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 Flame retardancy		
Features	Chlorine Free Impact modification Workability, good Fast molding cycle High liquidity Bromine-free ductility Flame retardancy		
RoHS Compliance	RoHS compliance		
Appearance	Opacity Available colors		
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 - 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	ASTM D638
Fracture	60.0	MPa	ASTM D638
Tensile Elongation [3]			ASTM D638
Yield	6.0	%	ASTM D638
Fracture	110	%	ASTM D638
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	ASTM D256
23°C	780	J/m	ASTM D256
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]
Linear thermal expansion coefficient			ASTM E831
Flow: -40 to 40°C	6.1E-5	cm/cm/°C	ASTM E831
Lateral: -40 to 40°C	6.2E-5	cm/cm/°C	ASTM E831
RTI Elec	125	°C	UL 746
RTI Imp	115	°C	UL 746
RTI	120	°C	UL 746
Flammability	**Nominal Value**	**Unit**	**Test Method**
Flame Rating			UL 94
1.50 mm	V-0		UL 94
3.00 mm	5VA		UL 94
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	IEC 60695-2-13
3.00 mm	825	°C	IEC 60695-2-13
Injection	**Nominal Value**	**Unit**	
Drying Temperature	120	°C	
Drying Time	3.0 - 4.0	hr	
Drying Time, Maximum	48	hr	
Suggested Max Moisture	0.020	%	
Suggested Shot Size	40 - 60	%	
Rear Temperature	270 - 295	°C	
Middle Temperature	280 - 305	°C	
Front Temperature	295 - 315	°C	
Nozzle Temperature	290 - 310	°C	
Processing (Melt) Temp	295 - 315	°C	
Mold Temperature	70.0 - 95.0	°C	
Back Pressure	0.300 - 0.700	MPa	
Screw Speed	40 - 70	rpm	
Vent Depth	0.025 - 0.076	mm	
NOTE			
1.	5.0 mm/min		
2.	Type 1, 50mm/min		

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

Recommended distributors for this material

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