

4LEX® 9F23100 XH

Polycarbonate
4Plas

Message:

4LEX 9F23100 XH is a MFI 20 to 22 FR-V0 UL Listed, Heat Stabilised Polycarbonate

General Information			
Additive	heat stabilizer		
Features	Thermal Stability		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.21	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	20	g/10 min	ISO 1133
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)	2500	MPa	ISO 527-2/5
Tensile Stress (Break, 23°C)	60.0	MPa	ISO 527-2/5
Tensile Strain (Break, 23°C)	25	%	ISO 527-2/5
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ISO 180/1A
-30°C	20	kJ/m ²	ISO 180/1A
23°C	50	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength			ISO 180/1U
-30°C	No Break		ISO 180/1U
23°C	No Break		ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, not annealed	140	°C	ISO 75-2/B
1.8 MPa, not annealed	120	°C	ISO 75-2/A
Vicat Softening Temperature	140	°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	225	V	IEC 60112
Flammability	Nominal Value	Unit	Test Method

Flame Rating			UL 94
1.60 mm	V-0		UL 94
3.20 mm	V-0		UL 94
Glow Wire Flammability Index (2.00 mm)	960	°C	IEC 60695-2-12
Glow Wire Ignition Temperature (2.00 mm)	875	°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	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 °CBack Pressure: Low			
NOTE			
1.	24 Hrs		

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