

4LEX® 10F13900

Polycarbonate
4Plas

Message:

4LEX 10F13900 is a MFI 14 to 16 FR-5VB Polycarbonate

General Information			
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.20	g/cm ³	ISO 1183
Molding Shrinkage			
Vertical flow direction	0.50 - 0.70	%	
Flow direction	0.50 - 0.70	%	
Water Absorption ¹ (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)	65.0	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 ²	ISO 180/1A
23°C	20	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, not annealed	136	°C	ISO 75-2/B
1.8 MPa, not annealed	130	°C	ISO 75-2/A
Vicat Softening Temperature	136	°C	ISO 306/B
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
	V-0		
1.60 mm	5VB		UL 94
	V-0		
3.20 mm	5VA		UL 94
Glow Wire Flammability Index (2.00 mm)	960	°C	IEC 60695-2-12
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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