



LEXAN™ Resin 4795R

Americas: COMMERCIAL

LEXAN 4795R is a high heat resistant poly(ester)carbonate injection molding resin. Flame Retardant.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	690	kgf/cm ²	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	710	kgf/cm ²	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	7.5	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	117	%	ASTM D 638
Tensile Modulus, 50 mm/min	22100	kgf/cm ²	ASTM D 638
Flexural Stress, brk, 1.3 mm/min, 50 mm span	1070	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	22400	kgf/cm ²	ASTM D 790
IMPACT			
Izod Impact, unnotched, 23°C	218	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	58	cm-kgf/cm	ASTM D 256
Instrumented Impact Energy @ peak, 23°C	744	cm-kgf	ASTM D 3763
Instrumented Impact Total Energy, 23°C	785	cm-kgf	ASTM D 3763
THERMAL			
Vicat Softening Temp, Rate B/50	164	°C	ASTM D 1525
HDT, 0.45 MPa, 3.2 mm, unannealed	160	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	147	°C	ASTM D 648
Ball Pressure Test, 125°C +/- 2°C	PASS	-	IEC 60695-10-2
PHYSICAL			
Specific Gravity	1.2	-	ASTM D 792
Melt Flow Rate, 330°C/2.16 kgf	15	g/10 min	ASTM D 1238
Density	1.2	g/cm ³	ISO 1183



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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	350 - 370	°C
Nozzle Temperature	345 - 365	°C
Front - Zone 3 Temperature	350 - 370	°C
Middle - Zone 2 Temperature	340 - 360	°C
Rear - Zone 1 Temperature	325 - 350	°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