

LEXAN™ 915R resin

Polycarbonate

SABIC Innovative Plastics

Message:

LEXAN 915R Polycarbonate (PC) resin is a non-filled, injection moldable grade. This non-chlorinated, non-brominated flame retardant PC has a UL V0 rating with good flow and mold release properties. LEXAN resin 915R is available in various opaque color options and is an excellent candidate for a wide variety of applications.

General Information			
UL YellowCard	E121562-220891		
Additive	Flame Retardant		
Features	Bromine Free		
	Chlorine Free		
	Flame Retardant		
	Good Flow		
	Good Mold Release		
Appearance	Colors Available		
	Opaque		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.20	g/cm³	ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	18	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm)	0.60 to 0.80	%	Internal Method
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ¹	2400	MPa	ASTM D638
Tensile Strength ²			ASTM D638
Yield	63.0	MPa	
Break	62.0	MPa	
Tensile Elongation ³			ASTM D638
Yield	6.0	%	
Break	130	%	
Flexural Modulus ⁴ (50.0 mm Span)	2460	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
Instrumented Dart Impact (23°C, Total Energy)	67.0	J	ASTM D3763
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648

0.45 MPa, Unannealed, 3.20 mm	132	°C	
1.8 MPa, Unannealed, 3.20 mm	123	°C	
Vicat Softening Temperature	138	°C	ASTM D1525 ⁶
CLTE			ASTM E831
Flow : -40 to 40°C	7.4E-5	cm/cm/°C	
Transverse : -40 to 40°C	7.0E-5	cm/cm/°C	
RTI Elec	130	°C	UL 746
RTI Imp	120	°C	UL 746
RTI Str	125	°C	UL 746
Electrical	Nominal Value	Unit	Test Method
Arc Resistance ⁷	PLC 7		ASTM D495
Comparative Tracking Index (CTI)	PLC 3		UL 746
High Amp Arc Ignition (HAI)	PLC 1		UL 746
High Voltage Arc Tracking Rate (HVTR)	PLC 0		UL 746
Hot-wire Ignition (HWI)	PLC 2		UL 746
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
0.800 mm	V-2		
1.09 mm	V-0		
Glow Wire Flammability Index			IEC 60695-2-12
1.00 mm	850	°C	
1.60 mm	960	°C	
Glow Wire Ignition Temperature (0.800 mm)	800	°C	IEC 60695-2-13
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	266 to 288	°C	
Middle Temperature	277 to 299	°C	
Front Temperature	288 to 310	°C	
Nozzle Temperature	282 to 304	°C	
Processing (Melt) Temp	288 to 310	°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.	Rate B (120°C/h), Loading 2 (50 N)
7.	Tungsten Electrode

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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519
Phone: +86 13424755533
Email: sales@su-jiao.com
No. 215, Lianhe North Road, Fengxian District, Shanghai, China

