

LEXAN™ HF1130R resin

Polycarbonate

SABIC Innovative Plastics Europe

Message:

PC, High Flow, Mold Release, UV-Stabilized

General Information			
UL YellowCard	E121562-101243762		
Additive	demoulding		
	UV stabilizer		
Features	High liquidity		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.20	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	25	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm)	0.50 - 0.70	%	Internal method
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ¹	2370	MPa	ASTM D638
Tensile Strength ²			ASTM D638
Yield	62.1	MPa	ASTM D638
Fracture	65.5	MPa	ASTM D638
Tensile Elongation ³			ASTM D638
Yield	6.0	%	ASTM D638
Fracture	110	%	ASTM D638
Flexural Modulus ⁴ (50.0 mm Span)	2310	MPa	ASTM D790
Flexural Strength ⁵ (Yield, 50.0 mm Span)	93.1	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	640	J/m	ASTM D256
Instrumented Dart Impact (23°C, Energy at Peak Load)	54.2	J	ASTM D3763
Tensile Impact Strength ⁶	378	kJ/m ²	ASTM D1822
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 6.40 mm)	127	°C	ASTM D648
Linear thermal expansion coefficient			ASTM E831
Flow: -40 to 40°C	7.0E-5	cm/cm/°C	ASTM E831
Lateral: -40 to 40°C	6.8E-5	cm/cm/°C	ASTM E831
Optical	Nominal Value	Unit	Test Method
Transmittance (2540 µm)	88.0	%	ASTM D1003
Haze (2540 µm)	1.0	%	ASTM D1003

Injection	Nominal Value	Unit
Drying Temperature	121	°C
Drying Time	3.0 - 4.0	hr
Drying Time, Maximum	48	hr
Suggested Max Moisture	0.020	%
Suggested Shot Size	40 - 60	%
Rear Temperature	249 - 271	°C
Middle Temperature	260 - 282	°C
Front Temperature	271 - 293	°C
Nozzle Temperature	266 - 288	°C
Processing (Melt) Temp	271 - 293	°C
Mold Temperature	71.1 - 93.3	°C
Back Pressure	0.345 - 0.689	MPa
Screw Speed	40 - 70	rpm
Vent Depth	0.025 - 0.076	mm

NOTE

- | | |
|----|------------------|
| 1. | 5.0 mm/min |
| 2. | Type 1, 50mm/min |
| 3. | Type 1, 50mm/min |
| 4. | 1.3 mm/min |
| 5. | 1.3 mm/min |
| 6. | Type S |

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