



LEXAN™ Resin FL920
Americas: COMMERCIAL

Various weight reductions at .250" (6.35 mm) wall, 20% GR. Excellent flex mod, high tensile strength/heat resistance. V-0/5V at .250" (6.35mm).

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
FOAM - MECHANICAL 6.4 mm Wt Reduction	10	%	-
Tensile Stress, yield, 6.35 mm	590	kgf/cm ²	ASTM D 638
Tensile Strain, break, 6.35 mm	3.6	%	ASTM D 638
Tensile Modulus, 6.4 mm	43500	kgf/cm ²	ASTM D 638
Flexural Stress, yield, 6.4 mm	1080	kgf/cm ²	ASTM D 790
Flexural Modulus, 6.4 mm	52300	kgf/cm ²	ASTM D 790
IMPACT			
FOAM - IMPACT 6.4 mm Wt Reduction	10	%	-
Izod Impact, unnotched, 23°C	43	cm-kgf/cm	ASTM D 4812
Falling Dart Impact, 23°C	442	cm-kgf	SABIC Method
THERMAL			
FOAM - THERMAL 6.4mm Wt Reduction	10	%	-
HDT, 0.45 MPa, 6.4 mm, unannealed	143	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	136	°C	ASTM D 648
CTE, -40°C to 95°C, flow	2.7E-05	1/°C	ASTM E 831
Specific Heat	1.17	J/g-°C	ASTM C 351
Relative Temp Index, Elec	110	°C	UL 746B
Relative Temp Index, Mech w/impact	110	°C	UL 746B
Relative Temp Index, Mech w/o impact	110	°C	UL 746B
PHYSICAL			
FOAM - PHYSICAL 6.4mm Wt Reduction	10	%	-
Specific Gravity	1.32	-	ASTM D 792
Specific Gravity, foam molded	1.19	-	ASTM D 792
Water Absorption, 24 hours	0.14	%	ASTM D 570



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TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
PHYSICAL			
Water Absorption, equilibrium, 23C	0.3	%	ASTM D 570
Mold Shrinkage, flow, 6.4 mm (5)	0.3 - 0.5	%	SABIC Method
ELECTRICAL			
FOAM - ELECTRICAL 6.4 mm Wt Reduction	20	%	-
Volume Resistivity	2.5E+17	Ohm-cm	ASTM D 257
Surface Resistivity	>1.1E+17	Ohm	ASTM D 257
Relative Permittivity, 100 Hz	2.52	-	ASTM D 150
Relative Permittivity, 1 MHz	2.5	-	ASTM D 150
Dissipation Factor, 100 Hz	0.0008	-	ASTM D 150
Dissipation Factor, 1 MHz	0.0052	-	ASTM D 150
Hot Wire Ignition {PLC}	1	PLC Code	UL 746A
High Voltage Arc Track Rate {PLC}	3	PLC Code	UL 746A
High Ampere Arc Ign, surface {PLC}	2	PLC Code	UL 746A
Comparative Tracking Index (UL) {PLC}	3	PLC Code	UL 746A
FLAME CHARACTERISTICS			
FOAM - Flame Class Minimum Density	0.85	g/cm ³	-
UL Recognized, 94V-0 Flame Class Rating (3)	5.99	mm	UL 94
UL Recognized, 94-5VA Rating (3)	5.99	mm	UL 94



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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Structural Foam Molding		
Blowing Agent, Physical System	Nitrogen	-
Blowing Agent, Chemical System	FLC95	-
Drying Time (Blowing Agent)	4	hrs
Drying Temperature (Blowing Agent)	105	°C
Concentration Range (Blowing Agent)	3 - 5	%
Recommended Concentration (Blowing Agent)	1.5	%
Drying Temperature (Resin)	120	°C
Drying Time (Resin)	3 - 4	hrs
Drying Time (Resin, Cumulative)	48	hrs
Melt Temperature	290 - 315	°C
Nozzle Temperature	270 - 295	°C
Front Temperature	295 - 310	°C
Middle Temperature	295 - 310	°C
Rear Temperature	255 - 265	°C
Mold Temperature	70 - 95	°C