LEXAN™ Copolymer HFD4413

REGION EUROPE

DESCRIPTION

LEXAN HFD4413 is a 30% glass filled, injection moldable grade designed for high flow and superior surface appearance. Internal mold release.

TYPICAL PROPERTY VALUES

Revision 20231109

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL [1]			
Tensile Stress, yld, Type I, 5 mm/min	111	MPa	ASTM D638
Tensile Stress, brk, Type I, 5 mm/min	111	MPa	ASTM D638
Tensile Strain, yld, Type I, 5 mm/min	3	%	ASTM D638
Tensile Modulus, 5 mm/min	7870	MPa	ASTM D638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	182	MPa	ASTM D790
Flexural Modulus, 1.3 mm/min, 50 mm span	7760	MPa	ASTM D790
Tensile Stress, yield, 5 mm/min	115	MPa	ISO 527
Tensile Stress, break, 5 mm/min	125	MPa	ISO 527
Tensile Strain, yield, 5 mm/min	2.5	%	ISO 527
Tensile Strain, break, 5 mm/min	2.1	%	ISO 527
IMPACT [1]			
Izod Impact, unnotched, 23°C	852	J/m	ASTM D4812
Izod Impact, notched, 23°C	133	J/m	ASTM D256
Instrumented Dart Impact Total Energy, 23°C	17	J	ASTM D3763
Izod Impact, unnotched 80*10*3 +23°C	37	kJ/m²	ISO 180/1U
Izod Impact, unnotched 80*10*3 -30°C	30	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*3 +23°C	10	kJ/m²	ISO 180/1A
Izod Impact, notched 80*10*3 -30°C	10	kJ/m²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*3 sp=62mm	12	kJ/m²	ISO 179/1eA
Charpy -30°C, V-notch Edgew 80*10*3 sp=62mm	11	kJ/m²	ISO 179/1eA
Charpy 23°C, Unnotch Edgew 80*10*3 sp=62mm	40	kJ/m²	ISO 179/1eU
Charpy -30°C, Unnotch Edgew 80*10*3 sp=62mm	49	kJ/m²	ISO 179/1eU
THERMAL [1]			
HDT, 0.45 MPa, 3.2 mm, unannealed	130	°C	ASTM D648
HDT, 1.82 MPa, 3.2mm, unannealed	125	°C	ASTM D648
CTE, -40°C to 40°C, flow	3.E-05	1/°C	ASTM E831
CTE, -40°C to 40°C, xflow	7.E-05	1/°C	ASTM E831
CTE, 23°C to 80°C, flow	3.E-05	1/°C	ISO 11359-2
CTE, 23°C to 80°C, xflow	7.E-05	1/°C	ISO 11359-2
Ball Pressure Test, 125°C +/- 2°C	PASSES	-	IEC 60695-10-2
Vicat Softening Temp, Rate B/120	143	°C	ISO 306
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	129	°C	ISO 75/Af
PHYSICAL [1]			
Specific Gravity	1.43	-	ASTM D792
Mold Shrinkage, flow, 3.2 mm [2]	0.1 – 0.3	%	SABIC method

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Mold Shrinkage, xflow, 3.2 mm [2]	0.1 – 0.3	%	SABIC method
Melt Flow Rate, 300°C/1.2 kgf	16	g/10 min	ASTM D1238
Density	1.44	g/cm³	ISO 1183
Water Absorption, (23°C/saturated)	0.3	%	ISO 62-1
Moisture Absorption (23°C / 50% RH)	0.12	%	ISO 62
Melt Volume Rate, MVR at 300°C/1.2 kg	18	cm³/10 min	ISO 1133
INJECTION MOLDING [3]			
Drying Temperature	120	°C	
Drying Time	3 – 4	Hrs	
Drying Time (Cumulative)	48	Hrs	
Maximum Moisture Content	0.02	%	
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	rpm	
Shot to Cylinder Size	40 – 60	%	
Vent Depth	0.025 – 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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