

# LEXANT™ VISUALFX™ RESIN FXD941A

## DESCRIPTION

LEXAN FXD941A resin is based on Polycarbonate (PC) resin for Extrusion / Blow molding. Added features of this grade include: Diffusion effect and Brominated Flame Retardant. Color package may affect performance.

GENERAL INFORMATION	
Features	Flame Retardant, Aesthetics/Visual effects, Transparent/Translucent
Fillers	Unreinforced
Polymer Types	Polycarbonate (PC)
Processing Techniques	Extrusion Blow Molding

  

INDUSTRY	SUB INDUSTRY
Electrical and Electronics	Mobile Phone - Computer - Tablets, Lighting
Industrial	Electrical

## TYPICAL PROPERTY VALUES

Revision 20241028

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL <sup>(1)</sup>			
Tensile Stress, yld, Type I, 50 mm/min	62	MPa	ASTM D638
Tensile Stress, brk, Type I, 50 mm/min	68	MPa	ASTM D638
Tensile Strain, yld, Type I, 50 mm/min	7	%	ASTM D638
Tensile Strain, brk, Type I, 50 mm/min	120	%	ASTM D638
Tensile Modulus, 50 mm/min	2350	MPa	ASTM D638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	94	MPa	ASTM D790
Flexural Modulus, 1.3 mm/min, 50 mm span	2340	MPa	ASTM D790
IMPACT <sup>(1)</sup>			
Izod Impact, unnotched, 23°C	3204	J/m	ASTM D4812
Izod Impact, notched, 23°C	800	J/m	ASTM D256
Instrumented Dart Impact Total Energy, 23°C	75	J	ASTM D3763
THERMAL <sup>(1)</sup>			
Vicat Softening Temp, Rate B/50	157	°C	ASTM D1525
HDT, 0.45 MPa, 3.2 mm, unannealed	138	°C	ASTM D648
HDT, 1.82 MPa, 3.2mm, unannealed	128	°C	ASTM D648
CTE, -40°C to 40°C, xflow	6.8E-05	1/°C	ASTM E831
Relative Temp Index, Elec <sup>(2)</sup>	130	°C	UL 746B
Relative Temp Index, Mech w/impact <sup>(2)</sup>	120	°C	UL 746B
Relative Temp Index, Mech w/o impact <sup>(2)</sup>	130	°C	UL 746B
PHYSICAL <sup>(1)</sup>			
Specific Gravity	1.2	-	ASTM D792
Mold Shrinkage, flow, 3.2 mm <sup>(3)</sup>	0.5 – 0.7	%	SABIC method
Melt Flow Rate, 300°C/1.2 kgf	10.2	g/10 min	ASTM D1238

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
<b>ELECTRICAL <sup>(2)</sup></b>			
High Voltage Arc Track Rate {PLC}	3	PLC Code	UL 746A
Comparative Tracking Index (UL) {PLC}	2	PLC Code	UL 746A
High Amp Arc Ignition (HAI), PLC 1	≥1.5	mm	UL 746A
High Amp Arc Ignition (HAI), PLC 3	≥3	mm	UL 746A
Hot-Wire Ignition (HWI), PLC 2	≥3	mm	UL 746A
Hot-Wire Ignition (HWI), PLC 3	≥1.5	mm	UL 746A
Arc Resistance, Tungsten {PLC}	7	PLC Code	ASTM D495
<b>FLAME CHARACTERISTICS <sup>(2)</sup></b>			
UL Yellow Card Link	<a href="#">E121562-220936</a>	-	-
UL Yellow Card Link 2	<a href="#">E207780-228424</a>	-	-
UL Yellow Card Link 3	<a href="#">E45329-541345</a>	-	-
UL Recognized, 94V-0 Flame Class Rating	≥3	mm	UL 94
UL Recognized, 94V-2 Flame Class Rating	≥1.5	mm	UL 94
<b>EXTRUSION BLOW MOLDING <sup>(4)</sup></b>			
Drying Temperature	120	°C	
Drying Time	2 – 4	Hrs	
Maximum Moisture Content	0.02	%	
Minimum Moisture Content	0.01	%	
Melt Temperature (Parison)	265 – 280	°C	
Barrel - Zone 1 Temperature	260 – 290	°C	
Barrel - Zone 2 Temperature	260 – 290	°C	
Barrel - Zone 3 Temperature	260 – 290	°C	
Barrel - Zone 4 Temperature	260 – 290	°C	
Adapter - Zone 5 Temperature	260 – 290	°C	
Mold Temperature	60 – 100	°C	

(1) The information stated on Technical Datasheets should be used as indicative only for material selection purposes and not be utilized as specification or used for part or tool design.

(2) UL Ratings shown on the technical datasheet might not cover the full range of thicknesses and colors. For details, please see the UL Yellow Card.

(3) 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.

(4) Extrusion blow Molding parameters are only mentioned as general guidelines.

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