

LEXANTM RESIN 104R

REGION ASIA

DESCRIPTION

UL rated HB. 200 series recommended when V-2 rating required. 7.0 MFR, for thicker sections without sinks. Internal mold release. FDA food contact compliant in limited colors. Effective January 15th, 2007 this grade will no longer be supported with biocompatibility information and should not be used for medical applications which require biocompatibility. Alternative grade HP6.

TYPICAL PROPERTY VALUES

Revision 20190214

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	62	MPa	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	68	MPa	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	7	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	135	%	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	97	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	2340	MPa	ASTM D 790
Hardness, Rockwell M	70	-	ASTM D 785
Hardness, Rockwell R	118	-	ASTM D 785
Taber Abrasion, CS-17, 1 kg	10	mg/1000cy	ASTM D 1044
IMPACT			
Izod Impact, unnotched, 23°C	3204	J/m	ASTM D 4812
Izod Impact, notched, 23°C	907	J/m	ASTM D 256
Tensile Impact, Type S	630	kJ/m ²	ASTM D 1822
Falling Dart Impact (D 3029), 23°C	169	J	ASTM D 3029
THERMAL			
Vicat Softening Temp, Rate B/50	154	°C	ASTM D 1525
HDT, 0.45 MPa, 6.4 mm, unannealed	137	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	132	°C	ASTM D 648
CTE, -40°C to 95°C, flow	6.84E-05	1/°C	ASTM E 831
Specific Heat	1.25	J/g·°C	ASTM C 351
Thermal Conductivity	0.19	W/m·°C	ASTM C177
Relative Temp Index, Elec	130	°C	UL 746B
Relative Temp Index, Mech w/impact	130	°C	UL 746B
Relative Temp Index, Mech w/o impact	130	°C	UL 746B
PHYSICAL			
Specific Gravity	1.2	-	ASTM D 792
Specific Volume	0.83	cm ³ /g	ASTM D 792
Density	1.19	g/cm ³	ASTM D 792
Water Absorption, 24 hours	0.15	%	ASTM D 570
Water Absorption, equilibrium, 23C	0.35	%	ASTM D 570
Water Absorption, equilibrium, 100°C	0.58	%	ASTM D 570
Mold Shrinkage, flow, 3.2 mm	0.5 – 0.7	%	SABIC method
Melt Flow Rate, 300°C/1.2 kgf	7	g/10 min	ASTM D 1238

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
OPTICAL			
Light Transmission, 2.54 mm	88	%	ASTM D 1003
Haze, 2.54 mm	1	%	ASTM D 1003
Refractive Index	1.586	-	ASTM D542
ELECTRICAL			
Volume Resistivity	>1.E+17	Ohm-cm	ASTM D 257
Dielectric Strength, in air, 3.2 mm	14.9	kV/mm	ASTM D 149
Relative Permittivity, 50/60 Hz	3.17	-	ASTM D 150
Relative Permittivity, 1 MHz	2.96	-	ASTM D 150
Dissipation Factor, 50/60 Hz	0.0009	-	ASTM D 150
Dissipation Factor, 1 MHz	0.01	-	ASTM D 150
Hot Wire Ignition {PLC}	2	PLC Code	UL 746A
High Voltage Arc Track Rate {PLC}	2	PLC Code	UL 746A
High Ampere Arc Ign, surface {PLC}	1	PLC Code	UL 746A
Comparative Tracking Index (UL) {PLC}	2	PLC Code	UL 746A
FLAME CHARACTERISTICS			
UL Recognized, 94HB Flame Class Rating	1.47	mm	UL 94
INJECTION MOLDING			
Drying Temperature	120	°C	
Drying Time	3 – 4	hrs	
Drying Time (Cumulative)	48	hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	310 – 330	°C	
Nozzle Temperature	305 – 325	°C	
Front - Zone 3 Temperature	310 – 330	°C	
Middle - Zone 2 Temperature	300 – 320	°C	
Rear - Zone 1 Temperature	290 – 310	°C	
Mold Temperature	80 – 115	°C	
Back Pressure	0.3 – 0.7	MPa	
Screw Speed	40 – 70	rpm	
Shot to Cylinder Size	40 – 60	%	
Vent Depth	0.025 – 0.076	mm	

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