

Lexan* Resin FL913

Americas: COMMERCIAL

Various weight reduction at 0.250" (6.35 mm) wall. 10% GR, high flexural strength/modulus. UL rated V-0/5VA (all except natural). UV-stabilized.

Property

TYPICAL PROPERTIES ⁽¹⁾			
MECHANICAL	Value	Unit	Standard
FOAM - MECHANICAL 6.4 mm Wt Reduction	10	%	-
Tensile Stress, yield, 6.35 mm	52	MPa	ASTM D 638
Tensile Strain, break, 6.35 mm	4.8	%	ASTM D 638
Tensile Modulus, 6.4 mm	3170	MPa	ASTM D 638
Flexural Stress, yield, 6.4 mm	89	MPa	ASTM D 790
Flexural Modulus, 6.4 mm	3510	MPa	ASTM D 790
IMPACT	Value	Unit	Standard
FOAM - IMPACT 6.4 mm Wt Reduction	10	%	-
Izod Impact, unnotched, 23°C	854	J/m	ASTM D 4812
THERMAL	Value	Unit	Standard
FOAM - THERMAL 6.4mm Wt Reduction	10	%	-
HDT, 0.45 MPa, 6.4 mm, unannealed	140	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	133	°C	ASTM D 648
CTE, -40°C to 95°C, flow	3.24E-05	1/°C	ASTM E 831
Specific Heat	1.19	J/g-°C	ASTM C 351
Thermal Conductivity	0.13	W/m-°C	ASTM C 177
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	Value	Unit	Standard
FOAM - PHYSICAL 6.4mm Wt Reduction	10	%	-
Specific Gravity	1.25	-	ASTM D 792
Specific Gravity, foam molded	1.12	-	ASTM D 792
Water Absorption, 24 hours	0.16	%	ASTM D 570
Water Absorption, equilibrium, 23C	0.32	%	ASTM D 570
Mold Shrinkage, flow, 6.4 mm	0.4 - 0.6	%	SABIC Method
FLAME CHARACTERISTICS	Value	Unit	Standard
FOAM - Flame Class Minimum Density	0.97	g/cm ³	-
UL Recognized, 94V-0 Flame Class Rating (3)	3.86	mm	UL 94
UL Recognized, 94-5VA Rating (3)	3.86	mm	UL 94
UV-light, water exposure/immersion	F1	-	UL 746C

Source GMD, last updated:02/22/1993

Processing

Parameter	Value	Unit
Structural Foam Molding		
Blowing Agent, Physical System	Nitrogen	-
Blowing Agent, Chemical System	FLC95	-

Drying Time (Blowing Agent)	4	hrs
Drying Temperature (Blowing Agent)	105	°C
Concentration Range (Blowing Agent)	3 - 5	%
Recommended Concentration (Blowing Agent)	1.5	%
Drying Temperature (Resin)	120	°C
Drying Time (Resin)	3 - 4	hrs
Drying Time (Resin, Cumulative)	48	hrs
Melt Temperature	290 - 315	°C
Nozzle Temperature	270 - 295	°C
Front Temperature	295 - 310	°C
Middle Temperature	295 - 310	°C
Rear Temperature	255 - 265	°C
Mold Temperature	70 - 95	°C

Source GMD, last updated:02/22/1993

THESE PROPERTY VALUES ARE NOT INTENDED FOR SPECIFICATION PURPOSES.

PLEASE CHECK WITH YOUR [\(LOCAL SALES OFFICE\)](#) FOR AVAILABILITY IN YOUR REGION

(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.

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