

LEXAN™ OQ4120R resin

Polycarbonate
SABIC Innovative Plastics

Message:
Optical grade with UV cut-off up to 400 nm, greater optical purity than standard grades. For needs of sunglass and sunvisor markets. MFR of 25.

General Information			
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.20	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	25	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm)	0.50 to 0.70	%	Internal Method
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield)	62.1	MPa	ASTM D638
Tensile Elongation ² (Break)	110	%	ASTM D638
Flexural Modulus ³ (50.0 mm Span)	2310	MPa	ASTM D790
Flexural Strength ⁴ (Yield, 50.0 mm Span)	93.1	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	640	J/m	ASTM D256
Instrumented Dart Impact (23°C, Energy at Peak Load)	54.2	J	ASTM D3763
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 6.40 mm)	127	°C	ASTM D648
Injection	Nominal Value	Unit	
Drying Temperature	121	°C	
Drying Time	3.0 to 4.0	hr	
Drying Time, Maximum	48	hr	
Suggested Max Moisture	0.020	%	
Suggested Shot Size	40 to 60	%	
Rear Temperature	249 to 271	°C	
Middle Temperature	260 to 282	°C	
Front Temperature	271 to 293	°C	
Nozzle Temperature	266 to 288	°C	
Processing (Melt) Temp	271 to 293	°C	
Mold Temperature	71.1 to 93.3	°C	
Back Pressure	0.345 to 0.689	MPa	
Screw Speed	40 to 70	rpm	
Vent Depth	0.025 to 0.076	mm	
NOTE			
1.	Type I, 50 mm/min		

2.	Type I, 50 mm/min
3.	1.3 mm/min
4.	1.3 mm/min

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