

LEXAN™ 4795R resin

Polyphthalate Carbonate

SABIC Innovative Plastics

Message:

LEXAN 4795R is a high heat resistant poly(ester)carbonate injection molding resin. Flame Retardant.

General Information			
Features	Heat resistance, high Flame retardancy		
RoHS Compliance	RoHS compliance		
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) (330°C/2.16 kg)	15	g/10 min	ASTM D1238
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ¹	2170	MPa	ASTM D638
Tensile Strength ²			ASTM D638
Yield	68.0	MPa	ASTM D638
Fracture	70.0	MPa	ASTM D638
Tensile Elongation ³			ASTM D638
Yield	7.5	%	ASTM D638
Fracture	120	%	ASTM D638
Flexural Modulus ⁴ (50.0 mm Span)	2210	MPa	ASTM D790
Flexural Strength ⁵ (Break, 50.0 mm Span)	105	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	580	J/m	ASTM D256
Unnotched Izod Impact (23°C)	2100	J/m	ASTM D4812
Instrumented Dart Impact			ASTM D3763
23°C, Energy at Peak Load	73.0	J	ASTM D3763
23°C, Total Energy	77.0	J	ASTM D3763
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, unannealed, 3.20mm	160	°C	ASTM D648
1.8 MPa, unannealed, 3.20mm	147	°C	ASTM D648
Vicat Softening Temperature	164	°C	ASTM D1525 ⁶
Ball Pressure Test (125°C)	Pass		IEC 60695-10-2
Injection	Nominal Value	Unit	Test Method
Drying Temperature	121	°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	327 - 349	°C
Middle Temperature	338 - 360	°C
Front Temperature	349 - 371	°C
Nozzle Temperature	343 - 366	°C
Processing (Melt) Temp	349 - 371	°C
Mold Temperature	82.2 - 116	°C
Back Pressure	0.345 - 0.689	MPa
Screw Speed	40 - 70	rpm
Vent Depth	0.025 - 0.076	mm

NOTE

- | | |
|----|---------------------------|
| 1. | 50 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) |

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