

LEXAN[™] FR RESINS 915R

REGION ASIA

DESCRIPTION

LEXAN 915R Polycarbonate (PC) is an injection moldable non-chlorinated and non-brominated, unfilled flame retardant grade with medium/high flow and good release. It has an MVR of 18 (300°C/1.2kg) and a UL94 VO@1.1mm, and is available in various opaque color options.

INDUSTRY	SUB INDUSTRY
Automotive	Automotive Exteriors, Aerospace
Building and Construction	Construction
Consumer	Home Appliance, Personal Recreation, Recreational Vehicle
Electrical and Electronics	Electrical Devices and Displays, Lighting, Electrical Components and Infrastructure
Healthcare	Patient Testing
Mass Transportation	Specialty Vehicles, Rail

TYPICAL PROPERTY VALUES

Revision 20190717

MECHANICAL Tensile Stress, yld, Type I, 50 mm/min 63 MPa ASTM D 638 Tensile Stress, brk, Type I, 50 mm/min 62 MPa ASTM D 638 Tensile Strain, brk, Type I, 50 mm/min 130 % ASTM D 638 Tensile Strain, brk, Type I, 50 mm/min 2400 MPa ASTM D 638 Tensile Modulus, 50 mm/min 2400 MPa ASTM D 790 Flexural Stress, yld, 1.3 mm/min, 50 mm span 2460 MPa ASTM D 790 Hardness, Rockwell M 70 - ASTM D 785 Hardness, Rockwell R 747 J/m ASTM D 256 Instrumented Impact, Total Energy, 23°C 747 J/m ASTM D 3763 Instrumented Impact, Packe B/50 18 J/m ASTM D 4812 THERNAL V ASTM D 4812 Tensile Stress, packe B/S HDT, 0.45 MPa, 3.2 mm, unannealed 132 °C ASTM D 648 HDT, 1.82 MPa, 3.2 mm, unannealed 123 °C ASTM D 648 HDT, 0.45 MPa, 3.2 mm, unannealed 123 °C ASTM D 648 CE, 40°C to 40°C, tilow<	PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Tensile Stress, brk, Type I, 50 mm/min 62 MPa ASTM D 638 Tensile Strain, yld, Type I, 50 mm/min 130 % ASTM D 638 Tensile Strain, brk, Type I, 50 mm/min 2400 MPa ASTM D 638 Flexural Stress, yld, 1.3 mm/min, 50 mm span 93 MPa ASTM D 790 Flexural Modulus, 1.3 mm/min, 50 mm span 2460 MPa ASTM D 785 Hardness, Rockwell M 70 ASTM D 785 ASTM D 785 Hardness, Rockwell R 118 2 ASTM D 785 Impact 17 ASTM D 785 ASTM D 785 Instrumented Impact Total Energy, 23°C 747 J/m ASTM D 256 Instrumented Impact Total Energy, 23°C 747 J/m ASTM D 4812 IterMAL J/m ASTM D 4812 ASTM D 4812 THERMAL Vicas Softening Temp, Rate B/50 138 °C ASTM D 648 HDT, 0.45 MPa, 3.2 mm, unannealed 132 °C ASTM D 648 HDT, 1.22 MPa, 3.2 mm, unannealed 123 °C ASTM E 811 CTE, 40°C to 40°C, 1600 700E-005	MECHANICAL			
Tensile Strain, yld, Type I, 50 mm/min 6 % ASTM D 638 Tensile Strain, brk, Type I, 50 mm/min 130 % ASTM D 638 Tensile Modulus, 50 mm/min 2400 MPa ASTM D 638 Flexural Stress, yld, 1.3 mm/min, 50 mm span 93 MPa ASTM D 790 Hardness, Rockwell M 70 - ASTM D 785 Hardness, Rockwell R 118 - ASTM D 785 IMPACT J/m ASTM D 256 Instrumented Impact Total Energy, 23°C 747 J/m ASTM D 481 Izod Impact, unnotched, 23°C 747 J/m ASTM D 481 Ital Modulus, unnotched, 23°C 747 J/m ASTM D 481 Izod Impact, unnotched, 23°C 747 J/m ASTM D 481 HDT, 0.45 MPa, 3.2 mm, unannealed 138 °C ASTM D 1525 HDT, 0.45 MPa, 3.2 mm, unannealed 123 °C ASTM D 648 CTE, 40°C to 40°C, filow 7.38€-05 1/l°C ASTM E 831 CTE, 40°C to 40°C, filow 7.02€-05 1/l°C ASTM C 177 Specifi	Tensile Stress, yld, Type I, 50 mm/min	63	MPa	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min 130 % ASTM D 638 Tensile Modulus, 50 mm/min 2400 MPa ASTM D 638 Flexural Stress, yld, 1.3 mm/min, 50 mm span 93 MPa ASTM D 790 Flexural Modulus, 1.3 mm/min, 50 mm span 2460 MPa ASTM D 790 Hardness, Rockwell M 70 - ASTM D 785 Hardness, Rockwell R 118 - ASTM D 785 IMPACT J/m ASTM D 256 Instrumented Impact Total Energy, 23°C 67 J/m ASTM D 3763 Izod Impact, unnotched, 23°C NB J/m ASTM D 4812 THERMAL J/m ASTM D 4812 ASTM D 4812 HDT, 0.45 MPa, 3.2 mm, unannealed 132 °C ASTM D 1525 HDT, 1.45 MPa, 3.2 mm, unannealed 123 °C ASTM D 648 GTE, 40°C to 40°C, filow 7.38E-05 1/°C ASTM E 831 GTE, 40°C to 40°C, filow 7.02E-05 1/°C ASTM C 177 Specific Heat 1.25 J/g°C ASTM C 177 Specific Heat	Tensile Stress, brk, Type I, 50 mm/min	62	MPa	ASTM D 638
Tensile Modulus, 50 mm/min 2400 MPa ASTM D 638 Flexural Stress, yld, 1.3 mm/min, 50 mm span 93 MPa ASTM D 790 Flexural Modulus, 1.3 mm/min, 50 mm span 2460 MPa ASTM D 790 Hardness, Rockwell M 70 - ASTM D 785 Hardness, Rockwell R 118 - ASTM D 785 IMPACT J/m ASTM D 256 Instrumented Impact, notched, 23°C 747 J/m ASTM D 3763 Izod Impact, unnotched, 23°C 78 J/m ASTM D 4812 THERMAL Vicat Softening Temp, Rate B/50 138 °C ASTM D 4812 HDT, 0.45 MPa, 3.2 mm, unannealed 132 °C ASTM D 648 HDT, 1.82 MPa, 3.2 mm, unannealed 123 °C ASTM D 648 CTE, -40°C to 40°C, filow 7.02E-05 1/°C ASTM E 831 CTE, 40°C to 40°C, xflow 7.02E-05 1/°C ASTM E 831 Thermal Conductivity 0.2 W/m.°C ASTM C 351 Specific Heat 1.25 1/ge* ASTM C 351 Rel	Tensile Strain, yld, Type I, 50 mm/min	6	%	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span 93 MPa ASTM D 790 Flexural Modulus, 1.3 mm/min, 50 mm span 2460 MPa ASTM D 785 Hardness, Rockwell M 70 - ASTM D 785 Hardness, Rockwell R 118 - ASTM D 785 IMPACT J/m ASTM D 256 Instrumented Impact, notched, 23°C 747 J/m ASTM D 3763 Izod Impact, unnotched, 23°C NB J/m ASTM D 4812 THERMAL J/m ASTM D 4812 ASTM D 4812 HDT, 0.45 MPa, 3.2 mm, unannealed 138 °C ASTM D 648 HDT, 1.82 MPa, 3.2 mm, unannealed 123 °C ASTM D 648 HDT, 1.82 MPa, 3.2 mm, unannealed 123 °C ASTM D 648 CTE, -40°C to 40°C, flow 7.02E-05 1/°C ASTM E 831 CTE, -40°C to 40°C, xflow 7.02E-05 1/°C ASTM C 351 Thermal Conductivity 0.2 W/m.°C ASTM C 351 Specific Heat 1.25 M/m.°C ASTM C 351 Relative Temp Index, Mech w/impact <td>Tensile Strain, brk, Type I, 50 mm/min</td> <td>130</td> <td>%</td> <td>ASTM D 638</td>	Tensile Strain, brk, Type I, 50 mm/min	130	%	ASTM D 638
Flexural Modulus, 1.3 mm/min, 50 mm span 2460 MPa ASTM D 790 Hardness, Rockwell M 70 . ASTM D 785 Hardness, Rockwell R 118 . ASTM D 785 IMPACT Impact Total Energy, 23°C 747 J/m ASTM D 256 Instrumented Impact Total Energy, 23°C 67 J/m ASTM D 3763 Izod Impact, unnotched, 23°C NB J/m ASTM D 4812 THERMAL Vicat Softening Temp, Rate B/50 138 °C ASTM D 648 HDT, 0.45 MPa, 3.2 mm, unannealed 123 °C ASTM D 648 HDT, 1.82 MPa, 3.2 mm, unannealed 123 °C ASTM D 648 CTE, -40°C to 40°C, flow 7.02E-05 1/°C ASTM E 831 CTE, -40°C to 40°C, flow 7.02E-05 1/°C ASTM C 351 Thermal Conductivity 0.2 W/m °C ASTM C 351 Specific Heat 1.25 1/g °C ASTM C 351 Relative Temp Index, Elec 130 °C U1 7468	Tensile Modulus, 50 mm/min	2400	MPa	ASTM D 638
Hardness, Rockwell M 70 - ASTM D 785 Hardness, Rockwell R 118 - ASTM D 785 IMPACT Impact Total Energy, 23°C 747 J/m ASTM D 256 Instrumented Impact Total Energy, 23°C 67 J m ASTM D 3763 Izod Impact, unnotched, 23°C NB J/m ASTM D 4812 THERMAL Vicat Softening Temp, Rate B/50 138 °C ASTM D 1525 HDT, 0.45 MPa, 3.2 mm, unannealed 132 °C ASTM D 648 HDT, 1.82 MPa, 3.2 mm, unannealed 123 °C ASTM D 648 CTE, -40°C to 40°C, flow 7.38E-05 1/°C ASTM E 81 CTE, 40°C to 40°C, xflow 7.02E-05 1/°C ASTM E 81 CTE, 40°C to 40°C, xflow 7.02E-05 1/°C ASTM C 351 Thermal Conductivity 0.2 W/m·°C ASTM C 351 Specific Heat 1.25 1/g °C ASTM C 351 Relative Temp Index, Elec 120 °C UL 746B	Flexural Stress, yld, 1.3 mm/min, 50 mm span	93	MPa	ASTM D 790
Hardness, Rockwell R 118 - ○ ASTM D 785 IMPACT Impact, notched, 23°C 747 J/m ASTM D 256 Instrumented Impact Total Energy, 23°C 67 J m ASTM D 3763 Izod Impact, unnotched, 23°C NB J/m ASTM D 4812 THERMAL Vicat Softening Temp, Rate B/50 138 °C ASTM D 1525 HDT, 0.45 MPa, 3.2 mm, unannealed 132 °C ASTM D 648 HDT, 1.82 MPa, 3.2mm, unannealed 123 °C ASTM D 648 CTE, -40°C to 40°C, flow 7.38E·05 1/°C ASTM E 831 CTE, -40°C to 40°C, xflow 7.02E·05 1/°C ASTM C 3T Thermal Conductivity 0.2 W/m·°C ASTM C 3T Specific Heat 1.25 J/g °C ASTM C 351 Relative Temp Index, Elec 130 °C U. 7468 Relative Temp Index, Mech w/impact 120 °C U. 7468	Flexural Modulus, 1.3 mm/min, 50 mm span	2460	MPa	ASTM D 790
IMPACT Izod Impact, notched, 23°C 747 J/m ASTM D 256 Instrumented Impact Total Energy, 23°C 67 J ASTM D 3763 Izod Impact, unnotched, 23°C NB J/m ASTM D 4812 THERMAL Vicat Softening Temp, Rate B/50 138 °C ASTM D 1525 HDT, 0.45 MPa, 3.2 mm, unannealed 132 °C ASTM D 648 HDT, 1.82 MPa, 3.2mm, unannealed 123 °C ASTM D 648 CTE, -40°C to 40°C, flow 7.38E-05 1/°C ASTM E 831 CTE, -40°C to 40°C, xflow 7.02E-05 1/°C ASTM E 81 Thermal Conductivity 0.2 W/m.°C ASTM C 177 Specific Heat 1.25 J/g.°C ASTM C 351 Relative Temp Index, Elec 130 °C U.1746B Relative Temp Index, Mech w/impact 120 °C U.1746B	Hardness, Rockwell M	70	-	ASTM D 785
Izod Impact, notched, 23°C 747 J/m ASTM D 256 Instrumented Impact Total Energy, 23°C 67 J ASTM D 3763 Izod Impact, unnotched, 23°C NB J/m ASTM D 4812 THERMAL Vicat Softening Temp, Rate B/50 138 °C ASTM D 1525 HDT, 0.45 MPa, 3.2 mm, unannealed 132 °C ASTM D 648 HDT, 1.82 MPa, 3.2 mm, unannealed 123 °C ASTM D 648 CTE, -40°C to 40°C, flow 7.38E-05 1/°C ASTM E 831 CTE, -40°C to 40°C, xflow 7.02E-05 1/°C ASTM E 831 Thermal Conductivity 0.2 W/m.°C ASTM C 351 Specific Heat 1.25 J/g.°C ASTM C 351 Relative Temp Index, Elec 130 °C UL 746B	Hardness, Rockwell R	118	-	ASTM D 785
Instrumented Impact Total Energy, 23°C 67 J ASTM D 3763 Izod Impact, unnotched, 23°C NB J/m ASTM D 4812 THERMAL Vicat Softening Temp, Rate B/50 138 °C ASTM D 1525 HDT, 0.45 MPa, 3.2 mm, unannealed 132 °C ASTM D 648 HDT, 1.82 MPa, 3.2 mm, unannealed 123 °C ASTM D 648 CTE, -40°C to 40°C, flow 7.38E-05 1/°C ASTM E 831 CTE, 40°C to 40°C, xflow 7.02E-05 1/°C ASTM E 831 Thermal Conductivity 0.2 W/m·°C ASTM C177 Specific Heat 1.25 J/g·°C ASTM C351 Relative Temp Index, Elec 130 °C UL 746B Relative Temp Index, Mech w/impact 120 °C UL 746B	IMPACT			
Izod Impact, unnotched, 23°C NB J/m ASTM D 4812 THERMAL Vicat Softening Temp, Rate B/50 138 °C ASTM D 1525 HDT, 0.45 MPa, 3.2 mm, unannealed 132 °C ASTM D 648 HDT, 1.82 MPa, 3.2mm, unannealed 123 °C ASTM D 648 CTE, -40°C to 40°C, flow 7.38E-05 1/°C ASTM E 831 CTE, -40°C to 40°C, xflow 7.02E-05 1/°C ASTM E 831 Thermal Conductivity 0.2 W/m.°C ASTM C 177 Specific Heat 1.25 J/g.°C ASTM C 351 Relative Temp Index, Elec 130 °C UL 746B Relative Temp Index, Mech w/impact 120 °C UL 746B	Izod Impact, notched, 23°C	747	J/m	ASTM D 256
THERMAL Vicat Softening Temp, Rate B/50 138 °C ASTM D 1525 HDT, 0.45 MPa, 3.2 mm, unannealed 132 °C ASTM D 648 HDT, 1.82 MPa, 3.2mm, unannealed 123 °C ASTM D 648 CTE, -40°C to 40°C, flow 7.38E-05 1/°C ASTM E 831 CTE, -40°C to 40°C, xflow 7.02E-05 1/°C ASTM E 831 Thermal Conductivity 0.2 W/m·°C ASTM C177 Specific Heat 1.25 J/g·°C ASTM C 351 Relative Temp Index, Elec 130 °C UL 746B Relative Temp Index, Mech w/impact 120 °C UL 746B	Instrumented Impact Total Energy, 23°C	67	J	ASTM D 3763
Vicat Softening Temp, Rate B/50 138 °C ASTM D 1525 HDT, 0.45 MPa, 3.2 mm, unannealed 132 °C ASTM D 648 HDT, 1.82 MPa, 3.2mm, unannealed 123 °C ASTM D 648 CTE, -40°C to 40°C, flow 7.38E-05 1/°C ASTM E 831 CTE, -40°C to 40°C, xflow 7.02E-05 1/°C ASTM E 831 Thermal Conductivity 0.2 W/m·°C ASTM C 177 Specific Heat 1.25 J/g·°C ASTM C 351 Relative Temp Index, Elec 130 °C UL 746B Relative Temp Index, Mech w/impact 120 °C UL 746B	Izod Impact, unnotched, 23°C	NB	J/m	ASTM D 4812
HDT, 0.45 MPa, 3.2 mm, unannealed 132 °C ASTM D 648 HDT, 1.82 MPa, 3.2mm, unannealed 123 °C ASTM D 648 CTE, -40°C to 40°C, flow 7.38E-05 1/°C ASTM E 831 CTE, -40°C to 40°C, xflow 7.02E-05 1/°C ASTM E 831 Thermal Conductivity 0.2 W/m·°C ASTM C 177 Specific Heat 1.25 J/g·°C ASTM C 351 Relative Temp Index, Elec 130 °C UL 746B Relative Temp Index, Mech w/impact 120 °C UL 746B	THERMAL			
HDT, 1.82 MPa, 3.2mm, unannealed 123 °C ASTM D 648 CTE, -40°C to 40°C, flow 7.38E-05 1/°C ASTM E 831 CTE, -40°C to 40°C, xflow 7.02E-05 1/°C ASTM E 831 Thermal Conductivity 0.2 W/m°C ASTM C177 Specific Heat 1.25 J/g-°C ASTM C 351 Relative Temp Index, Elec 130 °C UL 746B Relative Temp Index, Mech w/impact 120 °C UL 746B	Vicat Softening Temp, Rate B/50	138	°C	ASTM D 1525
CTE, -40°C to 40°C, flow 7.38E-05 1/°C ASTM E 831 CTE, -40°C to 40°C, xflow 7.02E-05 1/°C ASTM E 831 Thermal Conductivity 0.2 W/m-°C ASTM C177 Specific Heat 1.25 J/g-°C ASTM C 351 Relative Temp Index, Elec 130 °C UL 746B Relative Temp Index, Mech w/impact 120 °C UL 746B	HDT, 0.45 MPa, 3.2 mm, unannealed	132	°C	ASTM D 648
CTE, -40°C to 40°C, xflow 7.02E-05 1/°C ASTM E 831 Thermal Conductivity 0.2 W/m·°C ASTM C177 Specific Heat 1.25 J/g·°C ASTM C 351 Relative Temp Index, Elec 130 °C UL 746B Relative Temp Index, Mech w/impact 120 °C UL 746B	HDT, 1.82 MPa, 3.2mm, unannealed	123	°C	ASTM D 648
Thermal Conductivity 0.2 W/m-°C ASTM C177 Specific Heat 1.25 J/g-°C ASTM C 351 Relative Temp Index, Elec 130 °C UL 746B Relative Temp Index, Mech w/impact 120 °C UL 746B	CTE, -40°C to 40°C, flow	7.38E-05	1/°C	ASTM E 831
Specific Heat 1.25 J/g-°C ASTM C 351 Relative Temp Index, Elec 130 °C UL 746B Relative Temp Index, Mech w/impact 120 °C UL 746B	CTE, -40°C to 40°C, xflow	7.02E-05	1/°C	ASTM E 831
Relative Temp Index, Elec 130 °C UL 746B Relative Temp Index, Mech w/impact 120 °C UL 746B	Thermal Conductivity	0.2	W/m-°C	ASTM C177
Relative Temp Index, Mech w/impact 120 °C UL 746B	Specific Heat	1.25	J/g-°C	ASTM C 351
	Relative Temp Index, Elec	130	°C	UL 746B
Relative Temp Index, Mech w/o impact 125 °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	PHYSICAL			



PROFERTIES TYPICAL VALUES UNITS TEST METHODS Specific Gravity 1.2				
Moisture Absorption, 24 hours 0.15 % MSTM D 570 Water Absorption, 24 hours 0.15 % MSTM D 570 Water Absorption, 24 hours 0.6 − 0.8 % MSTM D 570 Water Absorption, 24 hours 6.6 − 0.8 % MSTM D 570 Water Absorption, 24 mours 6.6 − 0.8 % MSTM D 570 Mold Shrinkage, flow, 3.2 mm 6.6 − 0.8 % MSTM D 1728 Mold Shrinkage, flow, 3.2 mm 8.7 MSTM D 570 ASTM D 1728 Ble Flow Rate, 300°C/ 1.2 kgf 8 7 MSTM D 1728 ELECTRICA **** **** **** ELECTRICA 7 PLC Code MSTM D 495 High Voltage Are Track Rate [PLC] 9 PLC Code U.7 46A High More Are Ign, surface (PLC) 1 9 PLC Code U.7 46A High Ampere Are Ign, surface (PLC) 1 9 PLC Code U.7 46A Use How Card Link \$200 9 Code U.7 46A Use How Card Link \$200 9 Code U.7 46A Use How Card Link \$200	PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Water Absorption, 24 hours 9.16 ASTM D 570 Water Absorption, equilibrium, 23C 9.6 ASTM D 570 Mold Shrindage, flow, 3.2 mm 16 6.9 8 ASTM D 178 Mell Flow Rato, 3.2 mm 18 9.10 mm MTD 128 Bull Flow Rato, 30°C/1.2 kg 18 9.10 mm MTD 128 Bull Flow Rato, 10°C/1.2 kg 18 9.10 mm MTD 128 EUCTRICA V V V ASTM D 495 Hot Wire Injudicy (PLC) 2 C Code LA 746A High Amper Ar Ign, surface (PLC) 1 1 C C C C High Amper Are Ign, surface (PLC) 2 1 C	Specific Gravity	1.2	-	ASTM D 792
Water Absorption, equilibrium, 23C 0.5 45M D5 70 (method) ASM D5 70 (method) Mod Shrinkage, flow, 3.2 mm 0.6 − 0.8 9 (method) ASIM D1238 (method) Met Row Rate, 300°C/1.2 kgf 18 20 (method) ASIM D1238 (method) ELECTRICAL VEX. ASIM D495 ASIM D495 Hot Wire Ignition (PLC) 2 Code MID 406 ASIM D495 High Ampere Arc Ign, surface (PLC) 0 Code U.746A ASIM D495 High Ampere Arc Ign, surface (PLC) 2 0 Code U.746A ASIM D495 Chomparate Tracking Index (U) (PLC) 3 0 Code U.746A ASIM D495 EMBLY AMERICAN (LIC) 2 Code U.746A ASIM D495 <	Moisture Absorption, 50% RH, 24 hrs	0.15	%	ASTM D 570
Mold Shrinkage, flow, 3.2 mm 0.6 – 0.8 % ABIC method Melt Flow Rate, 300°C/1.2 kgf 18 9.10 min ASTM D1238 ELECTICAL FLOR Total Statinger, PlC) 7 PLC Code ATM D495 Brigh Voltage Arc Track Rate (PLC) 2 PLC Code U.7 46A High Ampere Arc Ign, surface (PLC) 1 2 U.7 60 U.7 46A Comparative Tracking Index (UI) (PLC) 3 2 U.7 60 U.7 46A Comparative Tracking Index (UI) (PLC) 3 0 PLC Code U.7 46A Comparative Tracking Index (UI) (PLC) 3 2 Code U.7 46A Comparative Tracking Index (UI) (PLC) 3 2 Code U.7 46A Comparative Tracking Index (UI) (PLC) 3 2 Code U.7 46A Law (Sangara Face) (PLC) 4 Code	Water Absorption, 24 hours	0.15	%	ASTM D 570
Melt Flow Rate, 30°C/1.2 kgf 8 910 min ASM D1238 ELECTRICA. Arc Resistance, Tungsten (PLC) 7 AC Code ASTM D495 Hot Wire Ignition (PLC) 2 PLC Code U.7 46A High Amper Arc Ign, surface (PLC) 9 PLC Code U.7 46A High Amper Arc Ign, surface (PLC) 1 PLC Code U.7 46A Comparative Tracking Index (UI) (PLC) 3 PLC Code U.7 46A ELM CHARACTERISTICS U.9 U.9 PLC Code U.9 4 Use Conglized, 940-9 flame Class Rating 1 Man PLC Code U.9 4 GLOW Wire Flammability Index 850°C, passes at 1 1 Min EC 60695-21 Glow Wire Ignitability Temperature, 0.8 mm 80 2 EC 60695-21 Code Drying Time 2 2 Code EC 60695-21 Code	Water Absorption, equilibrium, 23C	0.35	%	ASTM D 570
ELECTRICAL Arc Resistance, Tungsten (PLC) 7 Arc Resistance, Tungsten (PLC) 7 Bigh Arottge (RTC) 8 Bigh Arottge, Kata (Re (PLC) 8 Bigh Ampere Arc Inack Rate (PLC) 9 Big	Mold Shrinkage, flow, 3.2 mm	0.6 - 0.8	%	SABIC method
Arc Resistance, Tungsten (PLC) 7 PLC Ode ASTM D495 Hot Wire Ignition (PLC) 2 PLC Ode U.746A High Namper Arc Track Rate (PLC) 0 PLC Ode U.746A High Ampere Arc Ign, surface (PLC) 1 PLC Ode U.746A Comparative Tracking Index (Ut) (PLC) 3 U.74C U.74C EMBE CHARC TERISTICS V V U.74C Use Plance Gass Rating 5 U.74C U.74C Use Wire Flammability Index 850°C, passes at 1 mm U.24C U.74C Glow Wire Flammability Index 960°C, passes at 1 mm U.74C U.7	Melt Flow Rate, 300°C/1.2 kgf	18	g/10 min	ASTM D 1238
Hot Wire Ignition (PLC) 2 PLC Code U. 746A High Voltage Arc Track Rate (PLC) 0 PLC Code U. 746A High Ampere Arc Ign, surface (PLC) 1 PLC Code U. 746A Comparative Tracking Index (UI) (PLC) 3 PLC Code U. 746A ELAMEACTERISTICS V V V UL Recognized, 94V-0 Flame Class Rating 1 mm U. 94 Glow Wire Flammability Index 850°C, passes at 1 mm EC 60695-212 Glow Wire Flammability Index 950°C, passes at 1 mm EC 60695-212 Glow Wire Ignitability Temperature, 0.8 mm 10 C C C BOYLON MOLDING V C	ELECTRICAL			
High Voltage Arc Track Rate (PLC)0PC CodeU. 746AHigh Ampere Arc Ign, surface (PLC)1PC CodeU. 746AComparative Tracking Index (UL) (PLC)3PC CodeU. 746AFAME CHARACTERISTICSU. Vellow Card LinkE207780-228400U. Recognized, 94V-0 Flame Class Rating1mmU. 94Glow Wire Flammability Index 850°C, passes at1mmU. 560695-212Glow Wire Ignamability Index 960°C, passes at1mmU. 560695-212Glow Wire Ignamability Index 960°C, passes at1mmU. 560695-212Tolly Time Ignamability Index 960°C, passes at1mmU. 560695-212July Indignation2mmU. 560695-212Dying Time Ignamability Index 960°C, passes at2De Code95-212Dying Time Ignamability Index 960°C, passes at1mmmmJuly Indignation32Code95-212Dying Time (Cumulative)34mmmmJuly Indignation93MmMaximum Moisture Content293Moisture Temperature90-31021Nozel Temperature90-31021Font-Zone 3 Temperature90-31021Rear-Zone 1 Temperature90-31021Moidle-Zone 2 Temperature90-5221Back Pressure90-5290-5221Back Pressure90-5290-521Back Pressure <td>Arc Resistance, Tungsten {PLC}</td> <td>7</td> <td>PLC Code</td> <td>ASTM D 495</td>	Arc Resistance, Tungsten {PLC}	7	PLC Code	ASTM D 495
High Ampere Arc Ign, surface (PLC) 1 PCCOde U.746A Comparative Tracking Index (UL) (PLC) 3 PCCOde U.746A FLAME CHARACTERISTICS UL Yellow Card Link £207780-228400 - - Glow Wire Flammability Index 850°C, passe at 1 mm U.94 Glow Wire Ignamability Index 950°C, passe at 16 mm IEC 60695-212 Glow Wire Ignamability Index 950°C, passe at 16 mm IEC 60695-212 Glow Wire Ignamability Index 950°C, passe at 16 mm IEC 60695-212 Glow Wire Ignamability Index 950°C, passe at 16 mm IEC 60695-212 Glow Wire Ignamability Index 950°C, passe at 16 mm IEC 60695-212 Glow Wire Ignamability Index 950°C, passe at 16 mm IEC 60695-212 Glow Wire Ignamability Index 950°C, passe at 16 mm IEC 60695-212 Brown Ignamability Index 950°C, passe at 18 IEC 60695-212 IEC 60695-212 Brown Ignamability Index 950°C, passe at 20 20 20 20 20 20 20 </td <td>Hot Wire Ignition (PLC)</td> <td>2</td> <td>PLC Code</td> <td>UL 746A</td>	Hot Wire Ignition (PLC)	2	PLC Code	UL 746A
Comparative Tracking Index (UL) (PLC) 3 PLC Ode U.746A FLAME CHARACTERISTICS UL Yellow Card Link E207780-228400 - - UL Recognized, 94V-0 Flame Class Rating 1.1 mm UE 06095-2-12 Glow Wire Flammability Index 850°C, passes at 1.6 mm IEC 60695-2-12 Glow Wire Iganitability Temperature, 0.8 mm 80 **C EC 60695-2-13 INJECTION MOLDING Drying Temperature 120 **C **C **C Drying Time (Cumulative) 48 Ins **C **C **C Maximum Moisture Content 200-310 **C **C **C Melt Temperature 200-310 **C **C **C Front - Zone 3 Temperature 209-310 **C **C **C Rear- Zone 1 Temperature 275-300 **C **C **C Mold Temperature 20-95 **C **C **C Back Pressure 30-07 **C **C **C **C **C **C **C **C **C **C </td <td>High Voltage Arc Track Rate {PLC}</td> <td>0</td> <td>PLC Code</td> <td>UL 746A</td>	High Voltage Arc Track Rate {PLC}	0	PLC Code	UL 746A
TAMAE CHARACTERISTICS Ut. Vellow Card Link Ut. Recognized, 94V-0 Flame Class Rating 1.1 Clow Wire Flammability Index 850°C, passes at 1.6 Clow Wire Flammability Index 960°C, passes at 1.6 Clow Wire Index 9	High Ampere Arc Ign, surface {PLC}	1	PLC Code	UL 746A
U. Vellow Card LinkE207780-228400U. Recognized, 94V-0 Flame Class Rating1.1mmU.94Glow Wire Flammability Index 950°C, passes at1.6mmEC 6095-2-12Glow Wire Flammability Index 960°C, passes at1.6mmEC 6095-2-13Glow Wire Ignitability Temperature, 0.8 mm80******Drying Temperature120******Drying Time3-415******Maximum Moisture Content3-4******Melt Temperature20-310******Nozzle Temperature20-310******Mozzle Temperature20-310******Middle-Zone 2 Temperature20-310******Middle-Zone 2 Temperature20-530******Mold Temperature20-50******Mold Temperature3-0-95******Mold Temperature0.3-0.7MPa***Stew Speed40-70pm***Mot Cylinder Size40-60\$*****	Comparative Tracking Index (UL) {PLC}	3	PLC Code	UL 746A
Likecognized, 94V-0 Flame Class Rating 1.1 mm UL 94 Clow Wire Flammability Index 850°C, passes at 1.6 mm EC 60695-2-12 Clow Wire Flammability Index 960°C, passes at 1.6 mm EC 60695-2-13 Clow Wire Inditability Temperature, 0.8 mm 800 °C EC 60695-2-13 Drying Temperature 120 °C EC 60695-2-13 Drying Time (Cumulative) 48 hrs Instruction Maximum Moisture Content 200-310 °C Instruction Nozzle Temperature 290-310 °C Instruction Nozzle Temperature 290-310 °C Instruction Middle-Zone 2 Temperature 290-310 °C Instruction Middle-Zone 2 Temperature 290-310 °C Instruction Rear-Zone 1 Temperature 265-290 °C Instruction Moid Temperature 70-95 °C Instruction Back Pressure 30-30 MPa Instruction Screw Speed 40-60 90-70 Instruction	FLAME CHARACTERISTICS			
Glow Wire Flammability Index 850°C, passes at1mmIEC 60695-2·12Glow Wire Ignitability Temperature, 0.8 mm1.6mmIEC 60695-2·12INJECTION MOLDINGDrying Temperature120°C"SDrying Time (Cumulative)3 – 4hrsMaximum Moisture Content290 – 310°C"SNozel Temperature290 – 310°C"SFront - Zone 3 Temperature290 – 310°C"SMiddle - Zone 2 Temperature290 – 310°C"SMedid - Zone 2 Temperature275 – 300°C"SMod Temperature265 – 290°C"SMod Temperature70 – 95°C"SBack Pressure0.3 – 0.7MPa"SScrew Speed40 – 70pm"SShot to Cylinder Size40 – 60%"S	UL Yellow Card Link	E207780-228400	-	-
Glow Wire Flammability Index 960°C, passes at1.6mmIC 60695-2·12Glow Wire Ignitability Temperature, 0.8 mm800°CIC 60695-2·13INJECTION MOLDINGDrying Temperature120°C'SDrying Time3 - 4hrs'SDrying Time (Cumulative)48hrs'SMaximum Moisture Content200 - 310°C'SNozzle Temperature290 - 310°C'SFront - Zone 3 Temperature290 - 310°C'SMiddle - Zone 2 Temperature290 - 310°C'SMedid Temperature257 - 300°C'SMold Temperature70 - 95°CMold Temperature0.3 - 0.7MPaScrew Speed40 - 70pm'SStot Cylinder Size40 - 60%'S	UL Recognized, 94V-0 Flame Class Rating	1.1	mm	UL 94
Clow Wire Ignitability Temperature, 0.8 mm 800 °C 16C 60695-2·13 INJECTION MOLDING Drying Temperature 120 °C 15C	Glow Wire Flammability Index 850°C, passes at	1	mm	IEC 60695-2-12
INJECTION MOLDING Drying Temperature 120 °C Drying Time (Cumulative) 48 hrs Maximum Moisture Content 290 - 310 °C Nozzle Temperature 290 - 310 °C Front - Zone 3 Temperature 290 - 310 °C Middle - Zone 2 Temperature 290 - 310 °C Middle - Zone 2 Temperature 290 - 310 °C Middle - Zone 3 Temperature 290 - 310 °C Middle - Zone 3 Temperature 290 - 310 °C Middle - Zone 3 Temperature 290 - 310 °C Middle - Zone 4 Temperature 200 · 310 °C Rear - Zone 1 Temperature 200 · 310 °C Mold Temperature 300 °C Mold Tempera	Glow Wire Flammability Index 960°C, passes at	1.6	mm	IEC 60695-2-12
Drying Temperature 120 °C Drying Time (Cumulative) 3-4 hrs Drying Time (Cumulative) 48 hrs Maximum Moisture Content 200-310 °C Mozzle Temperature 200-310 °C Nozzle Temperature 200-310 °C Nozzle Temperature 200-310 °C Middle - Zone 3 Temperature 200-310 °C Middle - Zone 2 Temperature 200-310 °C Rear - Zone 1 Temperature 205-290 °C Rear - Zone 1 Temperature 205-290 °C Rear - Zone 1 Temperature 205-290 °C Scew Speed 40-70 mpa	Glow Wire Ignitability Temperature, 0.8 mm	800	°C	IEC 60695-2-13
Drying Time Drying Time (Cumulative) 48 Maximum Moisture Content 0.02 Melt Temperature 290-310 Crosser Temperature 280-305 Crosser Temperature 290-310 Crosser Temperature 290-310 Crosser Temperature 290-310 Crosser Temperature 275-300 Crosser Temperature 265-290 Crosser Temperature	INJECTION MOLDING			
Drying Time (Cumulative) Maximum Moisture Content Occ Melt Temperature Drying Time (Cumulative) Mozele Temperature Drying Time (Cumulative) Droit Temperature	Drying Temperature	120	°C	
Maximum Moisture Content0.02%Melt Temperature290 – 310°CNozzle Temperature280 – 305°CFront - Zone 3 Temperature290 – 310°CMiddle - Zone 2 Temperature275 – 300°CRear - Zone 1 Temperature265 – 290°CMold Temperature70 – 95°CBack Pressure0.3 – 0.7MPaScrew Speed40 – 70pmShot to Cylinder Size40 – 60%	Drying Time	3 – 4	hrs	
Melt Temperature 290 – 310 °C Nozzle Temperature 280 – 305 °C Front - Zone 3 Temperature 290 – 310 °C Middle - Zone 2 Temperature 275 – 300 °C Rear - Zone 1 Temperature 265 – 290 °C Mold Temperature 70 – 95 °C Back Pressure 0.3 – 0.7 MPa Screw Speed 40 – 70 pm Shot to Cylinder Size 40 – 60 %	Drying Time (Cumulative)	48	hrs	
Nozzle Temperature 280 – 305 °C Front - Zone 3 Temperature 290 – 310 °C Middle - Zone 2 Temperature 275 – 300 °C Rear - Zone 1 Temperature 265 – 290 °C Mold Temperature 70 – 95 °C Back Pressure 0.3 – 0.7 MPa Screw Speed 40 – 70 mpm Shot to Cylinder Size 40 – 60 %	Maximum Moisture Content	0.02	%	
Front - Zone 3 Temperature 290 – 310 °C Middle - Zone 2 Temperature 275 – 300 °C Rear - Zone 1 Temperature 265 – 290 °C Mold Temperature 70 – 95 °C Back Pressure 0.3 – 0.7 MPa Screw Speed 40 – 70 mm Shot to Cylinder Size 40 – 60 %	Melt Temperature	290 – 310	°C	
Middle - Zone 2 Temperature 275 – 300 °C Rear - Zone 1 Temperature 265 – 290 °C Mold Temperature 70 – 95 °C Back Pressure 0.3 – 0.7 MPa Screw Speed 40 – 70 rpm Shot to Cylinder Size 40 – 60 %	Nozzle Temperature	280 – 305	°C	
Rear - Zone 1 Temperature 265 - 290 °C Mold Temperature 70 - 95 °C Back Pressure 0.3 - 0.7 MPa Screw Speed 40 - 70 rpm Shot to Cylinder Size 40 - 60 %	Front - Zone 3 Temperature	290 – 310	°C	
Mold Temperature 70 – 95 °C Back Pressure 0.3 – 0.7 MPa Screw Speed 40 – 70 rpm Shot to Cylinder Size 40 – 60 %	Middle - Zone 2 Temperature	275 – 300	°C	
Back Pressure 0.3 – 0.7 MPa Screw Speed 40 – 70 rpm Shot to Cylinder Size 40 – 60 %	Rear - Zone 1 Temperature	265 – 290	°C	
Screw Speed 40 – 70 rpm Shot to Cylinder Size 40 – 60 %	Mold Temperature	70 – 95	°C	
Shot to Cylinder Size 40 – 60 %	Back Pressure	0.3 – 0.7	MPa	
•	Screw Speed	40 – 70	rpm	
Vent Depth 0.025 – 0.076 mm	Shot to Cylinder Size	40 – 60	%	
	Vent Depth	0.025 – 0.076	mm	

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