

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	6	cm ³ /10min	ISO 1133
Temperature	300	°C	-
Load	1.2	kg	-
ASTM Data			
Melt Flow Index, MFI	7.5	g/10min	ASTM D 1238
Temperature	300	°C	-
Load	1.2	kg	-

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	3900	MPa	ISO 527
Yield stress	54	MPa	ISO 527
Yield strain	4.3	%	ISO 527
Stress at break	48	MPa	ISO 527
Strain at break	8.7	%	ISO 527
Flexural modulus	3450	MPa	ISO 178
Charpy impact strength, +23°C, 3mm	N	kJ/m ²	ISO 179/1eU
Charpy impact strength, -30°C, 3mm	N	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, +23°C, 3mm	25	kJ/m ²	ISO 179/1eA
Charpy notched impact strength, -30°C, 3mm	15	kJ/m ²	ISO 179/1eA
Izod impact strength, +23°C	N	kJ/m ²	ISO 180/1U
Izod notched impact strength, +23°C, 3mm	25	kJ/m ²	ISO 180/1A
Izod notched impact strength, -30°C, 3mm	10	kJ/m ²	ISO 180/1A
ASTM Data			
Tensile Modulus	3950	MPa	ASTM D 638
Tensile Strength at Yield	55	MPa	ASTM D 638
Tensile Strength at Break	45	MPa	ASTM D 638
Elongation at Yield	4.3	%	ASTM D 638
Elongation at Break	14	%	ASTM D 638
Flexural Modulus	3500	MPa	ASTM D 790
Izod Impact notched, 1/8 in	345	J/m	ASTM D 256
Izod Impact notched, Low-Temperature	150	J/m	ASTM D 256
Temperature	-30	°C	-

Thermal properties	Value	Unit	Test Standard
ISO Data			
Vicat softening temperature, B	146	°C	ISO 306
Vicat softening temperature, 120°C/h 50N	146	°C	ISO 306
ASTM Data			
DTUL @ 264 psi	137	°C	ASTM D 648
Vicat Temperature	146	°C	ASTM D 1525

Other properties	Value	Unit	Test Standard
Water absorption	0.15	%	Sim. to ISO 62
Humidity absorption	0.4	%	Sim. to ISO 62
Density	1250	kg/m ³	ISO 1183
Density	1250	kg/m ³	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	120	°C	-
Pre-drying - Time	3 - 4	h	-
Processing humidity	≤0.02	%	-
Melt temperature	310 - 330	°C	-
Mold temperature	80 - 115	°C	-
Zone 1	290 - 310	°C	-
Zone 2	300 - 320	°C	-

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Zone 3	310 - 330	°C	-
Screw speed	40 - 70	rpm	-
Back pressure	0.3 - 0.7	MPa	-

Characteristics**Processing**

Injection Molding

Regional Availability

Europe