

LEXAN™ SFX173RU resin

Polycarbonate
SABIC Innovative Plastics

Message:

SFX173RU is a transparent SecurFX grade with high flow, mold release and UV stabilizer. This grade is for security applications and contains proprietary authentication technology.

General Information			
Additive	Mold Release		
	UV Stabilizer		
Features	High Flow		
Appearance	Clear/Transparent		
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 Modulus ¹	1570	MPa	ASTM D638
Tensile Strength ²			ASTM D638
Yield	62.0	MPa	
Break	65.0	MPa	
Tensile Elongation ³			ASTM D638
Yield	8.0	%	
Break	120	%	
Flexural Modulus ⁴ (50.0 mm Span)	2300	MPa	ASTM D790
Flexural Strength ⁵ (Yield, 50.0 mm Span)	93.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	640	J/m	ASTM D256
Instrumented Dart Impact (23°C, Total Energy)	58.0	J	ASTM D3763
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 3.20 mm)	126	°C	ASTM D648
Vicat Softening Temperature	144	°C	ASTM D1525 ⁶
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. 50 mm/min
2. Type I, 50 mm/min
3. Type I, 50 mm/min
4. 1.3 mm/min
5. 1.3 mm/min
6. Rate B (120°C/h), Loading 2 (50 N)

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