LEXAN™ Copolymer HFD1413

REGION AMERICAS

DESCRIPTION

11 MFR LEXAN High Flow Ductile Copolymer

TYPICAL PROPERTY VALUES

Revision 20261022

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL [1]			
Tensile Stress, yld, Type I, 50 mm/min	58	MPa	ASTM D638
Tensile Stress, brk, Type I, 50 mm/min	67	MPa	ASTM D638
Tensile Strain, yld, Type I, 50 mm/min	6	%	ASTM D638
Tensile Strain, brk, Type I, 50 mm/min	137	%	ASTM D638
Tensile Modulus, 5 mm/min	2240	MPa	ASTM D638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	98	MPa	ASTM D790
Flexural Modulus, 1.3 mm/min, 50 mm span	2230	MPa	ASTM D790
Hardness, Rockwell R	120	-	ASTM D785
Tensile Stress, yield, 50 mm/min	61	MPa	ISO 527
Tensile Stress, break, 50 mm/min	68	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	6	%	ISO 527
Tensile Strain, break, 50 mm/min	126	%	ISO 527
Tensile Modulus, 1 mm/min	2120	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	90	MPa	ISO 178
Flexural Modulus, 2 mm/min	2090	MPa	ISO 178
IMPACT [1]			
Izod impact, notched			
23°C	903	J/m	ASTM D256
-20°C	859	J/m	ASTM D256
-30°C	435	J/m	ASTM D256
80*10*3 +23°C	70	kJ/m²	ISO 180/1A
80*10*3 -30°C	32	kJ/m²	ISO 180/1A
Izod Impact, Unnotched			
80*10*3 +23°C	NB	kJ/m²	ISO 180/1U
80*10*3 -30°C	NB	kJ/m²	ISO 180/1U
Multiaxial Impact	120	J	ISO 6603
Instrumented Dart Impact Total Energy, 23°C	77	J	ASTM D3763
Charpy 23°C, V-notch Edgew 80*10*3 sp=62mm	80	kJ/m²	ISO 179/1eA
Charpy -30°C, V-notch Edgew 80*10*3 sp=62mm	43	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	136	°C	ASTM D1525
HDT, 0.45 MPa, 3.2 mm, unannealed	124	°C	ASTM D648
HDT, 1.82 MPa, 3.2mm, unannealed	114	°C	ASTM D648

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
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
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	130	°C	ISO 306
Vicat Softening Temp, Rate B/120	131	°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 746B
Relative Temp Index, Mech w/impact [2]	105	°C	UL 746B
Relative Temp Index, Mech w/o impact [2]	105	°C	UL 746B
PHYSICAL [1]			
Specific Gravity	1.2	-	ASTM D792
Density	1.2	g/cm³	ASTM D792
Mold Shrinkage, flow, 3.2 mm [3]	0.5 – 0.7	%	SABIC method
Melt Flow Rate, 300°C/1.2 kgf	11	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	10	cm³/10 min	ISO 1133
OPTICAL [1]			
Light Transmission, 2.54 mm	88	%	ASTM D1003
Haze, 2.54 mm	<1	%	ASTM D1003
Refractive Index	1.582	-	ASTM D542
FLAME CHARACTERISTICS [2]			
UL Yellow Card Link	E121562-100911706	-	-
UL Recognized, 94HB Flame Class Rating	≥0.75	mm	UL 94
INJECTION MOLDING [4]			
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	

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(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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