

Lexan* Resin 121RP

Asia Pacific: DEVELOPMENTAL

Another preliminary Datasheet

Property

TYPICAL PROPERTIES ⁽¹⁾			
MECHANICAL	Value	Unit	Standard
Tensile Stress, yield, 5 mm/min	43	MPa	ISO 527
Tensile Stress, break, 5 mm/min	43	MPa	ISO 527
Tensile Strain, yield, 5 mm/min	43	%	ISO 527
Tensile Strain, break, 5 mm/min	546	%	ISO 527
Tensile Modulus, 1 mm/min	3240	MPa	ISO 527
IMPACT	Value	Unit	Standard
Izod Impact, unnotched 80*10*4 +23°C	356	kJ/m ²	ISO 180/1U
Izod Impact, unnotched 80*10*4 -30°C	34	kJ/m ²	ISO 180/1U
THERMAL	Value	Unit	Standard
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	54	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	34	°C	ISO 75/Af
PHYSICAL	Value	Unit	Standard
Melt Volume Rate, MVR at 220°C/5.0 kg	43	cm ³ /10 min	ISO 1133

Source GMD, last updated:09/24/2003

Processing

Parameter	Value	Unit
Extrusion Blow Molding		
Drying Temperature	95 - 100	°C
Drying Time	4 - 6	hrs
Drying Time (Cumulative)	24	hrs
Maximum Moisture Content	0.01 - 0.02	%
Minimum Moisture Content	0.02	%
Melt Temperature (Parison)	240 - 250	°C
Barrel - Zone 1 Temperature	235 - 245	°C
Barrel - Zone 2 Temperature	235 - 245	°C
Barrel - Zone 3 Temperature	235 - 245	°C
Barrel - Zone 4 Temperature	235 - 245	°C
Adapter - Zone 5 Temperature	235 - 245	°C
Head - Zone 6 - Top Temperature	235 - 245	°C
Head - Zone 7 - Bottom Temperature	235 - 245	°C
Mold Temperature	65 - 90	°C
Die Temperature	240 - 250	°C

Source GMD, last updated:09/24/2003

- Purge with HDPE prior to changing screw, head, or die tooling and/or machine shutdown.
- Use moderate-slow screw speeds to keep melt temperature in suggested range. Suggested screw speed: 15 - 50 rpm. Actual rpm should be adjusted for desired output.
- Processing temperature must be measured with a hand-held probe as opposed to an internal-head probe.
- A reverse barrel profile may increase output while maintaining the melt temperature.

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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