



LEXAN™ Resin LUX9616

Asia Pacific: COMMERCIAL

Lexan LUX9616 is a flame retardant polycarbonate featuring non brominated and non chlorinated FR system with diffusion effective and thin wall FR performance. It intended to meet WEEE/RoHS requirements for various applications.

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	660	kgf/cm ²	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	6	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	80	%	ASTM D 638
Tensile Modulus, 5 mm/min	23400	kgf/cm ²	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	960	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	22000	kgf/cm ²	ASTM D 790
Tensile Stress, yield, 50 mm/min	62	MPa	ISO 527
Tensile Stress, break, 50 mm/min	58	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	6	%	ISO 527
Tensile Strain, break, 50 mm/min	75	%	ISO 527
Tensile Modulus, 1 mm/min	2230	MPa	ISO 527
Flexural Stress, brk, 12.5 mm/min	95	MPa	ISO 178
Flexural Modulus, 2 mm/min	2250	MPa	ISO 178
IMPACT			
Izod Impact, notched, 23°C	15	cm-kgf/cm	ASTM D 256
Instrumented Impact Total Energy, 23°C	713	cm-kgf	ASTM D 3763
Izod Impact, notched 80*10*3 +23°C	15	kJ/m ²	ISO 180/1A
THERMAL			
Vicat Softening Temp, Rate B/50	141	°C	ASTM D 1525
HDT, 1.82 MPa, 3.2mm, unannealed	125	°C	ASTM D 648
CTE, -40°C to 40°C, flow	6.8E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	6.7E-05	1/°C	ASTM E 831



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TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
THERMAL			
Ball Pressure Test, 125°C +/- 2°C	PASSES	-	IEC 60695-10-2
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	125	°C	ISO 75/Af
PHYSICAL			
Specific Gravity	1.2	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm (5)	0.6 - 0.8	%	SABIC Method
Melt Flow Rate, 300°C/1.2 kgf	7	g/10 min	ASTM D 1238
Density	1.2	g/cm ³	ISO 1183
Water Absorption, (23°C/sat)	0.35	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.15	%	ISO 62
ELECTRICAL			
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
FLAME CHARACTERISTICS			
UL Recognized, 94V-0 Flame Class Rating (3)	1.5	mm	UL 94
Glow Wire Flammability Index 960°C, passes at	1	mm	IEC 60695-2-12
Glow Wire Ignitability Temperature, 1.0 mm	850	°C	IEC 60695-2-13
Glow Wire Ignitability Temperature, 1.5 mm	850	°C	IEC 60695-2-13



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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	120	°C
Drying Time	2 - 4	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	280 - 310	°C
Nozzle Temperature	270 - 290	°C
Front - Zone 3 Temperature	280 - 310	°C
Middle - Zone 2 Temperature	270 - 290	°C
Rear - Zone 1 Temperature	260 - 280	°C
Hopper Temperature	60 - 80	°C
Mold Temperature	80 - 110	°C



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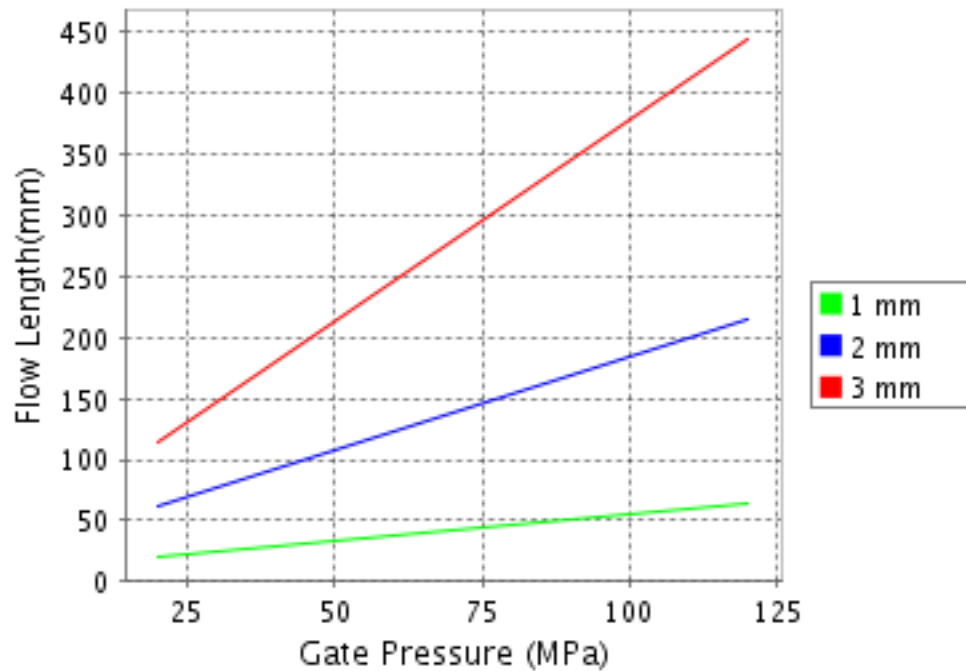
CALCULATED FLOW LENGTH INDICATION

Moldflow® Radial Flow Analysis

LEXAN® LUX9616

Melt Temperature : 295°C

Mold Temperature : 95°C



Note: Technical support is recommended if Gate Pressure is greater than 80 MPa. Contact your local representative.

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