



LEXAN™ Resin BX9349
Asia Pacific: COMMERCIAL

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

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Modulus, 50 mm/min	25400	kgf/cm ²	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	910	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	22900	kgf/cm ²	ASTM D 790
Tensile Stress, yield, 50 mm/min	65	MPa	ISO 527
Tensile Stress, break, 50 mm/min	50	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	4	%	ISO 527
Tensile Strain, break, 50 mm/min	50	%	ISO 527
IMPACT			
Izod Impact, notched, 23°C	69	cm-kgf/cm	ASTM D 256
Izod Impact, notched, 0°C	56	cm-kgf/cm	ASTM D 256
Instrumented Impact Total Energy, 23°C	662	cm-kgf	ASTM D 3763
THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	106	°C	ASTM D 648
Ball Pressure Test, 75°C +/- 2°C	PASS	-	IEC 60695-10-2
Vicat Softening Temp, Rate B/120	116	°C	ISO 306
Relative Temp Index, Elec	80	°C	UL 746B
Relative Temp Index, Mech w/impact	80	°C	UL 746B
Relative Temp Index, Mech w/o impact	80	°C	UL 746B
PHYSICAL			
Specific Gravity	1.2	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm (5)	0.4 - 0.6	%	SABIC Method
Melt Flow Rate, 260°C/2.16 kgf	9	g/10 min	ASTM D 1238
Density	1.2	g/cm ³	ISO 1183
Water Absorption, (23°C/sat)	0.2	%	ISO 62



(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.

Source GMD, last updated:

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TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
PHYSICAL			
Moisture Absorption (23°C / 50% RH)	0.1	%	ISO 62
FLAME CHARACTERISTICS			
UL Recognized, 94V-2 Flame Class Rating (3)	0.4	mm	UL 94
UL Recognized, 94V-0 Flame Class Rating (3)	0.5	mm	UL 94



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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	80 - 90	°C
Drying Time	2 - 4	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	250 - 300	°C
Nozzle Temperature	250 - 300	°C
Front - Zone 3 Temperature	250 - 300	°C
Middle - Zone 2 Temperature	240 - 290	°C
Rear - Zone 1 Temperature	230 - 280	°C
Hopper Temperature	60 - 80	°C
Mold Temperature	60 - 85	°C
Vent Depth	0.03 - 0.075	mm



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