



LEXAN™ Resin 955

Europe-Africa-Middle East: LIMITED USE

LEXAN 955 Polycarbonate (PC) resin is a non-filled, injection moldable grade. This non-chlorinated, non-brominated flame retardant PC has an UL-94 V0 rating and is available in various opaque color options. LEXAN 955 is of high viscosity for various applications.

| TYPICAL PROPERTIES ¹ | TYPICAL VALUE | Unit | Standard |
|---|---------------|-------------------|----------------|
| MECHANICAL | | | |
| Taber Abrasion, CS-17, 1 kg | 10 | mg/1000cy | SABIC Method |
| Tensile Stress, yield, 50 mm/min | 63 | MPa | ISO 527 |
| Tensile Stress, break, 50 mm/min | 60 | MPa | ISO 527 |
| Tensile Strain, yield, 50 mm/min | 6 | % | ISO 527 |
| Tensile Strain, break, 50 mm/min | 85 | % | ISO 527 |
| Tensile Modulus, 1 mm/min | 2300 | MPa | ISO 527 |
| Flexural Stress, yield, 2 mm/min | 90 | MPa | ISO 178 |
| Flexural Modulus, 2 mm/min | 2300 | MPa | ISO 178 |
| Hardness, H358/30 | 95 | MPa | ISO 2039-1 |
| IMPACT | | | |
| Izod Impact, unnotched 80*10*3 +23°C | NB | kJ/m ² | ISO 180/1U |
| Izod Impact, unnotched 80*10*3 -30°C | NB | kJ/m ² | ISO 180/1U |
| Izod Impact, notched 80*10*3 +23°C | 70 | kJ/m ² | ISO 180/1A |
| Izod Impact, notched 80*10*3 -30°C | 12 | kJ/m ² | ISO 180/1A |
| Charpy 23°C, V-notch Edgew 80*10*3 sp=62mm | 75 | kJ/m ² | ISO 179/1eA |
| Charpy -30°C, V-notch Edgew 80*10*3 sp=62mm | 14 | kJ/m ² | ISO 179/1eA |
| Charpy 23°C, Unnotch Edgew 80*10*3 sp=62mm | NB | kJ/m ² | ISO 179/1eU |
| Charpy -30°C, Unnotch Edgew 80*10*3 sp=62mm | NB | kJ/m ² | ISO 179/1eU |
| THERMAL | | | |
| Thermal Conductivity | 0.2 | W/m-°C | ISO 8302 |
| CTE, 23°C to 80°C, flow | 7.E-05 | 1/°C | ISO 11359-2 |
| Ball Pressure Test, 125°C +/- 2°C | PASSES | - | IEC 60695-10-2 |
| Ball Pressure Test, approximate maximum | 140 | °C | IEC 60695-10-2 |

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 (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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| THERMAL | | | |
| Vicat Softening Temp, Rate A/50 | 150 | °C | ISO 306 |
| Vicat Softening Temp, Rate B/50 | 141 | °C | ISO 306 |
| Vicat Softening Temp, Rate B/120 | 142 | °C | ISO 306 |
| HDT/Be, 0.45MPa Edgew 120*10*4 sp=100mm | 136 | °C | ISO 75/Be |
| HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm | 125 | °C | ISO 75/Ae |
| Relative Temp Index, Elec | 130 | °C | UL 746B |
| Relative Temp Index, Mech w/impact | 120 | °C | UL 746B |
| Relative Temp Index, Mech w/o impact | 125 | °C | UL 746B |
| PHYSICAL | | | |
| Mold Shrinkage on Tensile Bar, flow (2) (5) | 0.5 - 0.7 | % | SABIC Method |
| Density | 1.2 | g/cm ³ | ISO 1183 |
| Water Absorption, (23°C/sat) | 0.35 | % | ISO 62 |
| Moisture Absorption (23°C / 50% RH) | 0.15 | % | ISO 62 |
| Melt Volume Rate, MVR at 300°C/1.2 kg | 7 | cm ³ /10 min | ISO 1133 |
| ELECTRICAL | | | |
| Volume Resistivity | >1.E+15 | Ohm-cm | IEC 60093 |
| Surface Resistivity, ROA | >1.E+15 | Ohm | IEC 60093 |
| Dielectric Strength, shorttime, 1.0mm | 17 | kV/mm | IEC 60243-1 |
| Dielectric Strength, in oil, 3.2 mm | 17 | kV/mm | IEC 60243-1 |
| Relative Permittivity, 1 MHz | 2.7 | - | IEC 60250 |
| Dissipation Factor, 50/60 Hz | 0.001 | - | IEC 60250 |
| Dissipation Factor, 1 MHz | 0.01 | - | IEC 60250 |
| Comparative Tracking Index | 225 | V | IEC 60112 |
| Relative Permittivity, 50/60 Hz | 2.7 | - | IEC 60250 |
| FLAME CHARACTERISTICS | | | |
| 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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| TYPICAL PROPERTIES ¹ | TYPICAL VALUE | Unit | Standard |
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| FLAME CHARACTERISTICS | | | |
| UL Recognized, 94-5VA Rating (3) | 3 | mm | UL 94 |
| Glow Wire Flammability Index 960°C, passes at | 1 | mm | IEC 60695-2-12 |
| Glow Wire Ignitability Temperature, 1.0 mm | 850 | °C | IEC 60695-2-13 |
| Oxygen Index (LOI) | 35 | % | ISO 4589 |

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| PROCESSING PARAMETERS | TYPICAL VALUE | Unit |
|-----------------------------|---------------|------|
| Injection Molding | | |
| Drying Temperature | 120 | °C |
| Drying Time | 2 - 4 | hrs |
| Maximum Moisture Content | 0.02 | % |
| Melt Temperature | 290 - 320 | °C |
| Nozzle Temperature | 280 - 310 | °C |
| Front - Zone 3 Temperature | 290 - 320 | °C |
| Middle - Zone 2 Temperature | 280 - 310 | °C |
| Rear - Zone 1 Temperature | 270 - 300 | °C |
| Hopper Temperature | 60 - 80 | °C |
| Mold Temperature | 80 - 120 | °C |

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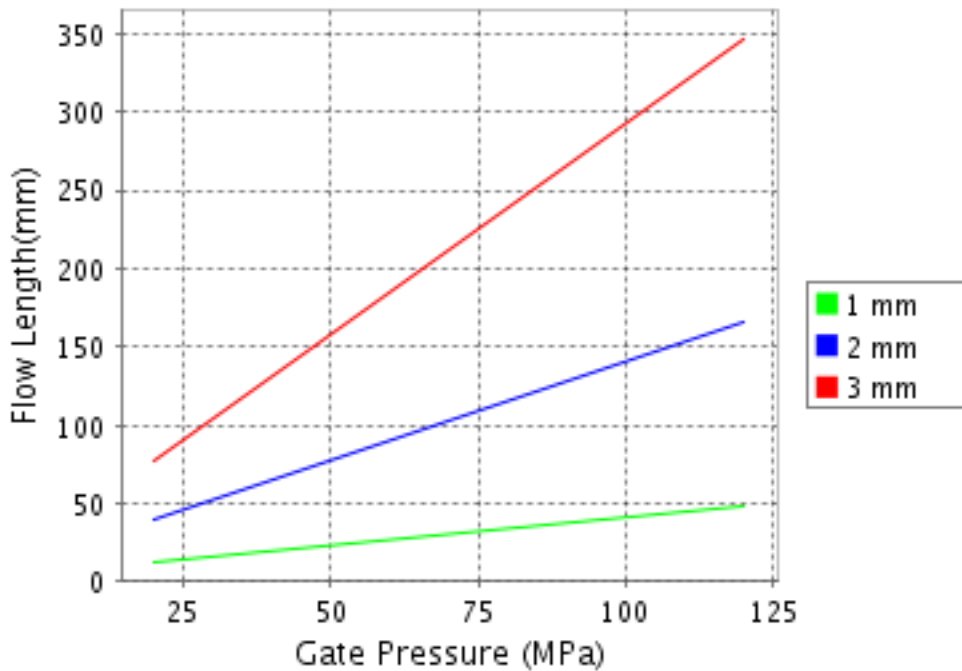
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CALCULATED FLOW LENGTH INDICATION
Moldflow® Radial Flow Analysis
LEXAN® 955
Melt Temperature : 290°C
Mold Temperature : 90°C



Note: Technical support is recommended if Gate Pressure is greater than 80 MPa. Contact your local representative.
® Moldflow is a registered trademark of the Moldflow Corporation.

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