

LEXANTM FR RESINS 920

REGION AMERICAS

DESCRIPTION

LEXAN 920 Polycarbonate (PC) resin is a non-filled, injection moldable grade. This brominated flame retardant PC has a UL V0 rating and is available in limited opaque color options. LEXAN 920 resin is a general-purpose resin that is an excellent candidate for a wide variety of applications. As a non-chlorinated, non-brominated flame retardant solution, LEXAN 925 resin could be considered an alternative.

TYPICAL PROPERTY VALUES

Revision 20191022

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	62	MPa	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	55	MPa	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	7	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	90	%	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	91	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	2240	MPa	ASTM D 790
Hardness, Rockwell M	70	-	ASTM D 785
Hardness, Rockwell R	118	-	ASTM D 785
Taber Abrasion, CS-17, 1 kg	10	mg/1000cy	ASTM D 1044
IMPACT			
Izod Impact, unnotched, 23°C	3204	J/m	ASTM D 4812
Izod Impact, notched, 23°C	640	J/m	ASTM D 256
Tensile Impact Strength, Type S	525	kJ/m ²	ASTM D 1822
Falling Dart Impact (D 3029), 23°C	169	J	ASTM D 3029
THERMAL			
Vicat Softening Temp, Rate B/50	151	°C	ASTM D 1525
HDT, 0.45 MPa, 6.4 mm, unannealed	137	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	132	°C	ASTM D 648
CTE, -40°C to 95°C, flow	6.84E-05	1/°C	ASTM E 831
Thermal Conductivity	0.19	W/m·°C	ASTM C177
Relative Temp Index, Elec	130	°C	UL 746B
Relative Temp Index, Mech w/impact	120	°C	UL 746B
Relative Temp Index, Mech w/o impact	130	°C	UL 746B
PHYSICAL			
Specific Gravity	1.21	-	ASTM D 792
Specific Volume	0.83	cm ³ /g	ASTM D 792
Density	1.217	g/cm ³	ASTM D 792
Water Absorption, 24 hours	0.15	%	ASTM D 570
Water Absorption, equilibrium, 23C	0.35	%	ASTM D 570
Water Absorption, equilibrium, 100°C	0.58	%	ASTM D 570
Mold Shrinkage, flow, 3.2 mm	0.5 – 0.7	%	SABIC method
Melt Flow Rate, 300°C/1.2 kgf	14.5	g/10 min	ASTM D 1238
ELECTRICAL			

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Volume Resistivity	>1.E+17	Ohm-cm	ASTM D 257
Dielectric Strength, in air, 3.2 mm	16.7	kV/mm	ASTM D 149
Relative Permittivity, 50/60 Hz	3.01	-	ASTM D 150
Relative Permittivity, 1 MHz	2.96	-	ASTM D 150
Dissipation Factor, 50/60 Hz	0.0009	-	ASTM D 150
Dissipation Factor, 1 MHz	0.01	-	ASTM D 150
Arc Resistance, Tungsten {PLC}	7	PLC Code	ASTM D 495
Hot Wire Ignition {PLC}	2	PLC Code	UL 746A
High Voltage Arc Track Rate {PLC}	4	PLC Code	UL 746A
High Ampere Arc Ign, surface {PLC}	3	PLC Code	UL 746A
Comparative Tracking Index (UL) {PLC}	2	PLC Code	UL 746A
FLAME CHARACTERISTICS			
UL Yellow Card Link	E121562-220892	-	-
UL Recognized, 94V-0 Flame Class Rating	1.5	mm	UL 94
Oxygen Index (LOI)	35	%	ASTM D 2863
UV-light, water exposure/immersion	F1	-	UL 746C
INJECTION MOLDING			
Drying Temperature	120	°C	
Drying Time	3 – 4	hrs	
Drying Time (Cumulative)	48	hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	290 – 310	°C	
Nozzle Temperature	280 – 305	°C	
Front - Zone 3 Temperature	290 – 310	°C	
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	
Shot to Cylinder Size	40 – 60	%	
Vent Depth	0.025 – 0.076	mm	

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