



## LEXAN™ Resin 9915A

### Americas: COMMERCIAL

LEXAN 9915A Polycarbonate (PC) resin is an un-filled, extrusion or injection moldable grade; non-chlorinated, non-brominated flame retardant systems with UL-90 V0 rating @1.5mm. It is UV stabilized & available in transparent & tinted color options.

| TYPICAL PROPERTIES <sup>1</sup>              | TYPICAL VALUE | Unit                | Standard    |
|----------------------------------------------|---------------|---------------------|-------------|
| <b>MECHANICAL</b>                            |               |                     |             |
| Tensile Stress, yld, Type I, 50 mm/min       | 650           | kgf/cm <sup>2</sup> | ASTM D 638  |
| Tensile Stress, brk, Type I, 50 mm/min       | 630           | kgf/cm <sup>2</sup> | ASTM D 638  |
| Tensile Strain, yld, Type I, 50 mm/min       | 6             | %                   | ASTM D 638  |
| Tensile Strain, brk, Type I, 50 mm/min       | 111           | %                   | ASTM D 638  |
| Tensile Modulus, 50 mm/min                   | 23600         | kgf/cm <sup>2</sup> | ASTM D 638  |
| Flexural Stress, yld, 1.3 mm/min, 50 mm span | 1020          | kgf/cm <sup>2</sup> | ASTM D 790  |
| Flexural Modulus, 1.3 mm/min, 50 mm span     | 23700         | kgf/cm <sup>2</sup> | ASTM D 790  |
| <b>IMPACT</b>                                |               |                     |             |
| Izod Impact, unnotched, 23°C                 | 217           | cm-kgf/cm           | ASTM D 4812 |
| Izod Impact, notched, 23°C                   | 81            | cm-kgf/cm           | ASTM D 256  |
| Izod Impact, notched, -30°C                  | 12            | cm-kgf/cm           | ASTM D 256  |
| Instrumented Impact Energy @ peak, 23°C      | 764           | cm-kgf              | ASTM D 3763 |
| <b>THERMAL</b>                               |               |                     |             |
| HDT, 0.45 MPa, 3.2 mm, unannealed            | 142           | °C                  | ASTM D 648  |
| HDT, 1.82 MPa, 3.2mm, unannealed             | 138           | °C                  | ASTM D 648  |
| CTE, -40°C to 95°C, flow                     | 6.8E-05       | 1/°C                | ASTM E 831  |
| CTE, -40°C to 95°C, xflow                    | 6.8E-05       | 1/°C                | ASTM E 831  |
| Vicat Softening Temp, Rate B/120             | 146           | °C                  | ISO 306     |
| Relative Temp Index, Elec                    | 125           | °C                  | UL 746B     |
| Relative Temp Index, Mech w/impact           | 115           | °C                  | UL 746B     |
| Relative Temp Index, Mech w/o impact         | 125           | °C                  | UL 746B     |
| <b>PHYSICAL</b>                              |               |                     |             |
| Specific Gravity                             | 1.2           | -                   | ASTM D 792  |
| Density                                      | 1.07          | g/cm <sup>3</sup>   | ASTM D 792  |



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|---------------------------------------------|---------------|----------|--------------|
| <b>PHYSICAL</b>                             |               |          |              |
| Mold Shrinkage on Tensile Bar, flow (2) (5) | 0.6 - 0.8     | %        | SABIC Method |
| Melt Flow Rate, 300°C/1.2 kgf               | 6.3           | g/10 min | ASTM D 1238  |
| <b>ELECTRICAL</b>                           |               |          |              |
| Hot Wire Ignition {PLC}                     | 3             | PLC Code | UL 746A      |
| High Ampere Arc Ign, surface {PLC}          | 1             | PLC Code | UL 746A      |
| Comparative Tracking Index (UL) {PLC}       | 3             | PLC Code | UL 746A      |
| <b>FLAME CHARACTERISTICS</b>                |               |          |              |
| UL Recognized, 94V-0 Flame Class Rating (3) | 1.5           | mm       | UL 94        |



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| PROCESSING PARAMETERS       | TYPICAL VALUE | Unit |
|-----------------------------|---------------|------|
| <b>Injection Molding</b>    |               |      |
| Drying Temperature          | 120           | °C   |
| Drying Time                 | 3 - 4         | hrs  |
| Drying Time (Cumulative)    | 48            | hrs  |
| Maximum Moisture Content    | 0.02          | %    |
| Melt Temperature            | 280 - 305     | °C   |
| Nozzle Temperature          | 275 - 300     | °C   |
| Front - Zone 3 Temperature  | 280 - 305     | °C   |
| Middle - Zone 2 Temperature | 270 - 295     | °C   |
| Rear - Zone 1 Temperature   | 260 - 280     | °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   |