

Lexan* Resin HFD1212

Americas: COMMERCIAL

18 MFR LEXAN High Flow Ductile Copolymer

Property

TYPICAL PROPERTIES ⁽¹⁾			
MECHANICAL	Value	Unit	Standard
Tensile Stress, yld, Type I, 50 mm/min	58	MPa	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	63	MPa	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	6	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	135	%	ASTM D 638
Tensile Modulus, 5 mm/min	2240	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	98	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	2220	MPa	ASTM D 790
Hardness, Rockwell R	120	-	ASTM D 785
Tensile Stress, yield, 50 mm/min	62	MPa	ISO 527
Tensile Stress, break, 50 mm/min	66	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	6	%	ISO 527
Tensile Strain, break, 50 mm/min	124	%	ISO 527
Tensile Modulus, 1 mm/min	2150	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	90	MPa	ISO 178
Flexural Modulus, 2 mm/min	2120	MPa	ISO 178
IMPACT	Value	Unit	Standard
Izod Impact, notched, 23°C	887	J/m	ASTM D 256
Izod Impact, notched, -10°C	838	J/m	ASTM D 256
Izod Impact, notched, -30°C	145	J/m	ASTM D 256
Multiaxial Impact	116	J	ISO 6603
Instrumented Impact Total Energy, 23°C	76	J	ASTM D 3763
Izod Impact, unnotched 80*10*3 +23°C	NB	kJ/m ²	ISO 180/1U
Izod Impact, unnotched 80*10*3 -30°C	NB	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*3 +23°C	67	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*3 -30°C	22	kJ/m ²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*3 sp=62mm	79	kJ/m ²	ISO 179/1eA
Charpy -30°C, V-notch Edgew 80*10*3 sp=62mm	14	kJ/m ²	ISO 179/1eA
Charpy 23°C, Unnotch Edgew 80*10*3 sp=62mm	NB	kJ/m ²	ISO 179/1eU
Charpy -30°C, Unnotch Edgew 80*10*3 sp=62mm	NB	kJ/m ²	ISO 179/1eU
THERMAL	Value	Unit	Standard
Vicat Softening Temp, Rate B/50	136	°C	ASTM D 1525
HDT, 0.45 MPa, 3.2 mm, unannealed	123	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	113	°C	ASTM D 648
CTE, -40°C to 40°C, flow	8.E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	8.E-05	1/°C	ASTM E 831
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	Value	Unit	Standard
Specific Gravity	1.2	-	ASTM D 792
Density	1.2	g/cm ³	ASTM D 792
Mold Shrinkage, flow, 3.2 mm (5)	0.5 - 0.7	%	SABIC Method
Melt Flow Rate, 300°C/1.2 kgf	18	g/10 min	ASTM D 1238
Density	1.2	g/cm ³	ISO 1183
Water Absorption, (23°C/sat)	0.3	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.15	%	ISO 62
Melt Volume Rate, MVR at 300°C/1.2 kg	17	cm ³ /10 min	ISO 1133
OPTICAL	Value	Unit	Standard
Light Transmission, 2.54 mm	88	%	ASTM D 1003
Haze, 2.54 mm	<1	%	ASTM D 1003
Refractive Index	1.582	-	ASTM D 542

Source GMD, last updated:2010/02/28

Processing

Parameter	Value	Unit
Injection Molding		
Drying Temperature	120	°C
Drying Time	3 - 4	hrs
Drying Time (Cumulative)	48	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	295 - 315	°C
Nozzle Temperature	290 - 310	°C
Front - Zone 3 Temperature	295 - 315	°C
Middle - Zone 2 Temperature	280 - 305	°C
Rear - Zone 1 Temperature	270 - 295	°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

Source GMD, last updated:2010/02/28

THESE PROPERTY VALUES ARE NOT INTENDED FOR SPECIFICATION PURPOSES.

PLEASE CHECK WITH YOUR [\(LOCAL SALES OFFICE\)](#) FOR AVAILABILITY IN YOUR REGION

(1) Typical values only. Variations within normal tolerances are possible for various colors. All values are measured after at least 48 hours storage at 23°C/50% relative humidity. All properties, except the melt volume and melt flow rates, are measured on injection molded samples. All samples tested under ISO test standards are prepared according to ISO 294.

(2) Only typical data for selection purposes. Not to be used for part or tool design.

(3) This rating is not intended to reflect hazards presented by this or any other material under actual fire conditions.

(4) Internal measurements according to UL standards.

(5) 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.

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