

LEXAN™ 3413HF resin

Polycarbonate
SABIC Innovative Plastics

Message:
30% glass reinforced, high flow PC.

General Information			
UL YellowCard	E121562-220882		
Filler / Reinforcement	Glass Fiber,30% Filler by Weight		
Features	High Flow		
Processing Method	Injection Molding		
Multi-Point Data	Viscosity vs. Shear Rate (ASTM D3835)		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.44	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/5.0 kg)	40	g/10 min	ASTM D1238
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Break)	100	MPa	ASTM D638
Tensile Elongation ² (Break)	2.0	%	ASTM D638
Flexural Modulus ³ (50.0 mm Span)	6620	MPa	ASTM D790
Flexural Strength ⁴ (Yield, 50.0 mm Span)	153	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	69	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 6.40 mm)	138	°C	ASTM D648
RTI Elec	80.0	°C	UL 746
RTI Imp	80.0	°C	UL 746
RTI Str	80.0	°C	UL 746
Electrical	Nominal Value	Test Method	
Comparative Tracking Index (CTI)	PLC 3	UL 746	
High Amp Arc Ignition (HAI)	PLC 4	UL 746	
Hot-wire Ignition (HWI)	PLC 1	UL 746	
Flammability	Nominal Value	Test Method	
Flame Rating			UL 94
1.47 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	288 to 310	°C
Middle Temperature	299 to 321	°C
Front Temperature	310 to 332	°C
Nozzle Temperature	304 to 327	°C
Processing (Melt) Temp	310 to 332	°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. | Type I, 5.0 mm/min |
| 2. | Type I, 5.0 mm/min |
| 3. | 1.3 mm/min |
| 4. | 1.3 mm/min |

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