

LEXAN™ RESIN HF4010SR

REGION EUROPE

DESCRIPTION

LEXAN™ HF4010SR resin is an excellent flow 42 MFR polycarbonate, MVR of 40. Superior release. High gloss. Suitable for large parts and thin wall molding. Available in opaque colors.

TYPICAL PROPERTY VALUES

Revision 20230131

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yield, 50 mm/min	63	MPa	ISO 527
Tensile Stress, break, 50 mm/min	50	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	5.5	%	ISO 527
Tensile Strain, break, 50 mm/min	67	%	ISO 527
Tensile Modulus, 1 mm/min	2350	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	90	MPa	ISO 178
Flexural Modulus, 2 mm/min	2300	MPa	ISO 178
Ball Indentation Hardness, H358/30	130	MPa	ISO 2039-1
IMPACT			
Izod Impact, unnotched 80*10*3 +23°C	NB	kJ/m ²	ISO 180/1U
Izod Impact, unnotched 80*10*3 -30°C	NB	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*3 +23°C	40	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*3 -30°C	12	kJ/m ²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*3 sp=62mm	45	kJ/m ²	ISO 179/1eA
Charpy -30°C, V-notch Edgew 80*10*3 sp=62mm	13	kJ/m ²	ISO 179/1eA
THERMAL			
CTE, 23°C to 80°C, flow	7.E-05	1/°C	ISO 11359-2
Ball Pressure Test, 125°C +/- 2°C	PASSES	-	IEC 60695-10-2
Vicat Softening Temp, Rate A/50	144	°C	ISO 306
Vicat Softening Temp, Rate B/50	138	°C	ISO 306
HDT/Be, 0.45MPa Edgew 120*10*4 sp=100mm	134	°C	ISO 75/Be
HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm	121	°C	ISO 75/Ae
PHYSICAL			
Mold Shrinkage on Tensile Bar, flow	0.5 – 0.7	%	SABIC method
Density	1.2	g/cm ³	ISO 1183
Moisture Absorption (23°C / 50% RH)	0.11	%	ISO 62
Melt Volume Rate, MVR at 300°C/1.2 kg	40	cm ³ /10 min	ISO 1133
ELECTRICAL			
Volume Resistivity	>1.10E+17	Ω.cm	ASTM D257
Surface Resistivity	>1.10E+17	Ω	ASTM D257
INJECTION MOLDING			
Drying Temperature	120	°C	
Drying Time	2 – 4	Hrs	
Maximum Moisture Content	0.02	%	

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Melt Temperature	280 – 300	°C	
Nozzle Temperature	270 – 290	°C	
Front - Zone 3 Temperature	280 – 300	°C	
Middle - Zone 2 Temperature	270 – 290	°C	
Rear - Zone 1 Temperature	260 – 280	°C	
Hopper Temperature	60 – 80	°C	
Mold Temperature	80 – 100	°C	

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