

LEXAN™ HF1110 resin

Polycarbonate

SABIC Innovative Plastics

Message:

General purpose grade. Good clarity, heat resistance, property retention and dimensional stability.

General Information			
UL YellowCard	E45587-236896	E207780-228431	
Features	Good dimensional stability		
	Heat resistance, high		
	General		
	Medium transparency		
Uses	General		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.20	g/cm³	ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	25	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm)	0.50 - 0.70	%	Internal method
Water Absorption			ASTM D570
24 hr	0.10	%	ASTM D570
Equilibrium, 23°C	0.35	%	ASTM D570
Equilibrium, 100°C	0.58	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹			ASTM D638
Yield	62.1	MPa	ASTM D638
Fracture	65.5	MPa	ASTM D638
Tensile Elongation ² (Break)	120	%	ASTM D638
Flexural Modulus ³ (50.0 mm Span)	2310	MPa	ASTM D790
Flexural Strength ⁴ (Yield, 50.0 mm Span)	93.1	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	640	J/m	ASTM D256
Instrumented Dart Impact (23°C, Energy at Peak Load)	54.2	J	ASTM D3763
Tensile Impact Strength ⁵	378	kJ/m²	ASTM D1822
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 3.20 mm)	127	°C	ASTM D648
RTI Elec	130	°C	UL 746
RTI Imp	130	°C	UL 746
RTI	130	°C	UL 746

Electrical	Nominal Value		Test Method
Comparative Tracking Index (CTI)	PLC 2		UL 746
High Amp Arc Ignition (HAI)	PLC 1		UL 746
High Voltage Arc Tracking Rate (HVTR)	PLC 2		UL 746
Hot-wire Ignition (HWI)	PLC 2		UL 746
Flammability	Nominal Value		Test Method
Flame Rating (1.09 mm)	V-2		UL 94
Optical	Nominal Value	Unit	Test Method
Transmittance (2540 μm)	88.0	%	ASTM D1003
Haze (2540 μm)	1.0	%	ASTM D1003
Injection	Nominal Value	Unit	
Drying Temperature	121	°C	
Drying Time	3.0 - 4.0	hr	
Drying Time, Maximum	48	hr	
Suggested Max Moisture	0.020	%	
Suggested Shot Size	40 - 60	%	
Rear Temperature	249 - 271	°C	
Middle Temperature	260 - 282	°C	
Front Temperature	271 - 293	°C	
Nozzle Temperature	266 - 288	°C	
Processing (Melt) Temp	271 - 293	°C	
Mold Temperature	71.1 - 93.3	°C	
Back Pressure	0.345 - 0.689	MPa	
Screw Speed	40 - 70	rpm	
Vent Depth	0.025 - 0.076	mm	
NOTE			
1.	Type 1, 50mm/min		
2.	Type 1, 50mm/min		
3.	1.3 mm/min		
4.	1.3 mm/min		
5.	Type S		

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