

# LEXAN<sup>TM</sup> VISUALFX<sup>TM</sup> RESIN FXM941A

REGION AMERICAS

## DESCRIPTION

PC in special effects colors. Metallic and pearlescent additives. Color package may affect performance.

## TYPICAL PROPERTY VALUES

Revision 20191031

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
<b>MECHANICAL</b>			
Tensile Stress, yld, Type I, 50 mm/min	61	MPa	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	57	MPa	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	6	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	95	%	ASTM D 638
Tensile Modulus, 50 mm/min	2300	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	95	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	2390	MPa	ASTM D 790
<b>IMPACT</b>			
Izod Impact, notched, 23°C	160	J/m	ASTM D 256
Instrumented Impact Total Energy, 23°C	59	J	ASTM D 3763
<b>THERMAL</b>			
HDT, 0.45 MPa, 3.2 mm, unannealed	137	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	126	°C	ASTM D 648
Relative Temp Index, Elec <sup>(1)</sup>	130	°C	UL 746B
Relative Temp Index, Mech w/impact <sup>(1)</sup>	120	°C	UL 746B
Relative Temp Index, Mech w/o impact <sup>(1)</sup>	130	°C	UL 746B
<b>PHYSICAL</b>			
Specific Gravity	1.2	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	0.5 – 0.7	%	SABIC method
Melt Flow Rate, 300°C/ 1.2 kgf	10.2	g/10 min	ASTM D 1238
<b>ELECTRICAL</b>			
Comparative Tracking Index (UL) {PLC}	2	PLC Code	UL 746A
Hot-Wire Ignition (HWI), PLC 2	≥3	mm	UL 746A
Hot-Wire Ignition (HWI), PLC 3	≥1.5	mm	UL 746A
High Amp Arc Ignition (HAI), PLC 1	≥1.5	mm	UL 746A
High Amp Arc Ignition (HAI), PLC 3	≥3	mm	UL 746A
High Voltage Arc Track Rate {PLC}	3	PLC Code	UL 746A
Arc Resistance, Tungsten {PLC}	7	PLC Code	ASTM D 495
<b>FLAME CHARACTERISTICS <sup>(1)</sup></b>			
UL Yellow Card Link	<a href="#">E121562-220936</a>	-	-
UL Yellow Card Link 2	<a href="#">E121562-220938</a>	-	-
UL Recognized, 94V-2 Flame Class Rating	≥1.5	mm	UL 94
UL Recognized, 94V-0 Flame Class Rating	≥3	mm	UL 94
<b>INJECTION MOLDING</b>			

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
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	

(1) 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.

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