

**Product Texts**

High heat polycarbonate copolymer blend with an excellent balance of heat resistance, processability, and impact strength. Available in a range of opaque colors.

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ISO Data</b>			
Melt volume-flow rate, MVR	31	cm <sup>3</sup> /10min	ISO 1133
Temperature	330	°C	-
Load	2.16	kg	-
<b>ASTM Data</b>			
Melt Flow Index, MFI	5.6	g/10min	ASTM D 1238
Temperature	300	°C	-
Load	1.2	kg	-

Mechanical properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Tensile Modulus	2160	MPa	ISO 527
Yield stress	62	MPa	ISO 527
Yield strain	6.6	%	ISO 527
Stress at break	59	MPa	ISO 527
Strain at break	50	%	ISO 527
Flexural modulus	2040	MPa	ISO 178
Charpy notched impact strength, +23°C	48	kJ/m <sup>2</sup>	ISO 179/1eA
Izod notched impact strength, +23°C, 4mm	43	kJ/m <sup>2</sup>	ISO 180/1A
Izod notched impact strength, -30°C, 4mm	20	kJ/m <sup>2</sup>	ISO 180/1A
<b>ASTM Data</b>			
Tensile Modulus	2180	MPa	ASTM D 638
Tensile Strength at Yield	64	MPa	ASTM D 638
Tensile Strength at Break	63	MPa	ASTM D 638
Elongation at Yield	6.7	%	ASTM D 638
Elongation at Break	102	%	ASTM D 638
Flexural Modulus	2230	MPa	ASTM D 790
Izod Impact notched, 1/8 in	639	J/m	ASTM D 256
Izod Impact notched, Low-Temperature	331	J/m	ASTM D 256
Temperature	-30	°C	-

Thermal properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Temp. of deflection under load, 1.80 MPa	134	°C	ISO 75-1/-2
Vicat softening temperature, B	155	°C	ISO 306
Vicat softening temperature, 120°C/h 50N	157	°C	ISO 306
<b>ASTM Data</b>			
DTUL @ 264 psi	136	°C	ASTM D 648
Vicat Temperature	156	°C	ASTM D 1525

Other properties	Value	Unit	Test Standard
Water absorption	0.24	%	Sim. to ISO 62
Humidity absorption	0.09	%	Sim. to ISO 62
Density	1100	kg/m <sup>3</sup>	ISO 1183
Density	1200	kg/m <sup>3</sup>	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	-

**LEXAN™ Copolymer 4251R - Americas**

PC

Saudi Basic Industries Corporation (SABIC)

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

**Characteristics****Processing**

Injection Molding

**Regional Availability**

North America