

LEXAN™ COPOLYMER HFD4211

REGION EUROPE

DESCRIPTION

LEXAN HFD4211 is a 10% glass filled, injection moldable grade designed for high flow and superior surface appearance. Internal mold release.

TYPICAL PROPERTY VALUES

Revision 20170913

| PROPERTIES | TYPICAL VALUES | UNITS | TEST METHODS |
|--|----------------|-------------------|--------------|
| MECHANICAL | | | |
| Tensile Stress, yld, Type I, 5 mm/min | 60 | MPa | ASTM D 638 |
| Tensile Stress, brk, Type I, 5 mm/min | 46 | MPa | ASTM D 638 |
| Tensile Strain, yld, Type I, 5 mm/min | 3.1 | % | ASTM D 638 |
| Tensile Modulus, 5 mm/min | 4120 | MPa | ASTM D 638 |
| Flexural Stress, yld, 1.3 mm/min, 50 mm span | 102 | MPa | ASTM D 790 |
| Flexural Modulus, 1.3 mm/min, 50 mm span | 3690 | MPa | ASTM D 790 |
| Tensile Stress, yield, 5 mm/min | 68 | MPa | ISO 527 |
| Tensile Stress, break, 5 mm/min | 59 | MPa | ISO 527 |
| Tensile Strain, yield, 5 mm/min | 2.7 | % | ISO 527 |
| Tensile Strain, break, 5 mm/min | 3.2 | % | ISO 527 |
| IMPACT | | | |
| Izod Impact, unnotched, 23°C | 1260 | J/m | ASTM D 4812 |
| Izod Impact, notched, 23°C | 120 | J/m | ASTM D 256 |
| Instrumented Impact Total Energy, 23°C | 50 | J | ASTM D 3763 |
| Izod Impact, unnotched 80*10*3 +23°C | 64 | kJ/m ² | ISO 180/1U |
| Izod Impact, unnotched 80*10*3 -30°C | 60 | kJ/m ² | ISO 180/1U |
| Izod Impact, notched 80*10*3 +23°C | 6 | kJ/m ² | ISO 180/1A |
| Izod Impact, notched 80*10*3 -30°C | 6 | kJ/m ² | ISO 180/1A |
| Charpy 23°C, V-notch Edgew 80*10*3 sp=62mm | 6 | kJ/m ² | ISO 179/1eA |
| Charpy -30°C, V-notch Edgew 80*10*3 sp=62mm | 7 | kJ/m ² | ISO 179/1eA |
| Charpy 23°C, Unnotch Edgew 80*10*3 sp=62mm | 75 | kJ/m ² | ISO 179/1eU |
| Charpy -30°C, Unnotch Edgew 80*10*3 sp=62mm | 81 | kJ/m ² | ISO 179/1eU |
| THERMAL | | | |
| HDT, 0.45 MPa, 3.2 mm, unannealed | 129 | °C | ASTM D 648 |

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| HDT, 1.82 MPa, 3.2mm, unannealed | 123 | °C | ASTM D 648 |
| CTE, -40°C to 40°C, flow | 4.E-05 | 1/°C | ASTM E 831 |
| CTE, -40°C to 40°C, xflow | 8.E-05 | 1/°C | ASTM E 831 |
| CTE, 23°C to 80°C, flow | 4.E-05 | 1/°C | ISO 11359-2 |
| CTE, 23°C to 80°C, xflow | 8.E-05 | 1/°C | ISO 11359-2 |
| Ball Pressure Test, 125°C +/- 2°C | PASSES | - | IEC 60695-10-2 |
| Vicat Softening Temp, Rate B/120 | 141 | °C | ISO 306 |
| HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm | 126 | °C | ISO 75/Af |
| Relative Temp Index, Elec | 80 | °C | UL 746B |
| Relative Temp Index, Mech w/impact | 80 | °C | UL 746B |
| Relative Temp Index, Mech w/o impact | 80 | °C | UL 746B |
| PHYSICAL | | | |
| Specific Gravity | 1.27 | - | ASTM D 792 |
| Mold Shrinkage, flow, 3.2 mm (5) | 0.2 – 0.4 | % | SABIC method |
| Mold Shrinkage, xflow, 3.2 mm (5) | 0.2 – 0.4 | % | SABIC method |
| Melt Flow Rate, 300°C/1.2 kgf | 18 | g/10 min | ASTM D 1238 |
| Density | 1.25 | g/cm ³ | ISO 1183 |
| Water Absorption, (23°C/sat) | 0.3 | % | ISO 62 |
| Moisture Absorption (23°C / 50% RH) | 0.12 | % | ISO 62 |
| Melt Volume Rate, MVR at 300°C/1.2 kg | 12 | cm ³ /10 min | ISO 1133 |
| FLAME CHARACTERISTICS | | | |
| UL Recognized, 94HB Flame Class Rating (3) | 0.3 | mm | UL 94 |
| Glow Wire Flammability Index 960°C, passes at | 1 | mm | IEC 60695-2-12 |
| Glow Wire Ignitability Temperature, 1.0 mm | 850 | °C | IEC 60695-2-13 |
| INJECTION MOLDING | | | |
| Drying Temperature | 120 | °C | |
| Drying Time | 3 – 4 | hrs | |
| Drying Time (Cumulative) | 48 | hrs | |
| Maximum Moisture Content | 0.02 | % | |
| Melt Temperature | 290 – 310 | °C | |
| Nozzle Temperature | 280 – 305 | °C | |
| Front - Zone 3 Temperature | 290 – 310 | °C | |
| Middle - Zone 2 Temperature | 275 – 300 | °C | |
| Rear - Zone 1 Temperature | 265 – 290 | °C | |
| Mold Temperature | 70 – 95 | °C | |
| Back Pressure | 0.3 – 0.7 | MPa | |
| Screw Speed | 40 – 70 | rpm | |
| Shot to Cylinder Size | 40 – 60 | % | |

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| Vent Depth | 0.025 – 0.076 | mm | |

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