

# LEXANT™ RESIN VR2820

REGION AMERICAS

## DESCRIPTION

LEXANT™ VR2820 resin is a 7 MFR polycarbonate, MVR of 6. UV stabilized. Mold release. Injection moldable. Available in transparent, limited package types, and must meet minimum order quantity requirements.

## TYPICAL PROPERTY VALUES

Revision 20201125

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
<b>MECHANICAL</b>			
Tensile Stress, yld, Type I, 50 mm/min	63	MPa	ASTM D638
Tensile Stress, brk, Type I, 50 mm/min	65	MPa	ASTM D638
Tensile Strain, yld, Type I, 50 mm/min	7	%	ASTM D638
Tensile Strain, brk, Type I, 50 mm/min	110	%	ASTM D638
Tensile Modulus, 50 mm/min	2350	MPa	ASTM D638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	93	MPa	ASTM D790
Flexural Modulus, 1.3 mm/min, 50 mm span	2300	MPa	ASTM D790
<b>IMPACT</b>			
Izod Impact, notched, 23°C	900	J/m	ASTM D256
<b>THERMAL</b>			
HDT, 1.82 MPa, 3.2mm, unannealed	124	°C	ASTM D648
CTE, -40°C to 95°C, flow	6.84E-05	1/°C	ASTM E831
<b>PHYSICAL</b>			
Specific Gravity	1.2	-	ASTM D792
Mold Shrinkage, flow, 3.2 mm	0.5 – 0.7	%	SABIC method
Melt Flow Rate, 300°C/1.2 kgf	7	g/10 min	ASTM D1238
<b>FLAME CHARACTERISTICS</b>			
UL Yellow Card Link	<a href="#">E121562-548558</a>	-	-
<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	310 – 330	°C	
Nozzle Temperature	305 – 325	°C	
Front - Zone 3 Temperature	310 – 330	°C	
Middle - Zone 2 Temperature	300 – 320	°C	
Rear - Zone 1 Temperature	290 – 310	°C	
Mold Temperature	80 – 115	°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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