LEXAN™ COPOLYMER HPF1

REGION AMERICAS

DESCRIPTION

25 MFR LEXAN High Flow Ductile Copolymer Healthcare Grade

TYPICAL PROPERTY VALUES

Revision 20260210

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL [1]			
Tensile Stress, yld, Type I, 50 mm/min	59	MPa	ASTM D638
Tensile Stress, brk, Type I, 50 mm/min	60	MPa	ASTM D638
Tensile Strain, yld, Type I, 50 mm/min	6	%	ASTM D638
Tensile Strain, brk, Type I, 50 mm/min	132	%	ASTM D638
Tensile Modulus, 5 mm/min	2230	MPa	ASTM D638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	99	MPa	ASTM D790
Flexural Modulus, 1.3 mm/min, 50 mm span	2220	MPa	ASTM D790
Hardness, Rockwell R	120	-	ASTM D785
Tensile Stress, yield, 50 mm/min	62	MPa	ISO 527
Tensile Stress, break, 50 mm/min	65	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	6	%	ISO 527
Tensile Strain, break, 50 mm/min	123	%	ISO 527
Tensile Modulus, 1 mm/min	2180	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	90	MPa	ISO 178
Flexural Modulus, 2 mm/min	2180	MPa	ISO 178
IMPACT [1]			
Izod Impact, notched, 23°C	812	J/m	ASTM D256
Izod Impact, notched, 0°C	789	J/m	ASTM D256
Izod Impact, notched, -30°C	125	J/m	ASTM D256
Multiaxial Impact	110	J	ISO 6603
Instrumented Dart Impact Total Energy, 23°C	67	J	ASTM D3763
Izod Impact, unnotched 80*10*3 +23°C	NB	kJ/m²	ISO 180/1U
Izod Impact, unnotched 80*10*3 -30°C	NB	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*3 +23°C	64	kJ/m²	ISO 180/1A
Izod Impact, notched 80*10*3 -30°C	13	kJ/m²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*3 sp=62mm	73	kJ/m²	ISO 179/1eA
Charpy -30°C, V-notch Edgew 80*10*3 sp=62mm	13	kJ/m²	ISO 179/1eA
Charpy 23°C, Unnotch Edgew 80*10*3 sp=62mm	NB	kJ/m²	ISO 179/1eU
Charpy -30°C, Unnotch Edgew 80*10*3 sp=62mm	NB	kJ/m²	ISO 179/1eU
THERMAL [1]			
Vicat Softening Temp, Rate B/50	135	°C	ASTM D1525
HDT, 0.45 MPa, 3.2 mm, unannealed	122	°C	ASTM D648
HDT, 1.82 MPa, 3.2mm, unannealed	111	°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

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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
PHYSICAL [1]			
Specific Gravity	1.2	-	ASTM D792
Density	1.2	g/cm³	ASTM D792
Mold Shrinkage, flow, 3.2 mm [2]	0.5 – 0.7	%	SABIC method
Melt Flow Rate, 300°C/1.2 kgf	25	g/10 min	ASTM D1238
Density	1.2	g/cm³	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	23	cm³/10 min	ISO 1133
OPTICAL [1]			
Light Transmission, 2.54 mm	80	%	ASTM D1003
Haze, 2.54 mm	<1	%	ASTM D1003
Refractive Index	1.582	-	ASTM D542
INJECTION MOLDING [3]			
Drying Temperature	105 – 110	°C	
Drying Time	3 – 4	Hrs	
Drying Time (Cumulative)	24	Hrs	
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) 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.

(3) 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

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