

4LEX® 9F22120 FR1

Polycarbonate
4Plas

Message:

4LEX 9F22120 FR1 is a Standard Flow 20% Glass Fibre Reinforced FR-V0 Polycarbonate

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 20% filler by weight		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.38	g/cm ³	ISO 1183
Molding Shrinkage			
Vertical flow direction	0.50	%	
Flow direction	0.50	%	
Water Absorption ¹ (Equilibrium, 23°C, 50% RH)	0.20	%	ISO 62
Moisture Content	< 1000	ppm	ISO 960
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	7000	MPa	ISO 527-2/5
Tensile Stress (Break, 23°C)	95.0	MPa	ISO 527-2/5
Tensile Strain (Break, 23°C)	2.5	%	ISO 527-2/5
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ISO 180/1A
-30°C	8.0	kJ/m ²	ISO 180/1A
23°C	10	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, not annealed	145	°C	ISO 75-2/B
1.8 MPa, not annealed	135	°C	ISO 75-2/A
Vicat Softening Temperature	145	°C	ISO 306/B
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+15	ohms	IEC 60093
Volume Resistivity	1.0E+15	ohms · cm	IEC 60093
Comparative Tracking Index	175	V	IEC 60112
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
0.750 mm	V-0		UL 94
1.60 mm	V-0		UL 94
Glow Wire Flammability Index (0.500 mm)	960	°C	IEC 60695-2-12
Glow Wire Ignition Temperature (2.00 mm)	925	°C	IEC 60695-2-13

Injection	Nominal Value	Unit
Drying Temperature	120	°C
Drying Time	3.0 - 4.0	hr
Suggested Max Moisture	0.020	%
Processing (Melt) Temp	270 - 310	°C
Mold Temperature	80.0 - 120	°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

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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China



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