

Lexan* Resin PK2870

Europe-Africa-Middle East: COMMERCIAL

LEXAN* PK2870 polycarbonate resin, global grade, MVR (300C/1.2kg) 2 cm3/10min, high viscosity, branched, blow molding, high melt strength, high impact resistance, Available in transparent colors only. FDA 21CFR177.1580, European food contact regulation EC Directive 2002/72/EC. Designed to be a candidate for water bottle applications.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	62	MPa	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	65	MPa	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	7	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	>70	%	ASTM D 638
Tensile Modulus, 50 mm/min	2350	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	93	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	2300	MPa	ASTM D 790
Tensile Stress, yield, 50 mm/min	65	MPa	ISO 527
Tensile Stress, break, 50 mm/min	70	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	7	%	ISO 527
Tensile Strain, break, 50 mm/min	>70	%	ISO 527
Tensile Modulus, 1 mm/min	2350	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	95	MPa	ISO 178
Flexural Modulus, 2 mm/min	2300	MPa	ISO 178
Hardness, Rockwell R	120	-	ISO 2039-2
IMPACT			
Izod Impact, unnotched, 23°C	NB	J/m	ASTM D 4812
Izod Impact, unnotched, -30°C	NB	J/m	ASTM D 4812
Izod Impact, notched, 23°C	750	J/m	ASTM D 256
Izod Impact, notched, -30°C	150	J/m	ASTM D 256
Falling Dart Impact (D 3029), 23°C	170	J	ASTM D 3029
Izod Impact, unnotched 80*10*3 +23°C	NB	kJ/m ²	ISO 180/1U

1) Typical values only. Variations within normal tolerances are possible for various colours. All values are measured at least after 48 hours storage at 230C/50% relative humidity. All properties, except the melt volume rate are measured on injection moulded samples. All samples are prepared according to ISO 294.

2) Only typical data for material selection purpose. Not to be used for part or tool design.
3) This rating is not intended to reflect hazards presented this or any other material under actual fire conditions.
4) Own measurement according to UL.
5) Measurements made from laboratory test coupon. Actual shrinkage may vary outside of range due to differences in processing conditions, equipment, part geometry and tool design. It is recommended that mold shrinkage studies be performed with surrogate or legacy tooling prior to cutting tools for new molded article.

Source, GMD, Last Update:

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IMPACT			
Izod Impact, unnotched 80*10*3 -30°C	NB	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*3 +23°C	75	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*3 -30°C	55	kJ/m ²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*3 sp=62mm	70	kJ/m ²	ISO 179/1eA
Charpy -30°C, V-notch Edgew 80*10*3 sp=62mm	50	kJ/m ²	ISO 179/1eA
Charpy 23°C, Unnotch Edgew 80*10*3 sp=62mm	NB	kJ/m ²	ISO 179/1eU
Charpy -30°C, Unnotch Edgew 80*10*3 sp=62mm	NB	kJ/m ²	ISO 179/1eU
THERMAL			
Vicat Softening Temp, Rate B/50	150	°C	ASTM D 1525
HDT, 0.45 MPa, 3.2 mm	145	°C	ASTM D 648
HDT, 1.82 MPa, 3.2 mm	130	°C	ASTM D 648
CTE, -40°C to 95°C, flow	7.E-05	1/°C	ASTM E 831
Specific Heat	1.25	J/g-°C	ASTM C 351
Thermal Conductivity	0.2	W/m-°C	ASTM C 177
Thermal Conductivity	0.2	W/m-°C	ISO 8302
CTE, 23°C to 80°C, flow	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	149	°C	ISO 306
Vicat Softening Temp, Rate B/120	150	°C	ISO 306
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	145	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	130	°C	ISO 75/Af
PHYSICAL			
Specific Gravity	1.2	-	ASTM D 792
Water Absorption, equilibrium, 23C	0.35	%	ASTM D 570
Water Absorption, equilibrium, 100°C	0.58	%	ASTM D 570

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TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
PHYSICAL			
Mold Shrinkage, flow, 3.2 mm (5)	0.5 - 0.7	%	SABIC Method
Melt Flow Rate, 300°C/1.2 kgf	2.5	g/10 min	ASTM D 1238
Density	1.2	g/cm ³	ISO 1183
Water Absorption, (23°C/sat)	0.35	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.15	%	ISO 62
Melt Volume Rate, MVR at 300°C/1.2 kg	2	cm ³ /10 min	ISO 1133
Melt Volume Rate, MVR at 300°C/2.16 kg	4	cm ³ /10 min	ISO 1133
OPTICAL			
Light Transmission, 2.54 mm	88	%	ASTM D 1003
Haze, 2.54 mm	<0.8	%	ASTM D 1003
Refractive Index	1.586	-	ISO 489

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- CAUTION: For production delays of two or more hours, reduce temperature setpoints to 150°C (300°F).

PROCESSING PARAMETERS	TYPICAL 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	320 - 345	°C
Nozzle Temperature	315 - 340	°C
Front - Zone 3 Temperature	320 - 345	°C
Middle - Zone 2 Temperature	310 - 330	°C
Rear - Zone 1 Temperature	300 - 320	°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
Extrusion Blow Molding		
Drying Temperature	115 - 120	°C
Drying Time	4 - 6	hrs
Drying Time (Cumulative)	48	hrs
Maximum Moisture Content	0.02	%
Minimum Moisture Content	0.01	%
Melt Temperature (Parison)	265 - 275	°C
Barrel - Zone 1 Temperature	260 - 275	°C
Barrel - Zone 2 Temperature	260 - 275	°C
Barrel - Zone 3 Temperature	260 - 275	°C
Barrel - Zone 4 Temperature	260 - 275	°C
Adapter - Zone 5 Temperature	260 - 275	°C
Head - Zone 6 - Top Temperature	260 - 275	°C
Head - Zone 7 - Bottom Temperature	260 - 275	°C

- Purge with HDPE prior to changing screw, head, or die tooling and/or machine shutdown.
- 24:1 L:D low shear 2.5:1 compression ratio screw recommended. Screw design affects melt temperature. Screw speed -- 15-50 rpm suggested. Adjust actual rpm for desired output while maintaining desired melt temperature range.

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PROCESSING PARAMETERS	TYPICAL VALUE	UNIT
Extrusion Blow Molding		
Screw Speed	15 - 50	rpm
Mold Temperature	65 - 95	°C
Die Temperature	270 - 280	°C

- Purge with HDPE prior to changing screw, head, or die tooling and/or machine shutdown.
- 24:1 L:D low shear 2.5:1 compression ratio screw recommended. Screw design affects melt temperature. Screw speed -- 15-50 rpm suggested. Adjust actual rpm for desired output while maintaining desired melt temperature range.

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