

## Lexan\* Resin PPC4701R

Americas: COMMERCIAL

High heat resistant polyphthlate carbonate, provides DTUL of 300F at 264 psi. Internal mold release.

### Property

TYPICAL PROPERTIES <sup>(1)</sup>			
	Value	Unit	Standard
<b>MECHANICAL</b>			
Tensile Stress, yld, Type I, 50 mm/min	65	MPa	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	77	MPa	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	78	%	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	97	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	2330	MPa	ASTM D 790
Hardness, Rockwell M	92	-	ASTM D 785
Hardness, Rockwell R	127	-	ASTM D 785
<b>IMPACT</b>			
Izod Impact, unnotched, 23°C	3204	J/m	ASTM D 4812
Izod Impact, notched, 23°C	373	J/m	ASTM D 256
Tensile Impact, Type "S"	577	kJ/m <sup>2</sup>	ASTM D 1822
Falling Dart Impact (D 3029), 23°C	149	J	ASTM D 3029
<b>THERMAL</b>			
HDT, 1.82 MPa, 3.2mm, unannealed	148	°C	ASTM D 648
CTE, -40°C to 95°C, flow	8.1E-05	1/°C	ASTM E 831
Specific Heat	1.25	J/g-°C	ASTM C 351
Thermal Conductivity	0.21	W/m-°C	ASTM C 177
Relative Temp Index, Elec	130	°C	UL 746B
Relative Temp Index, Mech w/impact	130	°C	UL 746B
Relative Temp Index, Mech w/o impact	130	°C	UL 746B
<b>PHYSICAL</b>			
Specific Gravity	1.2	-	ASTM D 792
Specific Volume	0.83	cm <sup>3</sup> /g	ASTM D 792
Density	1.19	g/cm <sup>3</sup>	ASTM D 792
Water Absorption, 24 hours	0.19	%	ASTM D 570
Mold Shrinkage, flow, 3.2 mm	0.8 - 1	%	SABIC Method
Melt Flow Rate, 300°C/1.2 kgf	2	g/10 min	ASTM D 1238
<b>OPTICAL</b>			
Light Transmission	85	%	ASTM D 1003
Haze	1	%	ASTM D 1003
Refractive Index	1.6	-	ASTM D 542
<b>ELECTRICAL</b>			
Volume Resistivity	>2.5E+17	Ohm-cm	ASTM D 257
Dielectric Strength, in air, 3.2 mm	20	kV/mm	ASTM D 149
Relative Permittivity, 50/60 Hz	3.27	-	ASTM D 150
Relative Permittivity, 1 MHz	3.1	-	ASTM D 150
Dissipation Factor, 50/60 Hz	0.0016	-	ASTM D 150
Dissipation Factor, 100 Hz	0.026	-	ASTM D 150
Arc Resistance, Tungsten {PLC}	6	PLC Code	ASTM D 495

Hot Wire Ignition {PLC}	2	PLC Code	UL 746A
High Voltage Arc Track Rate {PLC}	3	PLC Code	UL 746A
High Ampere Arc Ign, surface {PLC}	3	PLC Code	UL 746A
Comparative Tracking Index (UL) {PLC}	3	PLC Code	UL 746A
<b>FLAME CHARACTERISTICS</b>	<b>Value</b>	<b>Unit</b>	<b>Standard</b>
UL Recognized, 94HB Flame Class Rating (3)	1.47	mm	UL 94

Source GMD, last updated:08/26/2003

## Processing

Parameter	Value	Unit
Injection Molding		
Drying Temperature	120	°C
Drying Time	3 - 4	hrs
Drying Time (Cumulative)	48	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	350 - 370	°C
Nozzle Temperature	345 - 365	°C
Front - Zone 3 Temperature	350 - 370	°C
Middle - Zone 2 Temperature	340 - 360	°C
Rear - Zone 1 Temperature	325 - 350	°C
Mold Temperature	80 - 115	°C
Back Pressure	0.3 - 0.7	MPa
Screw Speed	40 - 70	rpm
Shot to Cylinder Size	40 - 60	%
Vent Depth	0.025 - 0.076	mm

Source GMD, last updated:08/26/2003

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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