

LEXANT™ RESIN 244RF

REGION ASIA

DESCRIPTION

LEXAN 244RF resin grade is a medium viscosity multi purpose product with improved flame resistance and release properties. It is also FDA food contact compliant available in limited colors.

TYPICAL PROPERTY VALUES

Revision 20260508

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	62	MPa	ASTM D638
Tensile Stress, brk, Type I, 50 mm/min	68	MPa	ASTM D638
Tensile Strain, yld, Type I, 50 mm/min	7	%	ASTM D638
Tensile Strain, brk, Type I, 50 mm/min	130	%	ASTM D638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	96	MPa	ASTM D790
Flexural Modulus, 1.3 mm/min, 50 mm span	2340	MPa	ASTM D790
Hardness, Rockwell M	70	-	ASTM D785
Hardness, Rockwell R	118	-	ASTM D785
Taber Abrasion, CS-17, 1 kg	10	mg/1000cy	ASTM D1044
IMPACT			
Izod Impact, unnotched, 23°C	3204	J/m	ASTM D4812
Izod Impact, notched, 23°C	801	J/m	ASTM D256
Tensile Impact Strength, Type S	577	kJ/m²	ASTM D1822
Falling Dart Impact (D 3029), 23°C	169	J	ASTM D3029
THERMAL			
Vicat Softening Temp, Rate B/50	154	°C	ASTM D1525
HDT, 0.45 MPa, 6.4 mm, unannealed	137	°C	ASTM D648
HDT, 1.82 MPa, 6.4 mm, unannealed	132	°C	ASTM D648
CTE, -40°C to 95°C, flow	6.84E-05	1/°C	ASTM E831
Specific Heat	1.25	J/g·°C	ASTM C351
Thermal Conductivity	0.27	W/m·°C	ASTM C177
Relative Temp Index, Elec	130	°C	UL 746B
Relative Temp Index, Mech w/impact	130	°C	UL 746B
Relative Temp Index, Mech w/o impact	130	°C	UL 746B
PHYSICAL			
Specific Gravity	1.2	-	ASTM D792
Specific Volume	0.83	cm³/g	ASTM D792
Density	1.19	g/cm³	ASTM D792
Water Absorption, (23°C/24hrs)	0.15	%	ASTM D570
Water Absorption, (23°C/Saturated)	0.35	%	ASTM D570
Water Absorption, equilibrium, 100°C	0.58	%	ASTM D570
Mold Shrinkage, flow, 3.2 mm	0.5 – 0.7	%	SABIC method
Melt Flow Rate, 300°C/1.2 kgf	10.5	g/10 min	ASTM D1238
OPTICAL			

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CHEMISTRY THAT MATTERS™



PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Light Transmission, 2.54 mm	88	%	ASTM D1003
Haze, 2.54 mm	1	%	ASTM D1003
Refractive Index	1.586	-	ASTM D542
ELECTRICAL			
Volume Resistivity	>1.E+17	Ω.cm	ASTM D257
Dielectric Strength, in air, 3.2 mm	14.9	kV/mm	ASTM D149
Relative Permittivity, 50/60 Hz	3.17	-	ASTM D150
Relative Permittivity, 1 MHz	2.96	-	ASTM D150
Dissipation Factor, 50/60 Hz	0.0009	-	ASTM D150
Dissipation Factor, 1 MHz	0.01	-	ASTM D150
Hot Wire Ignition {PLC}	2	PLC Code	UL 746A
High Voltage Arc Track Rate {PLC}	2	PLC Code	UL 746A
High Ampere Arc Ign, surface {PLC}	1	PLC Code	UL 746A
Comparative Tracking Index (UL) {PLC}	2	PLC Code	UL 746A
FLAME CHARACTERISTICS			
UL Recognized, 94V-2 Flame Class Rating	1.5	mm	UL 94
Oxygen Index (LOI)	25	%	ASTM D2863
Glow Wire Flammability Index 850°C, passes at	1	mm	IEC 60695-2-12
Glow Wire Ignitability Temperature, 1.0 mm	875	°C	IEC 60695-2-13
INJECTION MOLDING			
Drying Temperature	120	°C	
Drying Time	3 – 4	Hrs	
Drying Time (Cumulative)	48	Hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	295 – 315	°C	
Nozzle Temperature	290 – 310	°C	
Front - Zone 3 Temperature	295 – 315	°C	
Middle - Zone 2 Temperature	280 – 305	°C	
Rear - Zone 1 Temperature	270 – 295	°C	
Mold Temperature	70 – 95	°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	

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