

Datasheets

Section Navigation

Go

****NEW GRADE******LEXAN: 141R USA: COMMERCIAL**

UL rated HB as of 10/97. 200 series recommended when V-2 rating required. Nonhalogenated. 10.5 MFR. Internal mold release.

INJECTION MOLDING-USA

Melt Temperature	560-600	deg F
Nozzle Temperature	550-590	deg F
Front Temperature	560-600	deg F
Middle Temperature	540-580	deg F
Rear Temperature	520-560	deg F
Mold Temperature	160-200	deg F
Drying Temperature	250	deg F
Drying Time (minimum)	3-4	h
Drying Time (maximum)	48	h
Back Pressure	50-100	psi
Screw Speed	40-70	rpm
Suggested shot size	40-60	%
Vent Depth	.001-.003	in

Source Eris, last updated:97/05/27

THESE PROPERTY VALUES ARE NOT INTENDED FOR SPECIFICATION PURPOSES.

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LEXAN: 141R USA: COMMERCIAL

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PROPERTY	TYPICAL DATA	UNIT	METHOD
MECHANICAL			
Tensile Strength, yield, Type I, 0.125"	9000	psi	ASTM D 638
Tensile Strength, break, Type I, 0.125"	10000	psi	ASTM D 638
Tensile Elongation, yield, Type I 0.125"	7.0	%	ASTM D 638
Tensile Elongation, break, Type I 0.125"	130.0	%	ASTM D 638
Flexural Strength, yield, 0.125"	14000	psi	ASTM D 790
Flexural Modulus, 0.125"	340000	psi	ASTM D 790
Compressive Strength	12500	psi	ASTM D 695

Compressive Modulus	345000	psi	ASTM D 695
Shear Strength	6000	psi	ASTM D 732
Shear Modulus	114000	psi	ASTM D 4065
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
Fatigue Limit, 2.5 MM cycles	1000	psi	ASTM D 671

IMPACT

Izod Impact, unnotched, 73F	60.0	ft-lb/in	ASTM D 4812
Izod Impact, notched, 73F	15.0	ft-lb/in	ASTM D 256
Tensile Impact, Type "S"	275	ft-lb/in ²	ASTM D 1822
Falling Dart Impact (D 3029), 73F	125	ft-lbs	ASTM D 3029
Instrumented Impact Energy @ peak, 73F	565	in-lbs	ASTM D 3763

THERMAL

Vicat Softening Temp, Rate B	310	deg F	ASTM D 1525
HDT, 66 psi, 0.250", unannealed	280	deg F	ASTM D 648
HDT, 264 psi, 0.250", unannealed	270	deg F	ASTM D 648
Thermal Conductivity	0.27	W/m-C	ASTM C 177
CTE, flow, -40F to 200F	3.8 E-5	in/in-F	ASTM E 831
Specific Heat	0.30	BTU/lb-F	ASTM C 351
Thermal Index, Elec Prop	130	deg C	UL 746B
Thermal Index, Mech Prop with impact	130	deg C	UL 746B
Thermal Index, Mech prop without impact	130	deg C	UL 746B
Brittleness Temperature	-200	deg F	ASTM D 746

PHYSICAL

Specific Gravity, solid	1.20	-	ASTM D 792
Specific Volume	23.10	in ³ /lb	ASTM D 792
Density	0.043	lb/in ³	ASTM D 792
Water Absorption, 24 hours @ 73F	0.150	%	ASTM D 570
Water Absorption, equilibrium, 73F	0.35	%	ASTM D 570
Water Absorption, equilibrium, 212F	0.58	%	ASTM D 570
Mold Shrinkage, flow, 0.125"	5-7	in/in E-3	ASTM D 955
Melt Flow Rate, nom'l, 300C/1.2 kgf (O)	10.5	g/10 min	ASTM D 1238

OPTICAL

Light Transmission, 0.100"	88.0	%	ASTM D 1003
Haze, 0.100"	1.0	%	ASTM D 1003
Refractive Index	1.586	-	ASTM D 542

ELECTRICAL

Volume Resistivity	1.0E17	ohm-cm	ASTM D 257
Dielectric Strength, in air, 125 mils	380	V/mil	ASTM D 149
Dielectric Constant, 60 Hz	3.17	-	ASTM D 150
Dielectric Constant, 1 MHz	2.96	-	ASTM D 150
Dissipation Factor, 60 Hz	0.0009	-	ASTM D 150
Dissipation Factor, 1 MHz	0.0100	-	ASTM D 150

FLAME CHARACTERISTICS

UL File Number, USA	E121562	-	-
94HB Rated (tested thickness)	0.045	inch	UL 94

Source Eris, Last updated: 98/02/17

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[\[Previous \(141\)\]](#)

[\[Next \(141S\)\]](#)

[GE home page](#)

[GE Plastics home page](#)

[GE home page](#) | [GE Plastics home page](#)