

LEXANTM COPOLYMER HFD1731

REGION EUROPE

DESCRIPTION

25 MFR LEXAN High Flow Ductile Copolymer UV-stabilized

TYPICAL PROPERTY VALUES

Revision 20240620

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



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 (2) 105 °C UL 7468 Relative Temp Index, Mech w/impact (2) 105 °C UL 7468 Relative Temp Index, Mech w/impact (2) 105 °C UL 7468 Relative Temp Index, Mech w/impact (2) 105 °C UL 7468 Relative Temp Index, Mech w/impact (2) 105 °C UL 7468 Relative Temp Index, Mech w/impact (2) 105 °C UL 7468 Relative Temp Index, Mech w/impact (2) 105 °C WIL 7468 PHYSICAL (1) **** ASTM D792 Bentity (2) 105 0.7 %** ASTM D792 Mold Shrinkage, flow, 3.2 mm (3) 105 0.7 %** ASIM D1038 Melt Flow Rate, 300°C/1.2 kg 1.2 1.2 1.2 1.2 1.2 1.2 1.2 1.2 1.2 1.2 1.2 1.2 1.2 1.2 1.2 1.2				
CTE, 40°C to 40°C, xilow 86.05 1,1°C BO 1359-2 Ball Pressure Text, 125°C-12°C ASS - EC 60695102 Vicat Softening Temp, Rate 8/120 130 °C BO 306 Vicat Softening Temp, Rate 8/120 115 °C BO 306 HDT/AL I, MPa Flativ 80°10°4 spe-farm 115 °C U.7488 Relative Temp Index, Mech w/i impact ⁽¹⁾ 105 °C U.7468 Relative Temp Index, Mech w/i impact ⁽¹⁾ 105 °C U.7468 Relative Temp Index, Mech w/i impact ⁽¹⁾ 12 glom² ASTM 0792 Relative Temp Index, Mech w/i impact ⁽¹⁾ 12 glom² ASTM 0792 Relative Temp Index, Mech w/i impact ⁽¹⁾ 12 glom² ASTM 0792 Beatity 0.5 0.7 3 MSIM 0792 Bensity 0.5 0.7 3 MSIM 0792 Molt Stankage, flow, 3.2 mm ⁽¹⁾ 0.5 0.7 3 MSIM 0792 Bensity 0.15 8 S0 62 Bensity 1.2 Molt 20 MSIM 0792 Bensity	PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Ball Pressure Test, 125°C v. - 2°C PASS	CTE, -40°C to 40°C, flow	8.E-05	1/°C	ISO 11359-2
Vicat Softening Temp, Rate B/SO 129 °C SO 306 Vicat Softening Temp, Rate B/120 130 °C 80 306 MoDT/M, 1.8 MPa Flatw 80*10*4 sp=64mm 115 °C 80 75/M Relative Temp Index, Dete. ⁽¹⁾ 105 °C U. 7468 Relative Temp Index, Mech w/lo Impact ⁽²⁾ 105 °C U. 7468 Relative Temp Index, Mech w/lo Impact ⁽²⁾ 105 °C U. 7468 Relative Temp Index, Mech w/lo Impact ⁽²⁾ 105 °C U. 7468 Relative Temp Index, Mech w/lo Impact ⁽²⁾ 12 °C ASTM D792 Relative Temp Index, Mech w/lo Impact ⁽²⁾ 12 √C ASTM D792 Mell voll vice (Garwity) 12 √C ASTM D792 Mold Shrinkage, flow, 3.2 mm ⁽²⁾ 5.0 ASTM D792 Model of Ministry Mell Flow Rate, 3.00°(71.2 kg) 0.3 4 6.0 6.1 Density 1.2 2.0 0.0 6.0 6.0 Water Absorption (23°C / Suk H) 0.15 8 6.0 6.0 Melt Tow Junter S	CTE, -40°C to 40°C, xflow	8.E-05	1/°C	ISO 11359-2
Vical Softening Temp, Rate 8 120 130 °C 50 306 HDT /A. I. 8 Mra Flatw 80°10*4 spe-6mm 115 °C 10 7468 Relative Temp Index, Mech w/Impact ⁽¹⁾ 105 °C U. 7468 Relative Temp Index, Mech w/Impact ⁽²⁾ 105 °C U. 7468 PHYSICAL ⁽¹⁾ ************************************	Ball Pressure Test, 125°C +/- 2°C	PASS	-	IEC 60695-10-2
HDT/A, 1.8 MB Flatw 80*10*4 sp=64mm 155 150	Vicat Softening Temp, Rate B/50	129	°C	ISO 306
Relative Temp Index, Mech w/Impact (**) 105 "C U.7468 Relative Temp Index, Mech w/Impact (**) 105 "C U.7468 Relative Temp Index, Mech w/Impact (**) 105 "C U.7468 Relative Temp Index, Mech w/Impact (**) 12 "C ASTM D792 Possibit 1.2 9 (m²) ASTM D792 Density 1.2 9 (m²) ASTM D792 Mold Shrinkage, flow, 3.2 mm (**) 1.2 9 (m²) ASTM D792 Mold Shrinkage, flow, 3.2 mm (**) 1.2 9 (m²) ASTM D792 Mold H flow Rate, 300°C/1.2 kg/1 2.2 9 (m²) ASTM D792 Water Absorption (23°C/1.2 kg/1 3.2 3 (m²) 8 (m²) 6 (2 Water Absorption (23°C/1.2 kg/1 3.2 3 (m²) 9 (m²) 6 (2 Water Liviums Eath, Wk at 300°C/1.2 kg/1 3.2 3 (m²) 9 (m²) 9 (m²) Water Liviums Eath, Wk at 300°C/1.2 kg/1 4 3 (m²) 9 (m²) 9 (m²) Pull 1.2 4 3 (m²) 9 (m²) 9 (m²) 9 (m²) <th>Vicat Softening Temp, Rate B/120</th> <th>130</th> <th>°C</th> <th>ISO 306</th>	Vicat Softening Temp, Rate B/120	130	°C	ISO 306
Relative Temp Index, Mech w/i impact (1) 105 °C U.7468 Relative Temp Index, Mech w/i o impact (1) 105 °C U.7468 Privision, "************************************		115	°C	ISO 75/Af
Relative Temp Index. Mechan/nimpact. ⁽²⁾ 105 °C U. 7 468 PMSICAL. ⁽¹⁾ Specific Gravity 1.2 3 CM ASTM D792 Density 1.2 9 CM ASTM D792 Mold Shrinkage, flow, 3.2 mm ⁽²⁾ 5.5 -0.7 % CM ASTM D1238 Density 1.2 9 CM 50 F102 Mol 1238 Water Absorption, (23°C/ Jakurated) 0.3 2 50 F2 13 MID 1238 Moltsture Absorption, (23°C/ Josh RH) 0.15 8 0.6 G2 13 MID 1033 Moltsture Absorption (23°C/ Josh RH) 0.15 8 0.6 G2 13 MID 1033 Moltsture Absorption (23°C/ Josh RH) 0.15 8 0.6 G2 13 MID 1033 Moltsture Absorption (23°C/ Josh RH) 0.15 8 ASTM D1033 13 MID 1033 Moltsture Absorption (23°C/ Josh RH) 8 8 8 8 ASTM D1034 14 MID 1034 14 MID		105	°C	UL 746B
Printsical (**) Printsical (**) Print (**) <	Relative Temp Index, Mech w/impact (2)	105	°C	UL 746B
Specific Gravity 1.2 4.5 ASTM D792 Density 1.2 9.0 7.0° ASTM D792 Mold Shrinkage, flow, 3.2 mm (**) 0.5 – 0.7 80 ASTM D792 Mell Flow Rate, 300°C/1.2 kgr 25 9.0 min ASTM D138 Bensity 1.2 9.0 min ASTM D138 Water Absorption, (23°C/ Saturated) 3.3 8 9.0 6.2 Moltvo Mone Rate, Mora 27°C / 50°K RH) 0.1 9.0 10.0 min 10.0 6.2 Melt Volume Rate, Mar 300°C/1.2 kg 1.2 9.0 10.0 min 10.0 6.2 Melt Volume Rate, Mar 300°C/1.2 kg 2.0 10.0 2.0 10.0 2.0 Melt Volume Rate, Mar 300°C/1.2 kg 8 8 9.0 ASTM D103 10.0 <th>Relative Temp Index, Mech w/o impact ⁽²⁾</th> <td>105</td> <td>°C</td> <td>UL 746B</td>	Relative Temp Index, Mech w/o impact ⁽²⁾	105	°C	UL 746B
Density 1.2 g/cm² ASTM D792 Mold Shrinkage, flow, 3.2 mm (³) 0.5 – 0.7 % SABIC method Melt Flow Rate, 300°C/1.2 kgf 25 g/m³ SABIC method Density 10.2 g/m³ ISO 1823 Water Absorption, (23°C/ saturated) 0.3 % 150 62.1 Moisture Absorption (23°C/ So RH) 0.15 % 150 62.1 Melt Volume Rate, MVR at 300°C/ 1.2 kg 23 cm²/l 0 min ISO 62.1 Melt Volume Rate, MVR at 300°C/ 1.2 kg 23 cm²/l 0 min ISO 1133 US 45 Melt Volume Rate, MVR at 300°C/ 1.2 kg 3 ASTM D1003 Melt Volume Rate, MVR at 300°C/ 1.2 kg 3 ASTM D1003 Melt Volume Rate, MVR at 300°C/ 1.2 kg 4 ASTM D1003 Melt Volume Rate, MVR at 300°C/ 1.2 kg 4 ASTM D1003 ASTM D1003 Melt Volume Rate, MVR at 300°C/ 1.2 kg 4 ASTM D1003 ASTM D1003 ASTM D1003 Melt Carlot Info 1 5 5 4 4 <t< td=""><th>PHYSICAL (1)</th><td></td><td></td><td></td></t<>	PHYSICAL (1)			
Mold Shrinkage, flow, 3.2 mm ⁽¹⁾ 0.5 − 0.7 % SABIC method Melt Flow Rate, 300°C/1.2 kgf 25 g/10 min ASTM D1238 Density 1.2 g/m³ SO 1183 Water Absorption, (23°C/ 508 kH) 0.3 % SO 62-1 Molisture Absorption (23°C/ 508 kH) 0.15 % SO 50 Melt Volume Rate, MVR at 300°C/1.2 kg 23 m²/10 min ISO 62-1 Melt Volume Rate, MVR at 300°C/1.2 kg 88 % ASTM D1003 Market Hazer, 254 mm 88 % ASTM D1003 Refractive Index 1.52 x ASTM D1003 Refractive Index 1.52 x ASTM D1003 Refractive Index 1.52 x ASTM D1003 Refractive Index 5.52 x ASTM D1003 ASTM D1003 Refractive Index 5.52 x x X X ASTM D1003 <	Specific Gravity	1.2	-	ASTM D792
Met Flow Rate, 300°C/1.2 kgf 25 9/10min ASTM D1238 Density 1.2 9/10min 150 1183 Water Absorption, (23°C/ saturated) 0.3 3 150 621 Moisture Absorption (23°C/ saturated) 0.15 3 150 621 Met Volume Rate, MVR at 300°C/1.2 kg 3 20 71 min 150 1133 BME Volume Rate, MVR at 300°C/1.2 kg 3 20 71 min 150 113 BME Volume Rate, MVR at 300°C/1.2 kg 3 20 71 min 20 113 BME Volume Rate, MVR at 300°C/1.2 kg 3 20 71 min 20 113 20 113 BME Volume Rate, MVR at 300°C/1.2 kg 4 20 110 20	Density	1.2	g/cm³	ASTM D792
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 62-1 Melt Volume Rate, MVR at 300°C/1.2 kg 23 cm²/10 min ISO 1133 OPTICAL ⁽¹⁾ Usign Tasmision 2.54 mm 88 % ASTM D1003 Haze, 2.54 mm 1 % ASTM D1003 Refractive Index 4 ASTM D1003 Lagrange Marker	Mold Shrinkage, flow, 3.2 mm ⁽³⁾	0.5 – 0.7	%	SABIC method
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 cm²/10 min ISO 133 OPTICAL IO Utight Transmission, 2.54 mm 88 % ASTM D1003 Refractive Index 1.582 - ASTM D1003 Refractive Index 5.582 - ASTM D542 FLAME CHARACTERISTICS (2) Utige Congrized, 94HB Flame Class Rating 6.8329-100988172 - - - Utige Congrized, 94HB Flame Class Rating 105-110 C - - Unjug Time (Carriage Class Rating) 105-110 C - - Drying Time (Cumulative) 3-4 H/S - - - Drying Time (Cumulative) 2.0 % - - - - - - - - - - - - - - -	Melt Flow Rate, 300°C/1.2 kgf	25	g/10 min	ASTM D1238
Moisture Absorption (23°C / 50% RH) 0.15 % ISO 62 Melt Volume Rate, MVR at 300°C/1.2 kg 23 cm²/10 min ISO 1133 OPTICAL (**) Light Transmission, 2.54 mm 88 % ATM D1003 Refractive Index 1.582 % ASTM D1003 Refractive Index Light CARACTERISTICS (**) UL Yellow Card Link £45329-100988172 * <th>Density</th> <td>1.2</td> <td>g/cm³</td> <td>ISO 1183</td>	Density	1.2	g/cm³	ISO 1183
Melt Volume Rate, MVR at 300°C/1.2 kg OPTICAL (1) Light Transmission, 2.54 mm Base, 2.54 mm 1.582	Water Absorption, (23°C/saturated)	0.3	%	ISO 62-1
OPTICAL (**) Light Transmission, 2.54 mm 88 % ASTM D1003 Haze, 2.54 mm 1.582 * ASTM D542 FLAME CHARACTERISTICS (**) U. Vellow Card Link £45329-100988172 * * U. Vellow Card Link £45329-100988172 * * U. Vellow Card Link £45329-100988172 * * U. Vellow Card Link £50.2 mm U. 94 No. 1000 McDING (*) U. Spring Temperature \$0.5 * * Drying Time (Cumulative) 24 Hrs *	Moisture Absorption (23°C / 50% RH)	0.15	%	ISO 62
Light Transmission, 2.54 mm 88 % ASTM D1003 Haze, 2.54 mm <1 % ASTM D1003 Refractive Index 1.582 . ASTM D542 FLAME CHARACTERISTICS (*) UL Yellow Card Link £45329-100988172 . . . UL Recognized, 94HB Flame Class Rating 80.8 mm UL 94 . INJECTION MOLDING (*) .	Melt Volume Rate, MVR at 300°C/1.2 kg	23	cm³/10 min	ISO 1133
Haze, 2.54 mm ASTM D1003 Refractive Index 1.582 - 2 ASTM D542 FLAME CHARACTERISTICS (2) UL Yellow Card Link £45329-100988172 - 2 - 2 UL Recognized, 94HB Flame Class Rating 60.8 mm UL 94 INJECTION MOLDING (4) US Proping Temperature 105 − 110 °C C Drying Time (Cumulative) 417 Hrs C Maximum Moisture Content 60.2 4 C Mozzle Temperature 260 − 305 °C C Nozzle Temperature 260 − 305 °C C Front - Zone 3 Temperature 260 − 305 °C C Middle - Zone 2 Temperature 260 − 305 °C C Rear - Zone 1 Temperature 240 − 280 °C C Mold Temperature 30 − 80 °C C Back Pressure 30 − 30 MPa C Screw Speed 30 − 60<	OPTICAL (1)			
Refractive Index FLAME CHARACTERISTICS (2) UL Yellow Card Link UL Recognized, 94HB Flame Class Rating IDENTIFY OF THE PROOF OF THE	Light Transmission, 2.54 mm	88	%	ASTM D1003
FLAME CHARACTERISTICS (2) UL Yellow Card Link F45329-100988172 - - UL Recognized, 94HB Flame Class Rating a0.8 mm UL 94 INJECTION MOLDING (4) Drying Temperature 105 – 110 °C - Drying Time (Cumulative) 3 – 4 Hrs - - Maximum Moisture Content 0.02 % - <t< td=""><th>Haze, 2.54 mm</th><td><1</td><td>%</td><td>ASTM D1003</td></t<>	Haze, 2.54 mm	<1	%	ASTM D1003
Ut Yellow Card Link£4539-100988172UL Recognized, 94HB Flame Class Rating20.8mmUL 94INJECTION MOLDING**Drying Temperature105 – 110C-Drying Time (Cumulative)3 – 4Hrs-Maximum Moisture Content0.02%-Nozzle Temperature260 – 305C-Nozzle Temperature255 – 300C-Front - Zone 3 Temperature260 – 305C-Midd Lezone 2 Temperature250 – 295C-Rear - Zone 1 Temperature240 – 280C-Mold Temperature50 – 80C-Back Pressure0.3 – 0.7MPAStew Speed35 – 75pm-Stot to Cylinder Size40 – 60%-	Refractive Index	1.582	-	ASTM D542
NUERecognized, 94HB Flame Class Rating NUERECTION MOLDING (4) Drying Temperature 105 - 110 3 - 4 Hrs Drying Time (Cumulative) 44 40 - 280 Moldle - Zone 2 Temperature 240 - 280 Mold - Zone 2 Temperature 250 - 295 Mold Temperature 240 - 280 Mold Temperature 250 - 295 Mold Temperature 250 -	FLAME CHARACTERISTICS (2)			
INJECTION MOLDING ⁽⁴⁾ Drying Temperature 105 – 110 °C 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 260 – 305 °C Middle - Zone 2 Temperature 260 – 305 °C Mold Temperature 260 – 305 °C Rear - Zone 1 Temperature 260 – 305 °C Mold Temperature 300 – 300 °C Mold Temperature	UL Yellow Card Link	E45329-100988172	-	-
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 Middle - 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 %	UL Recognized, 94HB Flame Class Rating	≥0.8	mm	UL 94
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 %	INJECTION MOLDING (4)			
Drying Time (Cumulative) Maximum Moisture Content Mozle Temperature Mozle Temperature Mozle Temperature Mozle Temperature Mozle Temperature Mozle Temperature Modle - Zone 3 Temperature Middle - Zone 2 Temperature Modle - Zone 1 Temperature Mold Temperat	Drying Temperature	105 – 110	°C	
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 %	Drying Time	3 – 4	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 %	Drying Time (Cumulative)	24	Hrs	
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 %	Maximum Moisture Content	0.02	%	
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 %	Melt 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 %	Nozzle Temperature	255 – 300	°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 %	Front - Zone 3 Temperature	260 – 305	°C	
Mold Temperature 50 – 80 °C Back Pressure 0.3 – 0.7 MPa Screw Speed 35 – 75 rpm Shot to Cylinder Size 40 – 60 %	Middle - Zone 2 Temperature	250 – 295	°C	
Back Pressure 0.3 – 0.7 MPa Screw Speed 35 – 75 rpm Shot to Cylinder Size 40 – 60 %	Rear - Zone 1 Temperature	240 – 280	°C	
Screw Speed 35 – 75 rpm Shot to Cylinder Size 40 – 60 %	Mold Temperature	50 – 80	°C	
Shot to Cylinder Size 40 – 60 %	Back Pressure	0.3 – 0.7	MPa	
·	Screw Speed	35 – 75	rpm	
Vent Depth 0.038 – 0.076 mm	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

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