



LEXAN™ Resin FXD941A
Americas: COMMERCIAL

FXD153 is an Extrusion / Blow molding grade in a Diffusion effect, which is part of the VisualFX family. These effects have been developed to meet increasing Aesthetic demands in the Marketplace. Color Package may affect properties, Application testing always recommended.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	630	kgf/cm ²	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	670	kgf/cm ²	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	7	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	110	%	ASTM D 638
Tensile Modulus, 5 mm/min	23800	kgf/cm ²	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	940	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	23800	kgf/cm ²	ASTM D 790
IMPACT			
Izod Impact, unnotched, 23°C	326	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	76	cm-kgf/cm	ASTM D 256
THERMAL			
Vicat Softening Temp, Rate B/50	157	°C	ASTM D 1525
HDT, 0.45 MPa, 3.2 mm, unannealed	138	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	132	°C	ASTM D 648
CTE, -40°C to 40°C, xflow	6.8E-05	1/°C	ASTM E 831
PHYSICAL			
Specific Gravity	1.2	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm (5)	0.5 - 0.7	%	SABIC Method
Melt Flow Rate, 300°C/1.2 kgf	2.5	g/10 min	ASTM D 1238



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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	320 - 345	°C
Nozzle Temperature	315 - 340	°C
Front - Zone 3 Temperature	320 - 345	°C
Middle - Zone 2 Temperature	310 - 330	°C
Rear - Zone 1 Temperature	300 - 320	°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