

4LEX® 10F23100 X

Polycarbonate
4Plas

Message:

4LEX 10F23100 X is a MFI 20 to 22 FR-V0 UL Listed Polycarbonate

General Information			
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.20	g/cm ³	ISO 1183
Molding Shrinkage - Across 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)	2350	MPa	ISO 527-2/5
Tensile Stress (Break, 23°C)	60.0	MPa	ISO 527-2/5
Tensile Strain (Break, 23°C)	120	%	ISO 527-2/5
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ISO 180/1A
-30°C	10	kJ/m ²	ISO 180/1A
23°C	65	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, not annealed	136	°C	ISO 75-2/B
1.8 MPa, not annealed	135	°C	ISO 75-2/A
Glass Transition Temperature	145	°C	IEC 1006
Vicat Softening Temperature	148	°C	ISO 306/B
Melting Temperature ²	150	°C	ISO 11357
RTI Elec	80.0	°C	UL 746
RTI Imp	80.0	°C	UL 746
RTI	80.0	°C	UL 746
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+17	ohms · cm	IEC 60093
Dielectric Strength	17	kV/mm	ASTM D149
Arc Resistance	PLC 7		ASTM D495
Comparative Tracking Index (CTI)	PLC 3		UL 746
Comparative Tracking Index	250	V	IEC 60112
High Voltage Arc Tracking Rate (HVTR)	PLC 3		UL 746
Hot-wire Ignition (HWI)	PLC 2		UL 746
Flammability	Nominal Value	Unit	Test Method

Flame Rating (1.60 mm)	V-0	UL 94
Glow Wire Flammability Index (2.00 mm)	960	°C IEC 60695-2-12
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 °C Back Pressure: Low		
NOTE		
1.	24 Hrs	
2.	10 K/min	

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