

LEXAN™ XHT1141 resin

Polycarbonate

SABIC Innovative Plastics

Message:

XHT1141 is a high flow, high heat polycarbonate copolymer. It is the lowest heat product in the LEXAN XHT portfolio. It is available in a range of opaque and limited transparent colors.

General Information			
Features	Copolymer		
	High liquidity		
	Heat resistance, high		
Appearance	Opacity		
	Available colors		
	Clear/transparent		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.20	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR)			ISO 1133
300°C/1.2 kg	16.0	cm ³ /10min	ISO 1133
330°C/2.16 kg	70.0	cm ³ /10min	ISO 1133
Molding Shrinkage - Flow (3.20 mm)	0.60 - 0.90	%	Internal method
Water Absorption			ISO 62
Saturated, 23°C	0.30	%	ISO 62
Equilibrium, 23°C, 50% RH	0.30	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2400	MPa	ISO 527-2/1
Tensile Stress			ISO 527-2/50
Yield	65.0	MPa	ISO 527-2/50
Fracture	60.0	MPa	ISO 527-2/50
Tensile Strain			ISO 527-2/50
Yield	6.5	%	ISO 527-2/50
Fracture	80	%	ISO 527-2/50
Flexural Modulus ¹	2400	MPa	ISO 178
Flexural Stress	100	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ²			ISO 179/1eA
-30°C	12	kJ/m ²	ISO 179/1eA
23°C	16	kJ/m ²	ISO 179/1eA

Charpy Unnotched Impact Strength ³			ISO 179/1eU
-30°C	No Break		ISO 179/1eU
23°C	No Break		ISO 179/1eU
Notched Izod Impact ⁴			ISO 180/1A
-30°C	10	kJ/m ²	ISO 180/1A
23°C	14	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength ⁵			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 ⁶			
0.45 MPa, unannealed, 64.0mm span	144	°C	ISO 75-2/Bf
1.8 MPa, unannealed, 64.0mm span	132	°C	ISO 75-2/Af
Vicat Softening Temperature			
--	150	°C	ISO 306/B50
--	152	°C	ISO 306/B120
Linear thermal expansion coefficient			ISO 11359-2
Flow: -40 to 40°C	7.0E-5	cm/cm/°C	ISO 11359-2
Lateral: -40 to 40°C	7.0E-5	cm/cm/°C	ISO 11359-2
Injection	Nominal Value	Unit	
Drying Temperature	125	°C	
Drying Time	4.0 - 6.0	hr	
Suggested Max Moisture	0.020	%	
Suggested Shot Size	40 - 60	%	
Rear Temperature	270 - 305	°C	
Middle Temperature	280 - 325	°C	
Front Temperature	290 - 335	°C	
Nozzle Temperature	285 - 330	°C	
Processing (Melt) Temp	290 - 335	°C	
Mold Temperature	85.0 - 130	°C	
Back Pressure	0.300 - 0.700	MPa	
Screw Speed	40 - 90	rpm	
Vent Depth	0.025 - 0.080	mm	
NOTE			
1.	2.0 mm/min		
2.	80*10*3 sp=62mm		
3.	80*10*3 sp=62mm		
4.	80*10*3		
5.	80*10*3		
6.	80*10*4 mm		

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