

LEXAN™ FXM941A resin

Polycarbonate
SABIC Innovative Plastics

Message:
PC in special effects colors. Metallic and pearlescent additives. Color package may affect performance.

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)	10	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	2310	MPa	ASTM D638
Tensile Strength ²			ASTM D638
Yield	61.7	MPa	
Break	57.2	MPa	
Tensile Elongation ³			ASTM D638
Yield	6.0	%	
Break	95	%	
Flexural Modulus ⁴ (50.0 mm Span)	2400	MPa	ASTM D790
Flexural Strength ⁵ (Yield, 50.0 mm Span)	95.1	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	160	J/m	ASTM D256
Instrumented Dart Impact (23°C, Total Energy)	59.9	J	ASTM D3763
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	127	°C	
RTI Elec	80.0	°C	UL 746
RTI Imp	80.0	°C	UL 746
RTI Str	80.0	°C	UL 746
Electrical	Nominal Value		Test Method
Arc Resistance ⁶	PLC 7		ASTM D495
Comparative Tracking Index (CTI)	PLC 2		UL 746
High Amp Arc Ignition (HAI)	PLC 3		UL 746
High Voltage Arc Tracking Rate (HVTR)	PLC 3		UL 746
Hot-wire Ignition (HWI)	PLC 2		UL 746
Flammability	Nominal Value		Test Method

Flame Rating		UL 94
1.52 mm	V-2	
3.05 mm	V-0	
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	271 to 293	°C
Middle Temperature	282 to 304	°C
Front Temperature	293 to 316	°C
Nozzle Temperature	288 to 310	°C
Processing (Melt) Temp	293 to 316	°C
Mold Temperature	71.1 to 93.3	°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.	Tungsten Electrode	

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