

# 4LEX® 10F13100

Polycarbonate  
4Plas

Message:

4LEX 10F13100 is a MFI 14 to 16 FR-V0 Polycarbonate

| General Information                                       |                   |                   |                |
|-----------------------------------------------------------|-------------------|-------------------|----------------|
| Processing Method                                         | Injection molding |                   |                |
| Physical                                                  | Nominal Value     | Unit              | Test Method    |
| Density                                                   | 1.24              | g/cm <sup>3</sup> | ISO 1183       |
| Molding Shrinkage - Flow                                  | 0.50              | %                 |                |
| Water Absorption <sup>1</sup> (Equilibrium, 23°C, 50% RH) | 0.15              | %                 | ISO 62         |
| Mechanical                                                | Nominal Value     | Unit              | Test Method    |
| Tensile Modulus (23°C)                                    | 2500              | MPa               | ISO 527-2/5    |
| Tensile Stress (Break, 23°C)                              | 66.0              | MPa               | ISO 527-2/5    |
| Tensile Strain (Break, 23°C)                              | 93                | %                 | ISO 527-2/5    |
| Impact                                                    | Nominal Value     | Unit              | Test Method    |
| Notched Izod Impact                                       |                   |                   | ISO 180/1A     |
| -30°C                                                     | 15                | kJ/m <sup>2</sup> | ISO 180/1A     |
| -20°C                                                     | 15                | kJ/m <sup>2</sup> | ISO 180/1A     |
| 23°C                                                      | 50                | kJ/m <sup>2</sup> | ISO 180/1A     |
| Thermal                                                   | Nominal Value     | Unit              | Test Method    |
| Heat Deflection Temperature                               |                   |                   |                |
| 0.45 MPa, not annealed                                    | 144               | °C                | ISO 75-2/B     |
| 1.8 MPa, not annealed                                     | 133               | °C                | ISO 75-2/A     |
| Vicat Softening Temperature                               | 140               | °C                | ISO 306/B      |
| Ball Indentation Temperature                              | 125               | °C                | IEC 335        |
| Electrical                                                | Nominal Value     | Unit              | Test Method    |
| Comparative Tracking Index                                | 225               | V                 | IEC 60112      |
| Flammability                                              | Nominal Value     | Unit              | Test Method    |
| Flame Rating (1.60 mm)                                    | V-0               |                   | UL 94          |
| Glow Wire Flammability Index (2.00 mm)                    | 960               | °C                | IEC 60695-2-12 |
| Glow Wire Ignition Temperature (2.00 mm)                  | 875               | °C                | IEC 60695-2-13 |
| Injection                                                 | Nominal Value     | Unit              |                |
| Drying Temperature                                        | 120               | °C                |                |
| Drying Time                                               | 3.0 - 4.0         | hr                |                |
| Suggested Max Moisture                                    | 0.020             | %                 |                |
| Processing (Melt) Temp                                    | 260 - 300         | °C                |                |
| Mold Temperature                                          | 80.0 - 100        | °C                |                |

|                  |               |     |
|------------------|---------------|-----|
| Injection Rate   | Moderate-Fast |     |
| Holding Pressure | 60.0 - 120    | MPa |
| Screw Speed      | < 200         | rpm |

Injection instructions

Feed Throat Temperature: 60 - 80 °CBack Pressure: Low

NOTE

1.
- 24 Hrs

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Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519  
Phone: +86 13424755533  
Email: sales@su-jiao.com  
No. 215, Lianhe North Road, Fengxian District, Shanghai, China

