

## Lexan\* Resin IR1840

### Europe-Africa-Middle East: COMMERCIAL

IR1840 resin is a high flow (MFR = 22 at 300°C/1.2kg), heat stabilized, polycarbonate product with mold release designed for use in the general purpose molding market. Food contact approved

TYPICAL PROPERTIES <sup>1</sup>	TYPICAL VALUE	Unit	Standard
<b>MECHANICAL</b>			
Tensile Stress, yld, Type I, 50 mm/min	640	kgf/cm <sup>2</sup>	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	6	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	>70	%	ASTM D 638
Tensile Modulus, 50 mm/min	23900	kgf/cm <sup>2</sup>	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	910	kgf/cm <sup>2</sup>	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	23400	kgf/cm <sup>2</sup>	ASTM D 790
Hardness, Rockwell R	120	-	ASTM D 785
Tensile Stress, yield, 50 mm/min	63	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	6	%	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	90	MPa	ISO 178
Flexural Modulus, 2 mm/min	2300	MPa	ISO 178
Hardness, Rockwell R	120	-	ISO 2039-2
<b>IMPACT</b>			
Izod Impact, unnotched, 23°C	NB	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	65	cm-kgf/cm	ASTM D 256
Instrumented Impact Energy @ peak, 23°C	560	cm-kgf	ASTM D 3763
Izod Impact, unnotched 80°*10°*3 +23°C	NB	kJ/m <sup>2</sup>	ISO 180/1U
Izod Impact, unnotched 80°*10°*3 -30°C	NB	kJ/m <sup>2</sup>	ISO 180/1U
Izod Impact, notched 80°*10°*3 +23°C	65	kJ/m <sup>2</sup>	ISO 180/1A
Izod Impact, notched 80°*10°*3 -30°C	12	kJ/m <sup>2</sup>	ISO 180/1A

(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±176;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.

(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 updated:

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<b>THERMAL</b>			
Vicat Softening Temp, Rate B/50	140	°C	ASTM D 1525
HDT, 0.45 MPa, 3.2 mm	133	°C	ASTM D 648
HDT, 1.82 MPa, 3.2 mm	122	°C	ASTM D 648
CTE, -40°C to 95°C, flow	7.E-05	1/°C	ASTM E 831
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	140	°C	ISO 306
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	133	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	122	°C	ISO 75/Af
<b>PHYSICAL</b>			
Specific Gravity	1.2	-	ASTM D 792
Water Absorption, equilibrium, 23C	0.35	%	ASTM D 570
Mold Shrinkage on Tensile Bar, flow (2) (5)	0.5 - 0.7	%	SABIC Method
Mold Shrinkage, flow, 3.2 mm (5)	0.5 - 0.7	%	SABIC Method
Melt Flow Rate, 300°C/1.2 kgf	22	g/10 min	ASTM D 1238
Density	1.2	g/cm <sup>3</sup>	ISO 1183
Water Absorption, (23°C/sat)	0.35	%	ISO 62
Melt Volume Rate, MVR at 300°C/1.2 kg	21	cm <sup>3</sup> /10 min	ISO 1133
<b>OPTICAL</b>			
Light Transmission, 2.54 mm	88 - 90	%	ASTM D 1003
Haze, 2.54 mm	<0.8	%	ASTM D 1003
Refractive Index	1.586	-	ASTM D 542
Refractive Index	1.586	-	ISO 489

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TYPICAL PROPERTIES <sup>1</sup>	TYPICAL VALUE	Unit	Standard
<b>ELECTRICAL</b>			
Volume Resistivity	>1.E+15	Ohm-cm	ASTM D 257
Dielectric Strength, 1.6 mm	27	kV/mm	ASTM D 149
Relative Permittivity, 60 Hz	3	-	ASTM D 150
Relative Permittivity, 1 MHz	3	-	ASTM D 150
Dissipation Factor, 60 Hz	0.001	-	ASTM D 150
Dissipation Factor, 1 MHz	0.01	-	ASTM D 150
Volume Resistivity	>1.E+15	Ohm-cm	IEC 60093
Dielectric Strength, 1.6 mm	27	kV/mm	IEC 60243-1
Relative Permittivity, 60 Hz	3	-	IEC 60250
Relative Permittivity, 1 MHz	3	-	IEC 60250
Dissipation Factor, 60 Hz	0.001	-	IEC 60250
Dissipation Factor, 1 MHz	0.01	-	IEC 60250

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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
<b>Injection Molding</b>		
Drying Temperature	120	°C
Drying Time	2 - 4	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	280 - 300	°C
Nozzle Temperature	270 - 290	°C
Front - Zone 3 Temperature	280 - 300	°C
Middle - Zone 2 Temperature	270 - 290	°C
Rear - Zone 1 Temperature	260 - 280	°C
Hopper Temperature	60 - 80	°C
Mold Temperature	80 - 100	°C

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