

LEXAN™ GF1311R resin

Polycarbonate

SABIC Innovative Plastics Asia Pacific

Message:

Lexan® GF1311R Polycarbonate (PC) resin is a 15% glass fiber filled, injection moldable grade.

General Information			
Filler / Reinforcement	Glass Fiber,15% Filler by Weight		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.29	g/cm ³	ASTM D792
Melt Volume-Flow Rate (MVR) (300°C/1.2 kg)	5.00	cm ³ /10min	ASTM D1238
Molding Shrinkage			Internal Method
Flow : 3.20 mm	0.20 to 0.50	%	
Across Flow : 3.20 mm	0.20 to 0.50	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ¹	4170	MPa	ASTM D638
Tensile Strength ²			ASTM D638
Yield	73.0	MPa	
Break	60.0	MPa	
Tensile Elongation ³			ASTM D638
Yield	3.7	%	
Break	5.9	%	
Flexural Modulus ⁴ (50.0 mm Span)	3960	MPa	ASTM D790
Flexural Strength ⁵			ASTM D790
Yield, 50.0 mm Span	129	MPa	
Break, 50.0 mm Span	127	MPa	
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	95	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 3.20 mm)	138	°C	ASTM D648
Injection	Nominal Value	Unit	
Drying Temperature	120	°C	
Drying Time	2.0 to 4.0	hr	
Suggested Max Moisture	0.020	%	
Hopper Temperature	60.0 to 80.0	°C	
Rear Temperature	270 to 300	°C	
Middle Temperature	280 to 310	°C	
Front Temperature	290 to 320	°C	

Nozzle Temperature	280 to 310	°C
Processing (Melt) Temp	290 to 320	°C
Mold Temperature	80.0 to 120	°C

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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