LEXAN™ COPOLYMER HFD4471

REGION EUROPE

DESCRIPTION

LEXAN HFD4471 is a 10% glass filled, medium flow, impact modified, injection moldable grade designed for high flow and superior surface appearance. HFD4417 has enhanced mold release, impact ductility and broad color space.

TYPICAL PROPERTY VALUES

Revision 20230607

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL [1]			
Tensile Stress, yld, Type I, 5 mm/min	54	MPa	ASTM D638
Tensile Stress, brk, Type I, 5 mm/min	37	MPa	ASTM D638
Tensile Strain, yld, Type I, 5 mm/min	3	%	ASTM D638
Tensile Modulus, 5 mm/min	3700	MPa	ASTM D638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	95	MPa	ASTM D790
Flexural Modulus, 1.3 mm/min, 50 mm span	3300	MPa	ASTM D790
Tensile Stress, yield, 5 mm/min	58	MPa	ISO 527
Tensile Stress, break, 5 mm/min	41	MPa	ISO 527
Tensile Strain, yield, 5 mm/min	3	%	ISO 527
Tensile Strain, break, 5 mm/min	10	%	ISO 527
IMPACT [1]			
Izod Impact, unnotched, 23°C	2100	J/m	ASTM D4812
Izod Impact, notched, 23°C	290	J/m	ASTM D256
Instrumented Dart Impact Total Energy, 23°C	43	J	ASTM D3763
Izod Impact, unnotched 80*10*3 +23°C	175	kJ/m²	ISO 180/1U
Izod Impact, unnotched 80*10*3 -30°C	93	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*3 +23°C	30	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	29	kJ/m²	ISO 179/1eA
Charpy -30°C, V-notch Edgew 80*10*3 sp=62mm	10	kJ/m²	ISO 179/1eA
Charpy 23°C, Unnotch Edgew 80*10*3 sp=62mm	NB132	kJ/m²	ISO 179/1eU
Charpy -30°C, Unnotch Edgew 80*10*3 sp=62mm	NB132	kJ/m²	ISO 179/1eU
THERMAL [1]			
HDT, 0.45 MPa, 3.2 mm, unannealed	131	°C	ASTM D648
HDT, 1.82 MPa, 3.2mm, unannealed	125	°C	ASTM D648
CTE, -40°C to 40°C, flow	4.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	4.E-05	1/°C	ISO 11359-2
CTE, 23°C to 80°C, xflow	8.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	135	°C	ISO 306
Relative Temp Index, Elec [2]	80	°C	UL 746B
Relative Temp Index, Mech w/impact [2]	80	°C	UL 746B
Relative Temp Index, Mech w/o impact [2]	80	°C	UL 746B

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
PHYSICAL [1]			
Specific Gravity	1.26	-	ASTM D792
Mold Shrinkage, flow, 3.2 mm [3]	0.3 – 0.4	%	SABIC method
Mold Shrinkage, xflow, 3.2 mm [3]	0.4 – 0.5	%	SABIC method
Melt Flow Rate, 300°C/1.2 kgf	10	g/10 min	ASTM D1238
Density	1.25	g/cm³	ISO 1183
Water Absorption, (23°C/saturated)	0.14	%	ISO 62-1
Moisture Absorption (23°C / 50% RH)	0.04	%	ISO 62
Melt Volume Rate, MVR at 300°C/1.2 kg	9	cm³/10 min	ISO 1133
FLAME CHARACTERISTICS [2]			
UL Yellow Card Link	E207780-101177310	-	-
UL Recognized, 94HB Flame Class Rating	≥0.4	mm	UL 94
Glow Wire Ignitability Temperature, 3.0 mm	900	°C	IEC 60695-2-13
Glow Wire Ignitability Temperature, 2.0 mm	900	°C	IEC 60695-2-13
Glow Wire Ignitability Temperature, 1.0 mm	930	°C	IEC 60695-2-13
Glow Wire Flammability Index, 3.0 mm	960	°C	IEC 60695-2-12
Glow Wire Flammability Index, 2.0 mm	960	°C	IEC 60695-2-12
Glow Wire Flammability Index, 1.0 mm	930	°C	IEC 60695-2-12
INJECTION MOLDING [4]			
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) 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.

ADDITIONAL PRODUCT NOTES

No PFAS intentionally added: The grade listed in this document does not contain PFAS intentionally added during Seller's manufacturing process and is not expected to contain unintentional PFAS impurities. Each user is responsible for evaluating the presence of unintentional PFAS impurities.

MORE INFORMATION

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

DISCLAIMER