

LEXAN™ FXE4271L resin

Polycarbonate

SABIC Innovative Plastics Asia Pacific

Message:

LEXAN FXE4271L is a 10% glass filled, impact modified polycarbonate with excellent light-shield capability. It is designed for high flow, superior surface appearance, enhance release and good impact ductility. FXE4271L is available in white color only and ideal for light-shield applications.

General Information			
Filler / Reinforcement	Glass Fiber,10% Filler by Weight		
Additive	Impact Modifier		
Features	Good Impact Resistance		
	Good Mold Release		
	High Flow		
	Impact Modified		
	Outstanding Surface Finish		
Appearance	White		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.25	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	15	g/10 min	ASTM D1238
Melt Volume-Flow Rate (MVR) (300°C/1.2 kg)	14.0	cm ³ /10min	ISO 1133
Molding Shrinkage			Internal Method
Flow : 3.20 mm	0.20 to 0.30	%	
Across Flow : 3.20 mm	0.40 to 0.50	%	
Water Absorption			ISO 62
Saturation, 23°C	0.13	%	
Equilibrium, 23°C, 50% RH	0.040	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ¹	3850	MPa	ASTM D638
Tensile Strength ²			ASTM D638
Yield	48.0	MPa	
Break	37.0	MPa	
Tensile Elongation ³			ASTM D638
Yield	4.0	%	
Break	11	%	
Flexural Modulus ⁴ (50.0 mm Span)	3600	MPa	ASTM D790
Flexural Strength ⁵ (Yield, 50.0 mm Span)	87.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	210	J/m	ASTM D256

Unnotched Izod Impact (23°C)	1900	J/m	ASTM D4812
Instrumented Dart Impact (23°C, Total Energy)	36.0	J	ASTM D3763
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed, 3.20 mm	127	°C	
1.8 MPa, Unannealed, 3.20 mm	120	°C	
Vicat Softening Temperature	132	°C	ISO 306/B120
RTI Elec	80.0	°C	UL 746
RTI Imp	80.0	°C	UL 746
RTI Str	80.0	°C	UL 746
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	266 to 288	°C	
Middle Temperature	277 to 299	°C	
Front Temperature	288 to 310	°C	
Nozzle Temperature	282 to 304	°C	
Processing (Melt) Temp	288 to 310	°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.	5.0 mm/min		
2.	Type I, 5.0 mm/min		
3.	Type I, 5.0 mm/min		
4.	1.3 mm/min		
5.	1.3 mm/min		

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