

**Lexan\* Resin 144R**  
**Americas: COMMERCIAL**

UL rated HB. 200 series recommended when V-2 rating required. MFR 10.5. Internal mold release. FDA food contact compliant in limited colors. Effective January 15th, 2007 this grade will no longer be supported with biocompatibility information and should not be used for medical applications which require biocompatibility. Alternative grade HP4.

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	690	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	130	%	ASTM D 638
Tensile Modulus, 50 mm/min	24100	kgf/cm <sup>2</sup>	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	23800	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
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	110	%	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
<b>IMPACT</b>			
Izod Impact, unnotched, 23°C	326	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	81	cm-kgf/cm	ASTM D 256
Izod Impact, notched (natural, tints)	81	cm-kgf/cm	ASTM D 256
Izod Impact, notched (colors)	81	cm-kgf/cm	ASTM D 256

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(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.

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TYPICAL PROPERTIES <sup>1</sup>	TYPICAL VALUE	Unit	Standard
<b>IMPACT</b>			
Tensile Impact, Type S	588	cm-kgf/cm <sup>2</sup>	ASTM D 1822
Falling Dart Impact (D 3029), 23°C	1723	cm-kgf	ASTM D 3029
Instrumented Impact Energy @ peak, 23°C	642	cm-kgf	ASTM D 3763
Izod Impact, unnotched 80*10*4 +23°C	NA	kJ/m <sup>2</sup>	ISO 180/1U
Izod Impact, unnotched 80*10*4 -30°C	NA	kJ/m <sup>2</sup>	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	12	kJ/m <sup>2</sup>	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	10	kJ/m <sup>2</sup>	ISO 180/1A
Charpy Impact, notched, 23°C	35	kJ/m <sup>2</sup>	ISO 179/2C
Charpy 23°C, Unnotch Edgew 80*10*4 sp=62mm	NA	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy -30°C, Unnotch Edgew 80*10*4 sp=62mm	NA	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	132	°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	0.19	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 A/50	153	°C	ISO 306
Vicat Softening Temp, Rate B/50	141	°C	ISO 306
Vicat Softening Temp, Rate B/120	142	°C	ISO 306
HDT/Be, 0.45MPa Edgew 120*10*4 sp=100mm	136	°C	ISO 75/Be

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<b>THERMAL</b>			
HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm	125	°C	ISO 75/Ae
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	10.5	g/10 min	ASTM D 1238
Melt Volume Rate, MVR at 300°C/1.2 kg	10	cm <sup>3</sup> /10 min	ISO 1133
<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
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

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<b>ELECTRICAL</b>			
Volume Resistivity	>1.E+15	Ohm-cm	IEC 60093
Surface Resistivity, ROA	>1.E+15	Ohm	IEC 60093
Dielectric Strength, in oil, 3.2 mm	17	kV/mm	IEC 60243-1
Relative Permittivity, 1 MHz	2.7	-	IEC 60250
Dissipation Factor, 50/60 Hz	0.001	-	IEC 60250
Dissipation Factor, 1 MHz	0.01	-	IEC 60250
Relative Permittivity, 50/60 Hz	2.7	-	IEC 60250
<b>FLAME CHARACTERISTICS</b>			
UL Recognized, 94HB Flame Class Rating (3)	1.47	mm	UL 94
Oxygen Index (LOI)	25	%	ASTM D 2863
Oxygen Index (LOI)	25	%	ISO 4589

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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	295 - 315	°C
Nozzle Temperature	290 - 310	°C
Front - Zone 3 Temperature	295 - 315	°C
Middle - Zone 2 Temperature	280 - 305	°C
Rear - Zone 1 Temperature	270 - 295	°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

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