+135-3858-6433 (GuangDong)
+188-1699-6168 (ShangHai)
+852-6957-5415 (HongKong)

LEXAN™ Resin BX9349

Asia Pacific: COMMERCIAL

LEXAN BX9349 resin is an injection moldable modified PC resin with non-brominated and non-chlorinated flame retardant to meet UL-94 V0 at 0.5mm and V2 at 0.4mm. Balanced flow with low temperature ductile together with the thin wall flame resistance, make it an ideal material of choice for a wide variety of thin wall applications

TYPICAL PROPERTIES[1]	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Modulus, 50 mm/min	25400	kgf/cm²	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	910	kgf/cm²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	22900	kgf/cm²	ASTM D 790
Tensile Stress, yield, 50 mm/min	65	MPa	ISO 527
Tensile Stress, break, 50 mm/min	50	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	4	%	ISO 527
Tensile Strain, break, 50 mm/min	50	%	ISO 527
IMPACT			
Izod Impact, notched, 23°C	69	cm-kgf/cm	ASTM D 256
Izod Impact, notched, 0°C	56	cm-kgf/cm	ASTM D 256
Instrumented Impact Total Energy, 23°C	662	cm-kgf	ASTM D 3763
THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	106	°C	ASTM D 648
Ball Pressure Test, 75°C +/- 2°C	PASS	-	IEC 60695-10-2
Vicat Softening Temp, Rate B/120	116	°C	ISO 306
Relative Temp Index, Elec	80	°C	UL 746B
Relative Temp Index, Mech w/impact	80	°C	UL 746B
Relative Temp Index, Mech w/o impact	80	°C	UL 746B
PHYSICAL			
Specific Gravity	1.2	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm (5)	0.4 - 0.6	%	SABIC Method
Melt Flow Rate, 260°C/2.16 kgf	9	g/10 min	ASTM D 1238
Density	1.2	g/cm³	ISO 1183
Water Absorption, (23°C/sat)	0.2	%	ISO 62

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TYPICAL PROPERTIES[1]	TYPICAL VALUE	Unit	Standard
PHYSICAL			
Moisture Absorption (23°C / 50% RH)	0.1	%	ISO 62
FLAME CHARACTERISTICS			
UL Recognized, 94V-2 Flame Class Rating (3)	0.4	mm	UL 94
UL Recognized, 94V-0 Flame Class Rating (3)	0.5	mm	UL 94

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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	80 - 90	°C
Drying Time	2 - 4	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	250 - 300	°C
Nozzle Temperature	250 - 300	°C
Front - Zone 3 Temperature	250 - 300	°C
Middle - Zone 2 Temperature	240 - 290	°C
Rear - Zone 1 Temperature	230 - 280	°C
Hopper Temperature	60 - 80	°C
Mold Temperature	60 - 85	°C
Vent Depth	0.03 - 0.075	mm