

LEXAN™ FXD941A resin

Polycarbonate

SABIC Innovative Plastics

Message:

FXD941A 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.

General Information			
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.20	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	2.5	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm)	0.50 to 0.70	%	Internal Method
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ¹	2340	MPa	ASTM D638
Tensile Strength ²			ASTM D638
Yield	62.0	MPa	
Break	66.0	MPa	
Tensile Elongation ³			ASTM D638
Yield	7.0	%	
Break	110	%	
Flexural Modulus ⁴ (50.0 mm Span)	2340	MPa	ASTM D790
Flexural Strength ⁵ (Yield, 50.0 mm Span)	93.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	750	J/m	ASTM D256
Unnotched Izod Impact (23°C)	3200	J/m	ASTM D4812
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed, 3.20 mm	138	°C	
1.8 MPa, Unannealed, 3.20 mm	132	°C	
Vicat Softening Temperature	157	°C	ASTM D1525 ⁶
CLTE - Transverse (-40 to 40°C)	6.8E-5	cm/cm/°C	ASTM E831
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	299 to 321	°C	
Middle Temperature	310 to 332	°C	

Front Temperature	321 to 343	°C
Nozzle Temperature	316 to 338	°C
Processing (Melt) Temp	321 to 343	°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.	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)

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