

LEXAN™ RESIN HF1 130

REGION AMERICAS

DESCRIPTION

LEXAN™ HF1 130 resin is a 25 MFR polycarbonate. UV stabilized. UL94 V2 rated.

TYPICAL PROPERTY VALUES

Revision 20250424

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	62	MPa	ASTM D638
Tensile Stress, brk, Type I, 50 mm/min	65	MPa	ASTM D638
Tensile Strain, brk, Type I, 50 mm/min	110	%	ASTM D638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	93	MPa	ASTM D790
Flexural Modulus, 1.3 mm/min, 50 mm span	2300	MPa	ASTM D790
IMPACT			
Izod Impact, notched, 23°C	640	J/m	ASTM D256
Tensile Impact Strength, Type S	378	kJ/m²	ASTM D1822
Instrumented Dart Impact Energy @ peak, 23°C	54	J	ASTM D3763
THERMAL			
HDT, 1.82 MPa, 6.4 mm, unannealed	126	°C	ASTM D648
Relative Temp Index, Elec	130	°C	UL 746B
Relative Temp Index, Mech w/impact	130	°C	UL 746B
Relative Temp Index, Mech w/o impact	130	°C	UL 746B
PHYSICAL			
Specific Gravity	1.2	-	ASTM D792
Mold Shrinkage, flow, 3.2 mm	0.5 – 0.7	%	SABIC method
Melt Flow Rate, 300°C/1.2 kgf	25	g/10 min	ASTM D1238
OPTICAL			
Light Transmission, 2.54 mm	88	%	ASTM D1003
Haze, 2.54 mm	1	%	ASTM D1003
FLAME CHARACTERISTICS			
UL Yellow Card Link	E121562-220946	-	-
UL Recognized, 94V-2 Flame Class Rating	1.2	mm	UL 94
INJECTION MOLDING			
Drying Temperature	120	°C	
Drying Time	3 – 4	Hrs	
Drying Time (Cumulative)	48	Hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	270 – 295	°C	
Nozzle Temperature	265 – 290	°C	
Front - Zone 3 Temperature	270 – 295	°C	
Middle - Zone 2 Temperature	260 – 280	°C	
Rear - Zone 1 Temperature	250 – 270	°C	
Mold Temperature	70 – 95	°C	

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Back Pressure	0.3 – 0.7	MPa	
Screw Speed	40 – 70	rpm	
Shot to Cylinder Size	40 – 60	%	
Vent Depth	0.025 – 0.076	mm	

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