



LEXAN™ Resin 505R

Americas: COMMERCIAL

LEXAN 505R Polycarbonate (PC) resin is a 10% glass fiber filled, injection moldable grade. LEXAN 505R contains non-chlorinated, non-brominated flame retardant systems with UL-94 V0 rating at 1.5mm. It is available in various opaque color options for high stiffness applications.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	640	kgf/cm ²	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	480	kgf/cm ²	ASTM D 638
Tensile Strain, yld, Type I, 5 mm/min	3	%	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	12	%	ASTM D 638
Tensile Modulus, 5 mm/min	40000	kgf/cm ²	ASTM D 638
Flexural Stress, brk, 1.3 mm/min, 50 mm span	1100	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	35900	kgf/cm ²	ASTM D 790
Taber Abrasion, CS-17, 1 kg	11	mg/1000cy	SABIC Method
Tensile Stress, yield, 5 mm/min	60	MPa	ISO 527
Tensile Stress, break, 5 mm/min	45	MPa	ISO 527
Tensile Strain, yield, 5 mm/min	5	%	ISO 527
Tensile Strain, break, 5 mm/min	7	%	ISO 527
Tensile Modulus, 1 mm/min	3300	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	95	MPa	ISO 178
Flexural Modulus, 2 mm/min	3400	MPa	ISO 178
Hardness, H358/30	115	MPa	ISO 2039-1
IMPACT			
Izod Impact, unnotched, 23°C	163	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	10	cm-kgf/cm	ASTM D 256
Izod Impact, notched, -30°C	8	cm-kgf/cm	ASTM D 256
Instrumented Impact Total Energy, 23°C	622	cm-kgf	ASTM D 3763
Izod Impact, unnotched 80°10*3 +23°C	NB	kJ/m ²	ISO 180/1U

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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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IMPACT			
Izod Impact, unnotched 80*10*3 -30°C	130	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*3 +23°C	10	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*3 -30°C	8	kJ/m ²	ISO 180/1A
Izod Impact, unnotched 80*10*4 +23°C	NB	kJ/m ²	ISO 180/1U
Izod Impact, unnotched 80*10*4 -30°C	NB	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	8	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	8	kJ/m ²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*3 sp=62mm	10	kJ/m ²	ISO 179/1eA
Charpy -30°C, V-notch Edgew 80*10*3 sp=62mm	9	kJ/m ²	ISO 179/1eA
Charpy 23°C, Unnotch Edgew 80*10*3 sp=62mm	NB	kJ/m ²	ISO 179/1eU
Charpy -30°C, Unnotch Edgew 80*10*3 sp=62mm	NB	kJ/m ²	ISO 179/1eU
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	9	kJ/m ²	ISO 179/1eA
Charpy Impact, notched, 23°C	15	kJ/m ²	ISO 179/2C
Charpy 23°C, Unnotch Edgew 80*10*4 sp=62mm	NB	kJ/m ²	ISO 179/1eU
Charpy -30°C, Unnotch Edgew 80*10*4 sp=62mm	NB	kJ/m ²	ISO 179/1eU
THERMAL			
Vicat Softening Temp, Rate B/50	149	°C	ASTM D 1525
HDT, 0.45 MPa, 3.2 mm, unannealed	143	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	138	°C	ASTM D 648
CTE, -40°C to 40°C, flow	4.68E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	8.46E-05	1/°C	ASTM E 831
Thermal Conductivity	0.21	W/m-°C	ISO 8302
CTE, 23°C to 80°C, flow	4.E-05	1/°C	ISO 11359-2
CTE, 23°C to 80°C, xflow	7.E-05	1/°C	ISO 11359-2

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(4) Internal measurements according to UL standards.

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

Source GMD, last updated:

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THERMAL			
Ball Pressure Test, 125°C +/- 2°C	PASSES	-	IEC 60695-10-2
Vicat Softening Temp, Rate B/50	141	°C	ISO 306
Vicat Softening Temp, Rate B/120	143	°C	ISO 306
HDT/Be, 0.45MPa Edgew 120*10*4 sp=100mm	144	°C	ISO 75/Be
HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm	136	°C	ISO 75/Ae
HDT/Ae, 1.8 MPa Annealed 120°C, 2hrs	136	°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
PHYSICAL			
Specific Gravity	1.26	-	ASTM D 792
Mold Shrinkage on Tensile Bar, flow (2) (5)	0.2 - 0.6	%	SABIC Method
Mold Shrinkage, flow, 3.2 mm (5)	0.5 - 0.7	%	SABIC Method
Melt Flow Rate, 300°C/1.2 kgf	7	g/10 min	ASTM D 1238
Density	1.25	g/cm ³	ISO 1183
Water Absorption, (23°C/sat)	0.31	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.13	%	ISO 62
Melt Volume Rate, MVR at 300°C/1.2 kg	7	cm ³ /10 min	ISO 1133
ELECTRICAL			
Volume Resistivity	>1.E+15	Ohm-cm	IEC 60093
Surface Resistivity, ROA	>1.E+15	Ohm	IEC 60093
Dielectric Strength, in oil, 0.8 mm	33	kV/mm	IEC 60243-1
Dielectric Strength, in oil, 1.6 mm	25	kV/mm	IEC 60243-1
Dielectric Strength, in oil, 3.2 mm	16	kV/mm	IEC 60243-1
Relative Permittivity, 1 MHz	2.8	-	IEC 60250
Dissipation Factor, 50/60 Hz	0.001	-	IEC 60250
Dissipation Factor, 1 MHz	0.01	-	IEC 60250
Comparative Tracking Index	150	V	IEC 60112

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TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
ELECTRICAL			
Relative Permittivity, 50/60 Hz	2.9	-	IEC 60250
FLAME CHARACTERISTICS			
UL Recognized, 94V-0 Flame Class Rating (3)	1.5	mm	UL 94
UL Recognized, 94-5VA Rating (3)	3	mm	UL 94
Glow Wire Flammability Index 960°C, passes at	1	mm	IEC 60695-2-12
Glow Wire Ignitability Temperature, 1.0 mm	825	°C	IEC 60695-2-13
Oxygen Index (LOI)	37	%	ISO 4589

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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
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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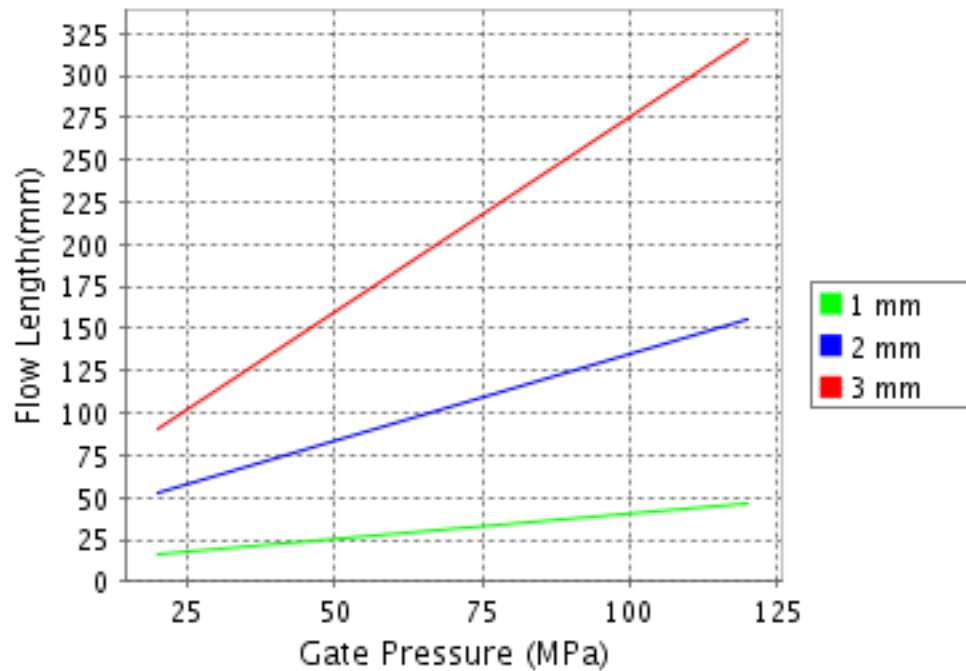
CALCULATED FLOW LENGTH INDICATION

Moldflow® Radial Flow Analysis

LEXAN® 505R

Melt Temperature : 305°C

Mold Temperature : 100°C



Note: Technical support is recommended if Gate Pressure is greater than 80 MPa. Contact your local representative.
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