

4LEX® 10F13301

Polycarbonate
4Plas

Message:

4LEX 10F13301 is a MFI 14 to 16 FR-V2 Polycarbonate

General Information			
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.20	g/cm ³	ISO 1183
Molding Shrinkage - Flow	0.50	%	
Water Absorption ¹ (Equilibrium, 23°C, 50% RH)	0.15	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	2500	MPa	ISO 527-2/5
Tensile Stress (Break, 23°C)	64.0	MPa	ISO 527-2/5
Tensile Strain (Break, 23°C)	93	%	ISO 527-2/5
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ISO 180/1A
-30°C	15	kJ/m ²	ISO 180/1A
23°C	45	kJ/m ²	ISO 180/1A
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	135	°C	ISO 75-2/A
Vicat Softening Temperature	148	°C	ISO 306/B
Melting Temperature ²	150	°C	ISO 11357
Electrical	Nominal Value	Unit	Test Method
Comparative Tracking Index	250	V	IEC 60112
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.60 mm)	V-2		UL 94
Glow Wire Ignition Temperature (2.00 mm)	850	°C	IEC 60695-2-13
Optical	Nominal Value	Unit	Test Method
Transmittance (3000 µm)	87.0 - 91.0	%	ASTM D1003
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
2.	10 K/min

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