

# LEXAN™ COPOLYMER 4795R

REGION EUROPE

## DESCRIPTION

LEXAN 4795R is a high heat resistant poly(ester)carbonate injection molding resin. Flame Retardant.

## TYPICAL PROPERTY VALUES

Revision 20170913

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
<b>MECHANICAL</b>			
Tensile Stress, yld, Type I, 50 mm/min	68	MPa	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	70	MPa	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	7.5	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	117	%	ASTM D 638
Tensile Modulus, 50 mm/min	2170	MPa	ASTM D 638
Flexural Stress, brk, 1.3 mm/min, 50 mm span	105	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	2200	MPa	ASTM D 790
<b>IMPACT</b>			
Izod Impact, unnotched, 23°C	2140	J/m	ASTM D 4812
Izod Impact, notched, 23°C	578	J/m	ASTM D 256
Instrumented Impact Energy @ peak, 23°C	73	J	ASTM D 3763
Instrumented Impact Total Energy, 23°C	77	J	ASTM D 3763
<b>THERMAL</b>			
Vicat Softening Temp, Rate B/50	164	°C	ASTM D 1525
HDT, 0.45 MPa, 3.2 mm, unannealed	160	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	147	°C	ASTM D 648
Ball Pressure Test, 125°C +/- 2°C	PASS	-	IEC 60695-10-2
<b>PHYSICAL</b>			
Specific Gravity	1.2	-	ASTM D 792
Melt Flow Rate, 330°C/2.16 kgf	15	g/10 min	ASTM D 1238
Density	1.2	g/cm <sup>3</sup>	ISO 1183
<b>INJECTION MOLDING</b>			
Drying Temperature	120	°C	
Drying Time	3 – 4	hrs	
Drying Time (Cumulative)	48	hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	350 – 370	°C	

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Nozzle Temperature	345 – 365	°C	
Front - Zone 3 Temperature	350 – 370	°C	
Middle - Zone 2 Temperature	340 – 360	°C	
Rear - Zone 1 Temperature	325 – 350	°C	
Mold Temperature	80 – 115	°C	
Back Pressure	0.3 – 0.7	MPa	
Screw Speed	40 – 70	rpm	
Shot to Cylinder Size	40 – 60	%	
Vent Depth	0.025 – 0.076	mm	

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