

LEXAN™ HPX8R resin

Polycarbonate
SABIC Innovative Plastics

Message:

Very high flow specialty polycarbonate with outstanding processability and ductility. For medical devices and pharmaceutical applications. Healthcare management of change, biocompatible (ISO10993 or USP Class VI). ETO sterilizable. Contains mold release.

General Information			
Additive	demoulding		
Features	Ethylene oxide disinfection		
	Workability, good		
	High liquidity		
	Biocompatibility		
	ductility		
Uses	Drug		
	Medical/nursing supplies		
Agency Ratings	ISO 10993		
	USP Class VI		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.19	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	35	g/10 min	ASTM D1238
Melt Volume-Flow Rate (MVR) (300°C/1.2 kg)	33.0	cm ³ /10min	ISO 1133
Molding Shrinkage			Internal method
Flow: 3.20mm	0.40 - 0.80	%	Internal method
Transverse flow: 3.20mm	0.40 - 0.80	%	Internal method
Water Absorption			ISO 62
Saturated, 23°C	0.12	%	ISO 62
Equilibrium, 23°C, 50% RH	0.093	%	ISO 62
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (L-Scale)	90		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	2370	MPa	ASTM D638
--	2400	MPa	ISO 527-2/1
Tensile Strength			
Yield ²	60.0	MPa	ASTM D638

Yield	59.0	MPa	ISO 527-2/50
Fracture ³	58.0	MPa	ASTM D638
Fracture	56.6	MPa	ISO 527-2/50
Tensile Elongation			
Yield ⁴	5.8	%	ASTM D638
Yield	5.4	%	ISO 527-2/50
Fracture ⁵	120	%	ASTM D638
Fracture	120	%	ISO 527-2/50
Flexural Modulus			
50.0mm span ⁶	2360	MPa	ASTM D790
-- ⁷	2250	MPa	ISO 178
Flexural Stress			
--	92.9	MPa	ISO 178
Yield, 50.0mm span ⁸	99.2	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ⁹			ISO 179/1eA
-30°C	30	kJ/m ²	ISO 179/1eA
23°C	60	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength ¹⁰			ISO 179/1eU
-30°C	No Break		ISO 179/1eU
23°C	No Break		ISO 179/1eU
Notched Izod Impact			
-30°C	220	J/m	ASTM D256
23°C	700	J/m	ASTM D256
-30°C ¹¹	30	kJ/m ²	ISO 180/1A
23°C ¹²	60	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength ¹³			ISO 180/1U
-30°C	No Break		ISO 180/1U
23°C	No Break		ISO 180/1U
Instrumented Dart Impact (23°C, Total Energy)	79.0	J	ASTM D3763
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
1.8 MPa, unannealed, 3.20mm	121	°C	ASTM D648
1.8 MPa, unannealed, 64.0mm span ¹⁴	118	°C	ISO 75-2/Af
Vicat Softening Temperature			
--	138	°C	ASTM D1525, ISO 306/B50 10 ¹⁵
--	140	°C	ISO 306/B120
Ball Pressure Test (125°C)	Pass		IEC 60695-10-2
Linear thermal expansion coefficient			
Flow: -40 to 95°C	6.5E-5	cm/cm/°C	ASTM E831
Flow: 23 to 80°C	6.5E-5	cm/cm/°C	ISO 11359-2

Lateral: -40 to 95°C	7.4E-5	cm/cm/°C	ASTM E831
Lateral: 23 to 80°C	7.4E-5	cm/cm/°C	ISO 11359-2
RTI Elec	130	°C	UL 746
RTI	130	°C	UL 746
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	> 1.0E+15	ohms	ASTM D257
Volume Resistivity	> 1.0E+15	ohms·cm	ASTM D257
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.50 mm)	HB		UL 94
Glow Wire Flammability Index (3.00 mm)	960	°C	IEC 60695-2-12
Glow Wire Ignition Temperature			IEC 60695-2-13
0.800 mm	825	°C	IEC 60695-2-13
3.00 mm	850	°C	IEC 60695-2-13
Optical	Nominal Value	Unit	Test Method
Transmittance (2540 µm)	82.0	%	ASTM D1003
Haze (2540 µm)	3.0	%	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	271 - 293	°C	
Middle Temperature	282 - 304	°C	
Front Temperature	293 - 316	°C	
Nozzle Temperature	288 - 310	°C	
Processing (Melt) Temp	293 - 316	°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.	50 mm/min		
2.	Type 1, 50mm/min		
3.	Type 1, 50mm/min		
4.	Type 1, 50mm/min		
5.	Type 1, 50mm/min		
6.	1.3 mm/min		
7.	2.0 mm/min		
8.	1.3 mm/min		
9.	80*10*3 sp=62mm		
10.	80*10*3 sp=62mm		

11.	80*10*3
12.	80*10*3
13.	80*10*3
14.	80*10*4 mm
15.	速率 A (50°C/h), 载荷2 (50N)

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