



**LEXAN™ Resin 9915A**  
**Americas: COMMERCIAL**

LEXAN 9915A Polycarbonate (PC) resin is an un-filled, extrusion or injection moldable grade; non-chlorinated, non-brominated flame retardant systems with UL-90 V0 rating @ 1.5mm. It is UV stabilized & available in transparent & tinted color options.

TYPICAL PROPERTIES <sup>1</sup>	TYPICAL VALUE	Unit	Standard
<b>MECHANICAL</b>			
Tensile Stress, yld, Type I, 50 mm/min	650	kgf/cm <sup>2</sup>	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	630	kgf/cm <sup>2</sup>	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	6	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	111	%	ASTM D 638
Tensile Modulus, 50 mm/min	23600	kgf/cm <sup>2</sup>	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	1020	kgf/cm <sup>2</sup>	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	23700	kgf/cm <sup>2</sup>	ASTM D 790
<b>IMPACT</b>			
Izod Impact, unnotched, 23°C	217	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	81	cm-kgf/cm	ASTM D 256
Izod Impact, notched, -30°C	12	cm-kgf/cm	ASTM D 256
Instrumented Impact Energy @ peak, 23°C	764	cm-kgf	ASTM D 3763
<b>THERMAL</b>			
HDT, 0.45 MPa, 3.2 mm, unannealed	142	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	138	°C	ASTM D 648
CTE, -40°C to 95°C, flow	6.8E-05	1/°C	ASTM E 831
CTE, -40°C to 95°C, xflow	6.8E-05	1/°C	ASTM E 831
Vicat Softening Temp, Rate B/120	146	°C	ISO 306
Relative Temp Index, Elec	125	°C	UL 746B
Relative Temp Index, Mech w/impact	115	°C	UL 746B
Relative Temp Index, Mech w/o impact	125	°C	UL 746B
<b>PHYSICAL</b>			
Specific Gravity	1.2	-	ASTM D 792
Density	1.07	g/cm <sup>3</sup>	ASTM D 792

(1) Typical values only. Variations within normal tolerances are possible for various colors. All values are measured after at least 48 hours storage at 23°C/50% relative humidity. All properties, except the melt volume and melt flow rates, are measured on injection molded samples. All samples tested under ISO test standards are prepared according to ISO 294.

(2) Only typical data for selection purposes. Not to be used for part or tool design.

(3) This rating is not intended to reflect hazards presented by this or any other material under actual fire conditions.

(4) Internal measurements according to UL standards.

(5) Measurements made from laboratory test coupon. Actual shrinkage may vary outside of range due to differences in processing conditions, equipment, part geometry and tool design. It is recommended that mold shrinkage studies be performed with surrogate or legacy tooling prior to cutting tools for new molded article.

(6) Needs hard coat to consistently pass 60 sec Vertical Burn.

Source GMD, last updated:

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TYPICAL PROPERTIES <sup>1</sup>	TYPICAL VALUE	Unit	Standard
<b>PHYSICAL</b>			
Mold Shrinkage on Tensile Bar, flow (2) (5)	0.6 - 0.8	%	SABIC Method
Melt Flow Rate, 300°C/1.2 kgf	6.3	g/10 min	ASTM D 1238
<b>ELECTRICAL</b>			
Hot Wire Ignition {PLC}	3	PLC Code	UL 746A
High Ampere Arc Ign, surface {PLC}	1	PLC Code	UL 746A
Comparative Tracking Index (UL) {PLC}	3	PLC Code	UL 746A
<b>FLAME CHARACTERISTICS</b>			
UL Recognized, 94V-0 Flame Class Rating (3)	1.5	mm	UL 94

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(6) Needs hard coat to consistently pass 60 sec Vertical Burn.

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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
<b>Injection Molding</b>		
Drying Temperature	120	°C
Drying Time	3 - 4	hrs
Drying Time (Cumulative)	48	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	280 - 305	°C
Nozzle Temperature	275 - 300	°C
Front - Zone 3 Temperature	280 - 305	°C
Middle - Zone 2 Temperature	270 - 295	°C
Rear - Zone 1 Temperature	260 - 280	°C
Mold Temperature	70 - 95	°C
Back Pressure	0.3 - 0.7	MPa
Screw Speed	40 - 70	rpm
Shot to Cylinder Size	40 - 60	%
Vent Depth	0.025 - 0.076	mm

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