

4LEX® 10F10000

Polycarbonate
4Plas

Message:

4LEX 10F10000 is a MFI 10 to 14 Unfilled Polycarbonate

General Information			
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.24	g/cm ³	ISO 1183
Molding Shrinkage	0.50	%	ISO 2557
Water Absorption ¹ (Equilibrium, 23°C, 50% RH)	0.15	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	2350	MPa	ISO 527-2/5
Tensile Stress			ISO 527-2/5
Yield, 23°C	58.0	MPa	ISO 527-2/5
Fracture, 23°C	52.0	MPa	ISO 527-2/5
Tensile Strain			ISO 527-2/5
Yield, 23°C	8.0	%	ISO 527-2/5
Fracture, 23°C	93	%	ISO 527-2/5
Flexural Modulus ² (23°C)	2200	MPa	ISO 178
Flexural Stress	90.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	19	kJ/m ²	ISO 179/1eA
Notched Izod Impact			ISO 180/1A
-30°C	15	kJ/m ²	ISO 180/1A
23°C	60	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength (23°C)	No Break		ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (0.45 MPa, Unannealed)	144	°C	ISO 75-2/B
Vicat Softening Temperature	145	°C	ISO 306/B
Electrical	Nominal Value	Unit	Test Method
Comparative Tracking Index	200	V	IEC 60112
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.60 mm)	HB		UL 94
Glow Wire Flammability Index (2.00 mm)	870	°C	IEC 60695-2-12
Injection	Nominal Value	Unit	
Drying Temperature	120	°C	
Drying Time	3.0 - 4.0	hr	

Suggested Max Moisture	0.020	%
Processing (Melt) Temp	260 - 300	°C
Mold Temperature	80.0 - 100	°C
Injection Rate	Moderate-Fast	
Holding Pressure	60.0 - 120	MPa
Screw Speed	200	rpm

Injection instructions

Feed Throat Temperature: 60 - 80 °C Back Pressure: Low

NOTE

1. 24 Hrs
2. 2.0 mm/min

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