

## Lexan\* Resin HF1130

Americas: COMMERCIAL

UV-stabilized. Good clarity, heat resistance, property retention and dimensional stability.

### Property

TYPICAL PROPERTIES <sup>(1)</sup>			
MECHANICAL	Value	Unit	Standard
Tensile Stress, yld, Type I, 50 mm/min	62	MPa	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	65	MPa	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	110	%	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	93	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	2300	MPa	ASTM D 790
IMPACT	Value	Unit	Standard
Izod Impact, notched, 23°C	640	J/m	ASTM D 256
Tensile Impact, Type "S"	378	kJ/m <sup>2</sup>	ASTM D 1822
Instrumented Impact Energy @ peak, 23°C	54	J	ASTM D 3763
THERMAL	Value	Unit	Standard
HDT, 1.82 MPa, 6.4 mm, unannealed	126	°C	ASTM D 648
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	Value	Unit	Standard
Specific Gravity	1.2	-	ASTM D 792
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 D 1238
OPTICAL	Value	Unit	Standard
Light Transmission	88	%	ASTM D 1003
Haze	1	%	ASTM D 1003
FLAME CHARACTERISTICS	Value	Unit	Standard
UL Recognized, 94V-2 Flame Class Rating (3)	1.2	mm	UL 94
CSA (See File for complete listing)	LS88480	File No.	CSA LISTED

Source GMD, last updated:01/04/2000

### Processing

Parameter	Value	Unit
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

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

Source GMD, last updated:01/04/2000

THESE PROPERTY VALUES ARE NOT INTENDED FOR SPECIFICATION PURPOSES.

PLEASE CHECK WITH YOUR [\(LOCAL SALES OFFICE\)](#) FOR AVAILABILITY IN YOUR REGION

(1) Typical values only. Variations within normal tolerances are possible for various colors. All values are measured after at least 48 hours storage at 23°C/50% relative humidity. All properties, except the melt volume and melt flow rates, are measured on injection molded samples. All samples tested under ISO test standards are prepared according to ISO 294.

(2) Only typical data for selection purposes. Not to be used for part or tool design.

(3) This rating is not intended to reflect hazards presented by this or any other material under actual fire conditions.

(4) Internal measurements according to UL standards.

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