaining the ductility.

### Property

TYPICAL PROPERTIES <sup>(1)</sup>			
MECHANICAL	Value	Unit	Standard
Tensile Stress, yield, 50 mm/min	60	MPa	ISO 527
Tensile Stress, break, 50 mm/min	45	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	6	%	ISO 527
Tensile Strain, break, 50 mm/min	>40	%	ISO 527
Tensile Modulus, 1 mm/min	2350	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	90	MPa	ISO 178
Flexural Modulus, 2 mm/min	2350	MPa	ISO 178
THERMAL	Value	Unit	Standard
CTE, 23°C to 80°C, flow	7.E-05	1/°C	ISO 11359-2
CTE, 23°C to 80°C, xflow	7.E-05	1/°C	ISO 11359-2
Vicat Softening Temp, Rate B/50	138	°C	ISO 306
Vicat Softening Temp, Rate B/120	140	°C	ISO 306
HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm	124	°C	ISO 75/Ae
PHYSICAL	Value	Unit	Standard
Density	1.2	g/cm <sup>3</sup>	ISO 1183
Water Absorption, (23°C/sat)	0.35	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.15	%	ISO 62
Melt Volume Rate, MVR at 250°C/1.2 kg	8	cm <sup>3</sup> /10 min	ISO 1133

Source GMD, last updated:03/27/2007

### Processing

Parameter	Value	Unit
Injection Molding		
Drying Temperature	120	°C
Drying Time	4 - 6	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	340 - 370	°C
Nozzle Temperature	340 - 370	°C
Front - Zone 3 Temperature	350 - 380	°C
Middle - Zone 2 Temperature	320 - 340	°C
Rear - Zone 1 Temperature	270 - 290	°C
Hopper Temperature	60 - 80	°C
Mold Temperature	75 - 95	°C

Source GMD, last updated:03/27/2007

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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