

## Lexan\* Resin 3412ECR

Americas: COMMERCIAL

Lexan\* 3412ECR Polycarbonate (PC) resin is a 20% glass fiber filled, injection moldable grade. This non-chlorinated, non-brominated flame retardant GF-PC has an UL-94 V0 rating and is available in various opaque color options. Lexan 3412ECR is a resin designed to meet the needs of high stiffness applications.

### Property

TYPICAL PROPERTIES <sup>(1)</sup>			
MECHANICAL	Value	Unit	Standard
Tensile Stress, yld, Type I, 5 mm/min	90	MPa	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	87	MPa	ASTM D 638
Tensile Strain, yld, Type I, 5 mm/min	3.1	%	ASTM D 638
Tensile Modulus, 5 mm/min	5500	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	156	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	5000	MPa	ASTM D 790
Tensile Stress, yield, 5 mm/min	95	MPa	ISO 527
Tensile Stress, break, 5 mm/min	90	MPa	ISO 527
Tensile Strain, yield, 5 mm/min	2.8	%	ISO 527
Tensile Strain, break, 5 mm/min	3.2	%	ISO 527
Tensile Modulus, 1 mm/min	6000	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	140	MPa	ISO 178
Flexural Modulus, 2 mm/min	5500	MPa	ISO 178
IMPACT	Value	Unit	Standard
Izod Impact, notched, 23°C	110	J/m	ASTM D 256
Izod Impact, notched, -30°C	107	J/m	ASTM D 256
Instrumented Impact Total Energy, 23°C	20	J	ASTM D 3763
Izod Impact, unnotched 80*10*3 +23°C	35	kJ/m <sup>2</sup>	ISO 180/1U
Izod Impact, unnotched 80*10*3 -30°C	35	kJ/m <sup>2</sup>	ISO 180/1U
Izod Impact, notched 80*10*3 +23°C	7	kJ/m <sup>2</sup>	ISO 180/1A
Izod Impact, notched 80*10*3 -30°C	6	kJ/m <sup>2</sup>	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*3 sp=62mm	6	kJ/m <sup>2</sup>	ISO 179/1eA
Charpy -30°C, V-notch Edgew 80*10*3 sp=62mm	5	kJ/m <sup>2</sup>	ISO 179/1eA
Charpy 23°C, Unnotch Edgew 80*10*3 sp=62mm	40	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy -30°C, Unnotch Edgew 80*10*3 sp=62mm	40	kJ/m <sup>2</sup>	ISO 179/1eU
THERMAL	Value	Unit	Standard
Vicat Softening Temp, Rate B/50	147	°C	ASTM D 1525
HDT, 1.82 MPa, 3.2mm, unannealed	141	°C	ASTM D 648
CTE, -40°C to 40°C, flow	3.E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	7.E-05	1/°C	ASTM E 831
CTE, 23°C to 80°C, flow	3.E-05	1/°C	ISO 11359-2
CTE, 23°C to 80°C, xflow	7.E-05	1/°C	ISO 11359-2
Ball Pressure Test, 125°C +/- 2°C	PASSES	-	IEC 60695-10-2
Vicat Softening Temp, Rate B/50	145	°C	ISO 306
Vicat Softening Temp, Rate B/120	146	°C	ISO 306
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	141	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	136	°C	ISO 75/Af

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
<b>PHYSICAL</b>	<b>Value</b>	<b>Unit</b>	<b>Standard</b>
Specific Gravity	1.3	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	0.2 - 0.5	%	SABIC Method
Mold Shrinkage, xflow, 3.2 mm	0.2 - 0.5	%	SABIC Method
Melt Flow Rate, 300°C/1.2 kgf	7	g/10 min	ASTM D 1238
Density	1.36	g/cm <sup>3</sup>	ISO 1183
Water Absorption, (23°C/sat)	0.29	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.12	%	ISO 62
Melt Volume Rate, MVR at 300°C/1.2 kg	7	cm <sup>3</sup> /10 min	ISO 1133
<b>ELECTRICAL</b>	<b>Value</b>	<b>Unit</b>	<b>Standard</b>
Arc Resistance, Tungsten {PLC}	7	PLC Code	ASTM D 495
Hot Wire Ignition {PLC}	0	PLC Code	UL 746A
High Voltage Arc Track Rate {PLC}	3	PLC Code	UL 746A
High Ampere Arc Ign, surface {PLC}	4	PLC Code	UL 746A
Comparative Tracking Index (UL) {PLC}	5	PLC Code	UL 746A
Volume Resistivity	>1.E+15	Ohm-cm	IEC 60093
Surface Resistivity, ROA	>1.E+15	Ohm	IEC 60093
Relative Permittivity, 50/60 Hz	3.3	-	IEC 60250
Relative Permittivity, 1 MHz	3.3	-	IEC 60250
Dissipation Factor, 50/60 Hz	0.02	-	IEC 60250
Dissipation Factor, 1 MHz	0.01	-	IEC 60250
<b>FLAME CHARACTERISTICS</b>	<b>Value</b>	<b>Unit</b>	<b>Standard</b>
UL Recognized, 94V-0 Flame Class Rating (3)	1.5	mm	UL 94
UL Recognized, 94-5VA Rating (3)	3	mm	UL 94
Glow Wire Flammability Index 960°C, passes at	1	mm	IEC 60695-2-12
Glow Wire Ignitability Temperature, 1.0 mm	825	°C	IEC 60695-2-13
Oxygen Index (LOI)	40	%	ISO 4589

Source GMD, last updated:06/18/2004

## Processing

Parameter	Value	Unit
Injection Molding		
Drying Temperature	120	°C
Drying Time	3 - 4	hrs
Drying Time (Cumulative)	48	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	290 - 310	°C
Nozzle Temperature	280 - 305	°C
Front - Zone 3 Temperature	290 - 310	°C
Middle - Zone 2 Temperature	275 - 300	°C
Rear - Zone 1 Temperature	265 - 290	°C
Mold Temperature	70 - 95	°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

Source GMD, last updated:06/18/2004

THESE PROPERTY VALUES ARE NOT INTENDED FOR SPECIFICATION PURPOSES.

PLEASE CHECK WITH YOUR [\(LOCAL SALES OFFICE\)](#) FOR AVAILABILITY IN YOUR REGION

- (1) Typical values only. Variations within normal tolerances are possible for various colors. All values are measured after at least 48 hours storage at 23°C/50% relative humidity. All properties, except the melt volume and melt flow rates, are measured on injection molded samples. All samples tested under ISO test standards are prepared according to ISO 294.
- (2) Only typical data for selection purposes. Not to be used for part or tool design.
- (3) This rating is not intended to reflect hazards presented by this or any other material under actual fire conditions.
- (4) Internal measurements according to UL standards.

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