

LEXAN™ 4795R resin

Polyphthalate Carbonate
SABIC Innovative Plastics

Message:

LEXAN 4795R is a high heat resistant poly(ester)carbonate injection molding resin. Flame Retardant.

General Information			
Features	Flame Retardant		
	High Heat Resistance		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.20	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (330°C/2.16 kg)	15	g/10 min	ASTM D1238
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ¹	2170	MPa	ASTM D638
Tensile Strength ²			ASTM D638
Yield	68.0	MPa	
Break	70.0	MPa	
Tensile Elongation ³			ASTM D638
Yield	7.5	%	
Break	120	%	
Flexural Modulus ⁴ (50.0 mm Span)	2210	MPa	ASTM D790
Flexural Strength ⁵ (Break, 50.0 mm Span)	105	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	580	J/m	ASTM D256
Unnotched Izod Impact (23°C)	2100	J/m	ASTM D4812
Instrumented Dart Impact			ASTM D3763
23°C, Energy at Peak Load	73.0	J	
23°C, Total Energy	77.0	J	
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed, 3.20 mm	160	°C	
1.8 MPa, Unannealed, 3.20 mm	147	°C	
Vicat Softening Temperature	164	°C	ASTM D1525 ⁶
Ball Pressure Test (125°C)	Pass		IEC 60695-10-2
Injection	Nominal Value	Unit	
Drying Temperature	121	°C	
Drying Time	3.0 to 4.0	hr	

Drying Time, Maximum	48	hr
Suggested Max Moisture	0.020	%
Suggested Shot Size	40 to 60	%
Rear Temperature	327 to 349	°C
Middle Temperature	338 to 360	°C
Front Temperature	349 to 371	°C
Nozzle Temperature	343 to 366	°C
Processing (Melt) Temp	349 to 371	°C
Mold Temperature	82.2 to 116	°C
Back Pressure	0.345 to 0.689	MPa
Screw Speed	40 to 70	rpm
Vent Depth	0.025 to 0.076	mm

NOTE

1. 50 mm/min
2. Type I, 50 mm/min
3. Type I, 50 mm/min
4. 1.3 mm/min
5. 1.3 mm/min
6. Rate B (120°C/h), Loading 2 (50 N)

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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China



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