

# LEXAN™ COPOLYMER HFD1810

REGION ASIA

## DESCRIPTION

40 MFR LEXAN High Flow Ductile Copolymer

## TYPICAL PROPERTY VALUES

Revision 20240624

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
<b>MECHANICAL <sup>(1)</sup></b>			
Tensile Stress, yld, Type I, 50 mm/min	60	MPa	ASTM D638
Tensile Stress, brk, Type I, 50 mm/min	56	MPa	ASTM D638
Tensile Strain, yld, Type I, 50 mm/min	5.5	%	ASTM D638
Tensile Strain, brk, Type I, 50 mm/min	130	%	ASTM D638
Tensile Modulus, 5 mm/min	2270	MPa	ASTM D638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	100	MPa	ASTM D790
Flexural Modulus, 1.3 mm/min, 50 mm span	2240	MPa	ASTM D790
Hardness, Rockwell R	120	-	ASTM D785
Tensile Stress, yield, 50 mm/min	63	MPa	ISO 527
Tensile Stress, break, 50 mm/min	56	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	6	%	ISO 527
Tensile Strain, break, 50 mm/min	97	%	ISO 527
Tensile Modulus, 1 mm/min	2180	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	91	MPa	ISO 178
Flexural Modulus, 2 mm/min	2180	MPa	ISO 178
<b>IMPACT <sup>(1)</sup></b>			
Izod Impact, notched, 23°C	728	J/m	ASTM D256
Izod Impact, notched, 0°C	699	J/m	ASTM D256
Izod Impact, notched, -30°C	110	J/m	ASTM D256
Multiaxial Impact	95	J	ISO 6603
Instrumented Dart Impact Total Energy, 23°C	56	J	ASTM D3763
Izod Impact, unnotched 80*10*3 +23°C	NB	kJ/m <sup>2</sup>	ISO 180/1U
Izod Impact, unnotched 80*10*3 -30°C	NB	kJ/m <sup>2</sup>	ISO 180/1U
Izod Impact, notched 80*10*3 +23°C	58	kJ/m <sup>2</sup>	ISO 180/1A
Izod Impact, notched 80*10*3 -30°C	11	kJ/m <sup>2</sup>	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*3 sp=62mm	64	kJ/m <sup>2</sup>	ISO 179/1eA
Charpy -30°C, V-notch Edgew 80*10*3 sp=62mm	13	kJ/m <sup>2</sup>	ISO 179/1eA
Charpy 23°C, Unnotch Edgew 80*10*3 sp=62mm	NB	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy -30°C, Unnotch Edgew 80*10*3 sp=62mm	NB	kJ/m <sup>2</sup>	ISO 179/1eU
<b>THERMAL <sup>(1)</sup></b>			
Vicat Softening Temp, Rate B/50	135	°C	ASTM D1525
HDT, 0.45 MPa, 3.2 mm, unannealed	121	°C	ASTM D648
HDT, 1.82 MPa, 3.2mm, unannealed	110	°C	ASTM D648
CTE, -40°C to 40°C, flow	8.E-05	1/°C	ASTM E831
CTE, -40°C to 40°C, xflow	8.E-05	1/°C	ASTM E831

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
CTE, -40°C to 40°C, flow	8.E-05	1 / °C	ISO 11359-2
CTE, -40°C to 40°C, xflow	8.E-05	1 / °C	ISO 11359-2
Ball Pressure Test, 125°C +/- 2°C	PASS	-	IEC 60695-10-2
Vicat Softening Temp, Rate B/50	129	°C	ISO 306
Vicat Softening Temp, Rate B/120	130	°C	ISO 306
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	115	°C	ISO 75/Af
Relative Temp Index, Elec <sup>(2)</sup>	105	°C	UL 746B
Relative Temp Index, Mech w/impact <sup>(2)</sup>	105	°C	UL 746B
Relative Temp Index, Mech w/o impact <sup>(2)</sup>	105	°C	UL 746B
PHYSICAL <sup>(1)</sup>			
Specific Gravity	1.2	-	ASTM D792
Density	1.2	g/cm <sup>3</sup>	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	40	g/10 min	ASTM D1238
Density	1.2	g/cm <sup>3</sup>	ISO 1183
Water Absorption, (23°C/saturated)	0.3	%	ISO 62-1
Moisture Absorption (23°C / 50% RH)	0.15	%	ISO 62
Melt Volume Rate, MVR at 300°C/1.2 kg	38	cm <sup>3</sup> /10 min	ISO 1133
OPTICAL <sup>(1)</sup>			
Light Transmission, 2.54 mm	88	%	ASTM D1003
Haze, 2.54 mm	<1	%	ASTM D1003
Refractive Index	1.582	-	ASTM D542
FLAME CHARACTERISTICS <sup>(2)</sup>			
UL Yellow Card Link	<a href="#">E207780-100910180</a>	-	-
UL Recognized, 94HB Flame Class Rating	≥0.3	mm	UL 94
UL Recognized, 94V-2 Flame Class Rating	≥1	mm	UL 94
INJECTION MOLDING <sup>(4)</sup>			
Drying Temperature	105 – 110	°C	
Drying Time	3 – 4	Hrs	
Drying Time (Cumulative)	24	Hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	260 – 305	°C	
Nozzle Temperature	255 – 300	°C	
Front - Zone 3 Temperature	260 – 305	°C	
Middle - Zone 2 Temperature	250 – 295	°C	
Rear - Zone 1 Temperature	240 – 280	°C	
Mold Temperature	50 – 80	°C	
Back Pressure	0.3 – 0.7	MPa	
Screw Speed	35 – 75	rpm	
Shot to Cylinder Size	40 – 60	%	
Vent Depth	0.038 – 0.076	mm	

- (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. 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.
- (4) Injection Molding parameters are only mentioned as general guidelines. These may not apply or may need adjustment in specific situations such as low shot sizes, large part molding, thin wall molding and gas-assist molding.

## MORE INFORMATION

For curve data and CAE cards, please visit and register at <https://materialfinder.sabic-specialties.com>

## DISCLAIMER

Any sale by SABIC, its subsidiaries and affiliates (each a "seller"), is made exclusively under seller's standard conditions of sale (available upon request) unless agreed otherwise in writing and signed on behalf of the seller. While the information contained herein is given in good faith, SELLER MAKES NO WARRANTY, EXPRESS OR IMPLIED, INCLUDING MERCHANTABILITY AND NONINFRINGEMENT OF INTELLECTUAL PROPERTY, NOR ASSUMES ANY LIABILITY, DIRECT OR INDIRECT, WITH RESPECT TO THE PERFORMANCE, SUITABILITY OR FITNESS FOR INTENDED USE OR PURPOSE OF THESE PRODUCTS IN ANY APPLICATION. Each customer must determine the suitability of seller materials for the customer's particular use through appropriate testing and analysis. No statement by seller concerning a possible use of any product, service or design is intended, or should be construed, to grant any license under any patent or other intellectual property right.