

LEXANT™ FR RESIN DSL1120

DESCRIPTION

LEXAN DSL1120 compound is based on Polycarbonate (PC) resin containing 20% glass bead. Added features of this grade include: Flame Retardant.

GENERAL INFORMATION

Features	Flame Retardant, Low Warpage, Dimensional stability
Fillers	Glass Bead
Polymer Types	Polycarbonate (PC)
Processing Techniques	Injection Molding

INDUSTRY

Building and Construction
Consumer
Electrical and Electronics
Industrial

SUB INDUSTRY

Building Component
Personal Accessory
Mobile Phone - Computer - Tablets
Electrical

TYPICAL PROPERTY VALUES

Revision 20231109

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL ⁽¹⁾			
Flexural Stress, yld, 2.6 mm/min, 100 mm span	88	MPa	ASTM D790
Flexural Modulus, 2.6 mm/min, 100 mm span	2732	MPa	ASTM D790
THERMAL ⁽¹⁾			
HDT, 1.82 MPa, 6.4 mm, unannealed	133	°C	ASTM D648
Relative Temp Index, Elec ⁽²⁾	80	°C	UL 746B
Relative Temp Index, Mech w/impact ⁽²⁾	80	°C	UL 746B
Relative Temp Index, Mech w/o impact ⁽²⁾	80	°C	UL 746B
PHYSICAL ⁽¹⁾			
Melt Flow Rate, 300°C/ 1.2 kgf	9.6	g/10 min	ASTM D1238
POLYMER PROPERTIES ⁽¹⁾			
Ash content	19	Wt. %	-
FLAME CHARACTERISTICS ⁽²⁾			
UL Yellow Card Link	E207780-228416	-	-
UL Recognized, 94V-0 Flame Class Rating	≥3	mm	UL 94
UL Recognized, 94V-1 Flame Class Rating	≥1.5	mm	UL 94
INJECTION MOLDING ⁽³⁾			
Drying Temperature	120	°C	
Drying Time	3 – 4	Hrs	
Melt Temperature	290 – 310	°C	
Nozzle Temperature	280 – 305	°C	
Front - Zone 3 Temperature	290 – 310	°C	



PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Middle - Zone 2 Temperature	275 – 300	°C	
Rear - Zone 1 Temperature	265 – 290	°C	
Mold Temperature	70 – 95	°C	
Back Pressure	0.3 – 0.7	MPa	
Screw Speed	40 – 70	rpm	

- (1) The information stated on Technical Datasheets should be used as indicative only for material selection purposes and not be utilized as specification or used for part or tool design.
- (2) UL Ratings shown on the technical datasheet might not cover the full range of thicknesses and colors. For details, please see the UL Yellow Card.
- (3) Injection Molding parameters are only mentioned as general guidelines. These may not apply or may need adjustment in specific situations such as low shot sizes, large part molding, thin wall molding and gas-assist molding.

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