

LEXAN™ FXG154 resin

Polycarbonate

SABIC Innovative Plastics Asia Pacific

Message:

FXG154 is a LEXAN PC grade with the Diamond effect. Color Package may affect properties, Application testing always recommended.

General Information			
Processing Method	Extrusion blow molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.20	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (200°C/3.8 kg)	2.5	g/10 min	ASTM D1238
Melt Volume-Flow Rate (MVR) (220°C/5.0 kg)	2.40	cm ³ /10min	ISO 1133
Molding Shrinkage - Flow (3.20 mm)	0.50 - 0.70	%	Internal method
Water Absorption			ISO 62
Saturated, 23°C	0.15	%	ISO 62
Equilibrium, 23°C, 50% RH	0.090	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	2680	MPa	ASTM D638
--	2430	MPa	ISO 527-2/1
Tensile Strength			
Yield ²	58.0	MPa	ASTM D638
Yield	61.0	MPa	ISO 527-2/5
Fracture ³	57.0	MPa	ASTM D638
Fracture	54.0	MPa	ISO 527-2/5
Tensile Elongation			
Yield ⁴	5.9	%	ASTM D638
Yield	6.2	%	ISO 527-2/5
Fracture ⁵	39	%	ASTM D638
Fracture	75	%	ISO 527-2/5
Flexural Modulus			
50.0mm span ⁶	2390	MPa	ASTM D790
-- ⁷	2340	MPa	ISO 178
Flexural Stress			
--	94.0	MPa	ISO 178
Yield, 50.0mm span ⁸	98.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ⁹ (23°C)	58	kJ/m ²	ISO 179/1eA
Notched Izod Impact			

-30°C	140	J/m	ASTM D256
23°C	750	J/m	ASTM D256
-30°C ¹⁰	16	kJ/m ²	ISO 180/1A
23°C ¹¹	51	kJ/m ²	ISO 180/1A
Instrumented Dart Impact (23°C, Total Energy)	62.0	J	ASTM D3763
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
1.8 MPa, unannealed, 3.20mm	133	°C	ASTM D648
1.8 MPa, unannealed, 64.0mm span ¹²	129	°C	ISO 75-2/Af
Vicat Softening Temperature			
--	153	°C	ASTM D1525 ¹³
--	147	°C	ISO 306/B50
--	149	°C	ISO 306/B120
Linear thermal expansion coefficient			ASTM E831, ISO 11359-2
Flow: -40 to 40°C	7.0E-5	cm/cm/°C	ASTM E831, ISO 11359-2
Lateral: -40 to 40°C	7.0E-5	cm/cm/°C	ASTM E831, ISO 11359-2
Extrusion	Nominal Value	Unit	
Drying Temperature	121	°C	
Drying Time	2.0 - 4.0	hr	
Suggested Max Moisture	0.020	%	
Cylinder Zone 1 Temp.	260 - 291	°C	
Cylinder Zone 2 Temp.	260 - 291	°C	
Cylinder Zone 3 Temp.	260 - 291	°C	
Cylinder Zone 4 Temp.	260 - 291	°C	
Cylinder Zone 5 Temp.	260 - 291	°C	
Adapter Temperature	260 - 291	°C	
Extrusion instructions			
Melt Temperature (Parison): 266 - 279 °CMinimum Moisture Content: 0.01 %Mold Temperature: 60 - 99 °C			
NOTE			
1.	5.0 mm/min		
2.	Type 1, 5.0 mm/min		
3.	Type 1, 5.0 mm/min		
4.	Type 1, 5.0 mm/min		
5.	Type 1, 5.0 mm/min		
6.	1.3 mm/min		
7.	2.0 mm/min		
8.	1.3 mm/min		
9.	80*10*4 sp=62mm		
10.	80*10*4		
11.	80*10*4		
12.	80*10*4 mm		

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