



LEXAN* 3414R Resin

SABIC Innovative Plastics Europe - Polycarbonate

Friday, August 01, 2008

General Information

Product Description

LEXAN 3414R is a high viscosity, 40% glass reinforced, flame retardant grade, especially designed for applications requiring high rigidity together with high heat resistance.

General

Material Status	• Commercial: Active
Availability	• Europe
Filler / Reinforcement	• Glass Fiber Reinforcement, 40 % Filler by Weight
Additive	• Ignition Resistant
Features	• Flame Retardant • High Rigidity • High Heat Resistance • High Viscosity
RoHS Compliance	• RoHS Compliant
Forms	• Pellets
Processing Method	• Injection Molding

ASTM and ISO Properties¹

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density	1.52 g/cm ³	1.52 g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (300°C/1.2 kg)	0.244 in ³ /10min	4.00 cm ³ /10min	ISO 1133
Molding Shrinkage (Flow)	0.0010 to 0.0030 in/in	0.10 to 0.30 %	ASTM D955
Water Absorption (73 °F (23 °C), Saturation)	0.23 %	0.23 %	ISO 62
Water Absorption 73 °F (23 °C), Equilibrium, 50 % RH	0.10 %	0.10 %	ISO 62

Mechanical	Nominal Value (English)	Nominal Value (SI)	Test Method
Tensile Modulus	1.45E+6 psi	10000 MPa	ISO 527-2/1
Tensile Stress (Break)	14500 psi	100.0 MPa	ISO 527-2/5
Tensile Strain (Break)	2.0 %	2.0 %	ISO 527-2/5
Flexural Modulus ²	1.23E+6 psi	8500 MPa	ISO 178
Flexural Strength ^{2, 3}	21000 psi	145 MPa	ISO 178
Taber Abrasion Resistance ⁴ (1000 Cycles)	32.0 mg	32.0 mg	ASTM D1044

Impact	Nominal Value (English)	Nominal Value (SI)	Test Method
Charpy Notched Impact Strength			
-22 °F (-30 °C) ⁵	2.38 ft-lb/in ²	5.00 kJ/m ²	ISO 179/1eA
73 °F (23 °C) ⁵	2.86 ft-lb/in ²	6.00 kJ/m ²	ISO 179/1eA
73 °F (23 °C)	4.28 ft-lb/in ²	9.00 kJ/m ²	ISO 179/2C
Charpy Unnotched Impact Strength ⁵			ISO 179/1eU
-22 °F (-30 °C)	19.0 ft-lb/in ²	40.0 kJ/m ²	
73 °F (23 °C)	19.0 ft-lb/in ²	40.0 kJ/m ²	
Notched Izod Impact Strength ⁶			ISO 180/1A
-22 °F (-30 °C)	2.86 ft-lb/in ²	6.00 kJ/m ²	
73 °F (23 °C)	3.33 ft-lb/in ²	7.00 kJ/m ²	
Unnotched Izod Impact Strength ⁶			ISO 180/1U
-22 °F (-30 °C)	16.7 ft-lb/in ²	35.0 kJ/m ²	
73 °F (23 °C)	16.7 ft-lb/in ²	35.0 kJ/m ²	

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Hardness	Nominal Value (English)	Nominal Value (SI)	Test Method
Ball Indentation Hardness - H 358/30	21000 psi	145 MPa	ISO 2039-1
Thermal	Nominal Value (English)	Nominal Value (SI)	Test Method
Heat Deflection Temperature ⁷ 66 psi (0.45 MPa), Unannealed	291 °F	144 °C	ISO 75-2/Be
Heat Deflection Temperature ⁷ 264 psi (1.8 MPa), Unannealed	282 °F	139 °C	ISO 75-2/Ae
Vicat Softening Temperature			
--	311 °F	155 °C	ISO 306/A50
--	297 °F	147 °C	ISO 306/B50
--	293 °F	145 °C	ISO 306/B120
CLTE (Flow, 73 to 176 °F (23 to 80 °C))	0.000011 in/in/°F	0.000020 cm/cm/°C	ISO 11359-2
Thermal Conductivity	1.5 Btu·in/hr/ft ² /°F	0.22 W/m/K	ISO 8302
Ball Pressure Test, 257 °F (125 °C)	Pass	Pass	IEC 60695-10-2

Electrical	Nominal Value (English)	Nominal Value (SI)	Test Method
Surface Resistivity	> 1.0E+15 ohms	> 1.0E+15 ohms	IEC 60093
Volume Resistivity	> 1.0E+15 ohm·cm	> 1.0E+15 ohm·cm	IEC 60093
Relative Permittivity			IEC 60250
50 Hz	3.20	3.20	
60 Hz	3.20	3.20	
1E+6 Hz	3.10	3.10	
Dissipation Factor			IEC 60250
50 Hz	0.00100	0.00100	
60 Hz	0.00100	0.00100	
1E+6 Hz	0.01000	0.01000	
Comparative Tracking Index	130 V	130 V	IEC 60112
Electric Strength			IEC 60243-1
0.0315 in (0.800 mm), in Oil	838.20 V/mil	33.00 kV/mm	
0.0394 in (1.00 mm)	508.00 V/mil	20.00 kV/mm	
0.0630 in (1.60 mm), in Oil	635.00 V/mil	25.00 kV/mm	
0.126 in (3.20 mm), in Oil	406.40 V/mil	16.00 kV/mm	

Flammability	Nominal Value (English)	Nominal Value (SI)	Test Method
Flame Rating - UL (0.0591 in (1.50 mm))	V-0	V-0	UL 94
Glow Wire Flammability Index			IEC 60695-2-12
0.0394 in (1.000 mm)	1560 °F	850 °C	
0.0630 in (1.60 mm)	1760 °F	960 °C	
Oxygen Index	38 %	38 %	ISO 4589-2

UL 746	Nominal Value (English)	Nominal Value (SI)	Test Method
RTI Str	266 °F	130 °C	UL 746
RTI Imp	257 °F	125 °C	UL 746
RTI Elec	266 °F	130 °C	UL 746

Processing Information

Injection	Nominal Value (English)	Nominal Value (SI)
Drying Temperature	248 °F	120 °C
Drying Time	2.0 to 4.0 hr	2.0 to 4.0 hr
Suggested Max Moisture	0.020 %	0.020 %
Hopper Temperature	140 to 176 °F	60.0 to 80.0 °C

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Injection	Nominal Value (English)	Nominal Value (SI)
Rear Temperature	518 to 572 °F	270 to 300 °C
Middle Temperature	536 to 590 °F	280 to 310 °C
Front Temperature	554 to 608 °F	290 to 320 °C
Nozzle Temperature	536 to 590 °F	280 to 310 °C
Processing (Melt) Temp	554 to 608 °F	290 to 320 °C
Mold Temperature	176 to 248 °F	80.0 to 120 °C

Notes

¹ Typical properties: these are not to be construed as specifications.

² 0.079 in/min (2.0 mm/min)

³ Break

⁴ 1000 g, CS-17 Wheel

⁵ 80*10*3 sp=62mm

⁶ 80*10*3

⁷ 120*10*4 mm, 3.94 in (100 mm)