LEXAN™ 923X resin

Polycarbonate

SABIC Innovative Plastics Asia Pacific

Message:

LEXAN923x is a UV stabilized high flow impact modified injection molding (IM) grade. This resin offers UL94 V0 @ 1.5mm flame retardancy based on non-bromine, non-chlorine FR systems, low temperature ductility characteristics and excellent processability with opportunities for shorter IM cycle times compared to standard PC. LEXAN 923x resin is a product available in a wide range of opaque colors and may be an excellent candidate for a wide range of applications.

General Information			
Additive	Impact Modifier UV Stabilizer		
Features	Bromine Free Chlorine Free Ductile Fast Molding Cycle Flame Retardant Good Processability High Flow Impact Modified		
Uses	General Purpose		
Appearance	Colors Available Opaque		
Processing Method	Injection Molding		
Physical	**Nominal Value**	**Unit**	**Test Method**
Specific Gravity	1.19	g/cm³	ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	16	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm)	0.40 to 0.80	%	Internal Method
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus [1]	2100	MPa	ASTM D638
Tensile Strength [2]			ASTM D638
Yield	58.0	MPa	
Break	60.0	MPa	
Tensile Elongation [3]			ASTM D638
Yield	6.0	%	
Break	110	%	
Flexural Modulus [4] (50.0 mm Span)	2400	MPa	ASTM D790
Flexural Strength [5] (Yield, 50.0 mm Span)	90.0	MPa	ASTM D790

Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-30°C	650	J/m	
23°C	780	J/m	
Instrumented Dart Impact (23°C, Total Energy)	65.0	J	ASTM D3763
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load (1.8 MPa, Unannealed, 3.20 mm)	123	°C	ASTM D648
Vicat Softening Temperature	140	°C	ASTM D1525 [6]
CLTE			ASTM E831
Flow : -40 to 40°C	6.1E-5	cm/cm/°C	
Transverse : -40 to 40°C	6.2E-5	cm/cm/°C	
RTI Elec	125	°C	UL 746
RTI Imp	115	°C	UL 746
RTI Str	120	°C	UL 746
Flammability	**Nominal Value**	**Unit**	**Test Method**
Flame Rating			UL 94
1.50 mm	V-0		
3.00 mm	5VA		
Glow Wire Flammability Index (1.50 mm)	960	°C	IEC 60695-2-12
Glow Wire Ignition Temperature			IEC 60695-2-13
1.50 mm	825	°C	
3.00 mm	825	°C	
Injection	**Nominal Value**	**Unit**	
Drying Temperature	120	°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	270 to 295	°C	
Middle Temperature	280 to 305	°C	
Front Temperature	295 to 315	°C	
Nozzle Temperature	290 to 310	°C	
Processing (Melt) Temp	295 to 315	°C	
Mold Temperature	70.0 to 95.0	°C	
Back Pressure	0.300 to 0.700	MPa	
Screw Speed	40 to 70	rpm	
Vent Depth	0.025 to 0.076	mm	
NOTE			
1.	5.0 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)

Recommended distributors for this material

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