



LEXAN® LGK3020
Americas: COMMERCIAL

CUSTOM ENGINEERED PRODUCTS from GENERAL ELECTRIC PLASTICS. Glass reinforced. Flame retardant.

| TYPICAL PROPERTIES ¹ | TYPICAL VALUE | UNIT | STANDARD |
|--|---------------|-------|------------|
| MECHANICAL | | | |
| Tensile Stress, brk, Type I, 50 mm/min | 118 | MPa | ASTM D 638 |
| Tensile Strain, brk, Type I, 50 mm/min | 4 | % | ASTM D 638 |
| Flexural Stress, brk, 1.3 mm/min, 50 mm span | 148 | MPa | ASTM D 790 |
| Flexural Modulus, 1.3 mm/min, 50 mm span | 6580 | MPa | ASTM D 790 |
| IMPACT | | | |
| Izod Impact, notched, 23°C | 123 | J/m | ASTM D 256 |
| THERMAL | | | |
| HDT, 1.82 MPa, 6.4 mm, unannealed | 146 | °C | ASTM D 648 |
| CTE, -30°C to 30°C, flow | 2.7E-05 | 1/°C | ASTM D 696 |
| CTE, -30°C to 30°C, xflow | 4.68E-05 | 1/°C | ASTM D 696 |
| PHYSICAL | | | |
| Specific Gravity | 1.43 | - | ASTM D 792 |
| Water Absorption, 24 hours | 0.13 | % | ASTM D 570 |
| Mold Shrinkage, flow, 3.2 mm | 0.1 - 0.2 | % | GE Method |
| Mold Shrinkage, xflow, 3.2 mm | 0.2 - 0.3 | % | GE Method |
| ELECTRICAL | | | |
| Dielectric Strength, in oil, 3.2 mm | 17.7 | kV/mm | ASTM D 149 |
| FLAME CHARACTERISTICS | | | |
| UL Recognized, 94V-0 Flame Class Rating (3) | 1.6 | mm | UL 94 |





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| PROCESSING PARAMETERS | TYPICAL VALUE | UNIT |
|-----------------------------|---------------|------|
| Injection Molding | | |
| Drying Temperature | 120 | °C |
| Drying Time | 3 - 4 | hrs |
| Drying Time (Cumulative) | 48 | hrs |
| Maximum Moisture Content | 0.02 | % |
| Melt Temperature | 315 - 340 | °C |
| Nozzle Temperature | 310 - 330 | °C |
| Front - Zone 3 Temperature | 315 - 340 | °C |
| Middle - Zone 2 Temperature | 305 - 325 | °C |
| Rear - Zone 1 Temperature | 295 - 315 | °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 |

