



## LEXAN™ Resin 3412R

### Europe-Africa-Middle East: COMMERCIAL

LEXAN 3412R is a high viscosity, 20% glass reinforced grade. It offers excellent flame retardancy and is especially designed for applications requiring high rigidity together with high heat.

TYPICAL PROPERTIES <sup>1</sup>	TYPICAL VALUE	Unit	Standard
<b>MECHANICAL</b>			
Taber Abrasion, CS-17, 1 kg	17	mg/1000cy	SABIC Method
Tensile Stress, break, 5 mm/min	90	MPa	ISO 527
Tensile Strain, break, 5 mm/min	2	%	ISO 527
Tensile Modulus, 1 mm/min	6000	MPa	ISO 527
Flexural Stress, break, 2 mm/min	120	MPa	ISO 178
Flexural Modulus, 2 mm/min	5500	MPa	ISO 178
Hardness, H358/30	125	MPa	ISO 2039-1
<b>IMPACT</b>			
Izod Impact, unnotched 80*10*3 +23°C	35	kJ/m <sup>2</sup>	ISO 180/1U
Izod Impact, unnotched 80*10*3 -30°C	35	kJ/m <sup>2</sup>	ISO 180/1U
Izod Impact, notched 80*10*3 +23°C	7	kJ/m <sup>2</sup>	ISO 180/1A
Izod Impact, notched 80*10*3 -30°C	6	kJ/m <sup>2</sup>	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*3 sp=62mm	6	kJ/m <sup>2</sup>	ISO 179/1eA
Charpy -30°C, V-notch Edgew 80*10*3 sp=62mm	5	kJ/m <sup>2</sup>	ISO 179/1eA
Charpy 23°C, Unnotch Edgew 80*10*3 sp=62mm	40	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy -30°C, Unnotch Edgew 80*10*3 sp=62mm	40	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy Impact, notched, 23°C	9	kJ/m <sup>2</sup>	ISO 179/2C
<b>THERMAL</b>			
Thermal Conductivity	0.22	W/m-°C	ISO 8302
CTE, 23°C to 80°C, flow	3.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	155	°C	ISO 306
Vicat Softening Temp, Rate B/50	147	°C	ISO 306

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(2) Only typical data for selection purposes. Not to be used for part or tool design.

(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.

Source GMD, last updated:

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<b>THERMAL</b>			
Vicat Softening Temp, Rate B/120	145	°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	139	°C	ISO 75/Ae
Relative Temp Index, Elec	130	°C	UL 746B
Relative Temp Index, Mech w/impact	125	°C	UL 746B
Relative Temp Index, Mech w/o impact	130	°C	UL 746B
<b>PHYSICAL</b>			
Mold Shrinkage on Tensile Bar, flow (2) (5)	0.2 - 0.5	%	SABIC Method
Density	1.35	g/cm <sup>3</sup>	ISO 1183
Water Absorption, (23°C/sat)	0.29	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.12	%	ISO 62
Melt Volume Rate, MVR at 300°C/1.2 kg	6	cm <sup>3</sup> /10 min	ISO 1133
<b>OPTICAL</b>			
Haze, 2.54 mm	NA	%	ASTM D 1003
Refractive Index	NA	-	ISO 489
<b>ELECTRICAL</b>			
Volume Resistivity	>1.E+15	Ohm-cm	IEC 60093
Surface Resistivity, ROA	>1.E+15	Ohm	IEC 60093
Dielectric Strength, shorttime, 1.0mm	20	kV/mm	IEC 60243-1
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	2.9	-	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 <sup>1</sup>	TYPICAL VALUE	Unit	Standard
<b>ELECTRICAL</b>			
Relative Permittivity, 50/60 Hz	3	-	IEC 60250
<b>FLAME CHARACTERISTICS</b>			
UL Recognized, 94V-0 Flame Class Rating (3)	1.5	mm	UL 94
Glow Wire Flammability Index 850°C, passes at	1	mm	IEC 60695-2-12
Glow Wire Flammability Index 960°C, passes at	1.6	mm	IEC 60695-2-12
Oxygen Index (LOI)	37	%	ISO 4589

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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
<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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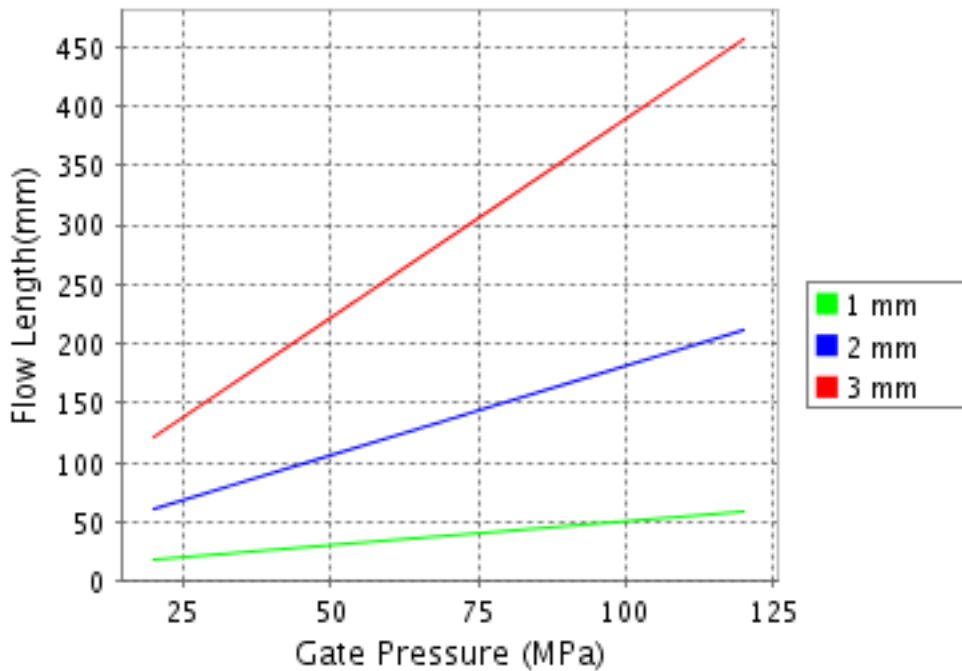
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**CALCULATED FLOW LENGTH INDICATION**  
**Moldflow® Radial Flow Analysis**  
**LEXAN® 3412R**  
**Melt Temperature : 300°C**  
**Mold Temperature : 90°C**



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