

LEXAN™ BX9349 resin

Polycarbonate

SABIC Innovative Plastics Asia Pacific

Message:

LEXAN BX9349 resin is an injection moldable modified PC resin with non-brominated and non-chlorinated flame retardant to meet UL-94 V0 at 0.5mm and V2 at 0.4mm. Balanced flow with low temperature ductile together with the thin wall flame resistance, make it an ideal material of choice for a wide variety of thin wall applications

General Information			
Features	Bromine Free		
	Chlorine Free		
	Ductile		
	Flame Retardant		
	Good Flow		
Uses	Thin-walled Parts		
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) (260°C/2.16 kg)	9.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm)	0.40 to 0.60	%	Internal Method
Water Absorption			ISO 62
Saturation, 23°C	0.20	%	
Equilibrium, 23°C, 50% RH	0.10	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ¹	2500	MPa	ASTM D638
Tensile Stress			ISO 527-2/50
Yield	65.0	MPa	
Break	50.0	MPa	
Tensile Strain			ISO 527-2/50
Yield	4.0	%	
Break	50	%	
Flexural Modulus ² (50.0 mm Span)	2250	MPa	ASTM D790
Flexural Strength ³ (Yield, 50.0 mm Span)	90.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
0°C	550	J/m	
23°C	680	J/m	
Instrumented Dart Impact (23°C, Total Energy)	65.0	J	ASTM D3763

Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (0.45 MPa, Unannealed, 3.20 mm)	106	°C	ASTM D648
Vicat Softening Temperature	116	°C	ISO 306/B120
Ball Pressure Test (75°C)	Pass		IEC 60695-10-2
RTI Elec	80.0	°C	UL 746
RTI Imp	80.0	°C	UL 746
RTI Str	80.0	°C	UL 746
Flammability	Nominal Value		Test Method
Flame Rating			UL 94
0.400 mm	V-2		
0.500 mm	V-0		
Injection	Nominal Value	Unit	
Drying Temperature	80.0 to 90.0	°C	
Drying Time	2.0 to 4.0	hr	
Suggested Max Moisture	0.020	%	
Hopper Temperature	60.0 to 80.0	°C	
Rear Temperature	230 to 280	°C	
Middle Temperature	240 to 290	°C	
Front Temperature	250 to 300	°C	
Nozzle Temperature	250 to 300	°C	
Processing (Melt) Temp	250 to 300	°C	
Mold Temperature	60.0 to 85.0	°C	
Vent Depth	0.030 to 0.075	mm	
NOTE			
1.	50 mm/min		
2.	1.3 mm/min		
3.	1.3 mm/min		

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