

LEXAN™ 3412HF resin

Polycarbonate

SABIC Innovative Plastics

Message:

20% glass reinforced, high flow PC. UL rated V-1 at 0.059",

General Information			
UL YellowCard	E121562-220880		
Filler / Reinforcement	Glass Fiber,20% Filler by Weight		
Features	High Flow		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.34	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	8.5	g/10 min	ASTM D1238
Molding Shrinkage			Internal Method
Flow : 3.20 mm	0.20 to 0.40	%	
Across Flow : 3.20 mm	0.45 to 0.65	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ¹	3450	MPa	ASTM D638
Tensile Strength ²			ASTM D638
Yield	100	MPa	
Break	107	MPa	
Tensile Elongation ³ (Break)	4.0	%	ASTM D638
Flexural Modulus ⁴ (50.0 mm Span)	5520	MPa	ASTM D790
Flexural Strength ⁵			ASTM D790
Yield, 50.0 mm Span	157	MPa	
Break, 50.0 mm Span	165	MPa	
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	110	J/m	ASTM D256
Unnotched Izod Impact (23°C)	530	J/m	ASTM D4812
Instrumented Dart Impact (23°C, Total Energy)	3.39	J	ASTM D3763
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed, 3.20 mm	142	°C	
1.8 MPa, Unannealed, 3.20 mm	138	°C	
RTI Elec	80.0	°C	UL 746
RTI Imp	80.0	°C	UL 746
RTI Str	80.0	°C	UL 746
Flammability	Nominal Value		Test Method

Flame Rating		UL 94
1.50 mm	V-1	
3.00 mm	V-0	
Injection	Nominal Value	Unit
Drying Temperature	121	°C
Drying Time	3.0 to 4.0	hr
Drying Time, Maximum	48	hr
Suggested Max Moisture	0.020	%
Suggested Shot Size	40 to 60	%
Rear Temperature	293 to 316	°C
Middle Temperature	304 to 327	°C
Front Temperature	316 to 338	°C
Nozzle Temperature	310 to 332	°C
Processing (Melt) Temp	316 to 338	°C
Mold Temperature	82.2 to 116	°C
Back Pressure	0.345 to 0.689	MPa
Screw Speed	40 to 70	rpm
Vent Depth	0.025 to 0.076	mm
NOTE		
1.	5.0 mm/min	
2.	Type I, 5.0 mm/min	
3.	Type I, 5.0 mm/min	
4.	1.3 mm/min	
5.	1.3 mm/min	

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