



LEXAN™ Resin FST9436
Americas: COMMERCIAL

Medium viscosity opaque, low smoke, and OSU 65/65 compliant PC Copolymer

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	660	kgf/cm ²	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	580	kgf/cm ²	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	6.5	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	103	%	ASTM D 638
Tensile Modulus, 5 mm/min	23000	kgf/cm ²	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	1040	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	23900	kgf/cm ²	ASTM D 790
Tensile Stress, yield, 50 mm/min	65	MPa	ISO 527
Tensile Stress, break, 50 mm/min	58	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	6.3	%	ISO 527
Tensile Strain, break, 50 mm/min	92	%	ISO 527
Tensile Modulus, 1 mm/min	2260	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	96	MPa	ISO 178
Flexural Modulus, 2 mm/min	2280	MPa	ISO 178
IMPACT			
Izod Impact, notched, 23°C	41	cm-kgf/cm	ASTM D 256
Izod Impact, notched, -30°C	12	cm-kgf/cm	ASTM D 256
Instrumented Impact Total Energy, 23°C	754	cm-kgf	ASTM D 3763
Izod Impact, notched 80*10*4 +23°C	22	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	13	kJ/m ²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	27	kJ/m ²	ISO 179/1eA
THERMAL			
Vicat Softening Temp, Rate B/50	154	°C	ASTM D 1525



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THERMAL			
HDT, 1.82 MPa, 3.2mm, unannealed	134	°C	ASTM D 648
CTE, -40°C to 40°C, flow	6.E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	6.3E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, flow	6.E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	6.3E-05	1/°C	ISO 11359-2
Ball Pressure Test, approximate maximum	125	°C	IEC 60695-10-2
Vicat Softening Temp, Rate B/50	152	°C	ISO 306
Vicat Softening Temp, Rate B/120	154	°C	ISO 306
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	131	°C	ISO 75/Af
PHYSICAL			
Specific Gravity	1.29	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm (5)	0.6 - 0.8	%	SABIC Method
Melt Flow Rate, 300°C/1.2 kgf	10	g/10 min	ASTM D 1238
Density	1.29	g/cm ³	ISO 1183
Melt Volume Rate, MVR at 300°C/1.2 kg	9	cm ³ /10 min	ISO 1133
Melt Volume Rate, MVR at 300°C/5.0 kg	44	cm ³ /10 min	ISO 1133
FLAME CHARACTERISTICS			
OSU total heat release (2 minute test)	<65	kW-min/m ²	FAR 25.853
OSU peak heat release rate (5 minute test)	<65	kW/m ²	FAR 25.853
Vertical Burn a (60s) passes at	<15	sec	FAR 25.853
Vertical Burn b (12s) passes at	<15	sec	FAR 25.853
NBS Smoke Density, Flaming, Dmax	<40	-	ASTM E 662



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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	105	°C
Drying Time	3 - 4	hrs
Drying Time (Cumulative)	12	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 - 105	°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