

# LEXAN<sup>TM</sup> RESIN OQ4820

REGION EUROPE

## DESCRIPTION

LEXAN OQ4820 is a high viscosity grade with a UV cut-off up to 400 nm and a greater optical purity than standard resins. Fields of application for this material are optical lenses, f.i. in sun glasses and sunvisors market.

## TYPICAL PROPERTY VALUES

Revision 20181012

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
<b>MECHANICAL</b>			
Taber Abrasion, CS-17, 1 kg	10	mg/1000cy	SABIC method
Tensile Stress, yield, 50 mm/min	63	MPa	ISO 527
Tensile Stress, break, 50 mm/min	70	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	6	%	ISO 527
Tensile Strain, break, 50 mm/min	120	%	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, H358/30	95	MPa	ISO 2039-1
<b>IMPACT</b>			
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	70	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
Charpy 23°C, V-notch Edgew 80*10*3 sp=62mm	75	kJ/m <sup>2</sup>	ISO 179/1eA
Charpy -30°C, V-notch Edgew 80*10*3 sp=62mm	15	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
Charpy -30°C, Unnotch Edgew 80*10*3 sp=62mm	NB	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy Impact, notched, 23°C	35	kJ/m <sup>2</sup>	ISO 179/2C
<b>THERMAL</b>			
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	144	°C	ISO 306
Vicat Softening Temp, Rate B/120	145	°C	ISO 306
HDT/Be, 0.45MPa Edgew 120*10*4 sp=100mm	138	°C	ISO 75/Be
HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm	127	°C	ISO 75/Ae
<b>PHYSICAL</b>			
Mold Shrinkage on Tensile Bar, flow	0.5 – 0.7	%	SABIC method
Density	1.2	g/cm <sup>3</sup>	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	6	cm <sup>3</sup> /10 min	ISO 1133
<b>OPTICAL</b>			

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Light Transmission, 2.54 mm	88 – 89	%	ASTM D 1003
<b>FLAME CHARACTERISTICS</b>			
Glow Wire Flammability Index 850°C, passes at	1	mm	IEC 60695-2-12
Oxygen Index (LOI)	25	%	ISO 4589
<b>INJECTION MOLDING</b>			
Drying Temperature	120	°C	
Drying Time	2 – 4	hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	290 – 320	°C	
Nozzle Temperature	280 – 310	°C	
Front - Zone 3 Temperature	290 – 320	°C	
Middle - Zone 2 Temperature	280 – 310	°C	
Rear - Zone 1 Temperature	270 – 300	°C	
Hopper Temperature	60 – 80	°C	
Mold Temperature	80 – 120	°C	

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