



**LEXAN™ Resin 121R**  
**Asia Pacific: COMMERCIAL**

Nonhalogenated. 17.5 MFR, for small, intricate parts. Internal mold release.

TYPICAL PROPERTIES <sup>1</sup>	TYPICAL VALUE	Unit	Standard
<b>MECHANICAL</b>			
Tensile Stress, yld, Type I, 50 mm/min	630	kgf/cm <sup>2</sup>	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	700	kgf/cm <sup>2</sup>	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	7	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	125	%	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	980	kgf/cm <sup>2</sup>	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	23900	kgf/cm <sup>2</sup>	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
<b>IMPACT</b>			
Izod Impact, unnotched, 23°C	326	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	70	cm-kgf/cm	ASTM D 256
Tensile Impact, Type S	557	cm-kgf/cm <sup>2</sup>	ASTM D 1822
Falling Dart Impact (D 3029), 23°C	1728	cm-kgf	ASTM D 3029
Instrumented Impact Energy @ peak, 23°C	633	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	11	kJ/m <sup>2</sup>	ISO 180/1A
Charpy 23°C, V-notch Edgew 80°10*3 sp=62mm	65	kJ/m <sup>2</sup>	ISO 179/1eA
Charpy -30°C, V-notch Edgew 80°10*3 sp=62mm	12	kJ/m <sup>2</sup>	ISO 179/1eA
Charpy 23°C, Unnotch Edgew 80°10*3 sp=62mm	NB	kJ/m <sup>2</sup>	ISO 179/1eU

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(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.

(6) Needs hard coat to consistently pass 60 sec Vertical Burn.

Source GMD, last updated:

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TYPICAL PROPERTIES <sup>1</sup>	TYPICAL VALUE	Unit	Standard
<b>IMPACT</b>			
Charpy -30°C, Unnotch Edgew 80*10*3 sp=62mm	NB	kJ/m <sup>2</sup>	ISO 179/1eU
<b>THERMAL</b>			
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	129	°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	0.25	W/m-°C	ASTM C 177
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>			
Specific Gravity	1.2	-	ASTM D 792
Specific Volume	0.83	cm <sup>3</sup> /g	ASTM D 792
Density	1.19	g/cm <sup>3</sup>	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 (5)	0.5 - 0.7	%	SABIC Method
Melt Flow Rate, 300°C/1.2 kgf	17.5	g/10 min	ASTM D 1238
<b>OPTICAL</b>			
Light Transmission, 2.54 mm	88	%	ASTM D 1003
Haze, 2.54 mm	1	%	ASTM D 1003
Refractive Index	1.586	-	ASTM D 542
<b>ELECTRICAL</b>			
Volume Resistivity	>1.E+17	Ohm-cm	ASTM D 257
Dielectric Strength, in air, 3.2 mm	14.9	kV/mm	ASTM D 149

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TYPICAL PROPERTIES <sup>1</sup>	TYPICAL VALUE	Unit	Standard
<b>ELECTRICAL</b>			
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
<b>FLAME CHARACTERISTICS</b>			
UL Recognized, 94HB Flame Class Rating (3)	0.71	mm	UL 94
Radiant Panel Listing	YES	-	UL Tested
UV-light, water exposure/immersion	F2	-	UL 746C

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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
<b>Injection Molding</b>		
Drying Temperature	120	°C
Drying Time	3 - 4	hrs
Drying Time (Cumulative)	48	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	280 - 305	°C
Nozzle Temperature	275 - 300	°C
Front - Zone 3 Temperature	280 - 305	°C
Middle - Zone 2 Temperature	270 - 295	°C
Rear - Zone 1 Temperature	260 - 280	°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

• NOTE: Back Pressure, Screw Speed, Shot to Cylinder Size and Vent Depth are only mentioned as general guidelines. These may not apply or need adjustment in specific situations such as low shot sizes, thin wall molding and gas-assist molding.

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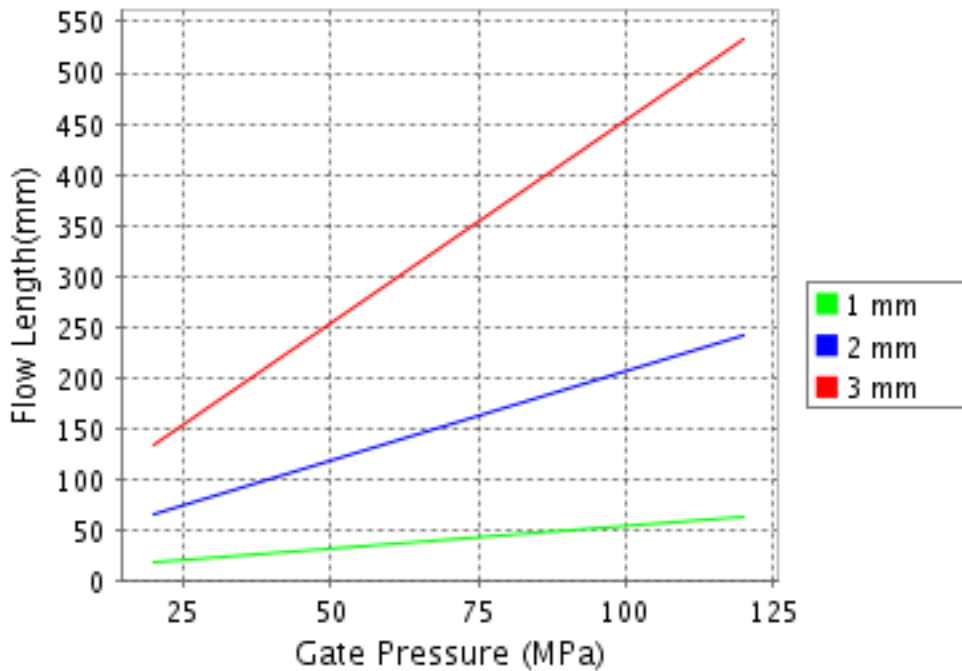
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**CALCULATED FLOW LENGTH INDICATION**  
**Moldflow® Radial Flow Analysis**  
**LEXAN® 121R**  
**Melt Temperature : 290°C**  
**Mold Temperature : 90°C**



**Note: Technical support is recommended if Gate Pressure is greater than 80 MPa. Contact your local representative.**  
**® Moldflow is a registered trademark of the Moldflow Corporation.**

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