



# LEXANT™ RESIN HF35 10R

REGION EUROPE

## DESCRIPTION

LEXANT™ HF35 10R resin is a 39 MFR polycarbonate, MVR of 34. Mold release. Easy processing. Suitable for automotive applications, including bezels. Available only in opaque colors.

## TYPICAL PROPERTY VALUES

Revision 20230321

| PROPERTIES                                   | TYPICAL VALUES | UNITS | TEST METHODS |
|----------------------------------------------|----------------|-------|--------------|
| MECHANICAL                                   |                |       |              |
| Tensile Stress, yld, Type I, 50 mm/min       | 62             | MPa   | ASTM D638    |
| Tensile Stress, brk, Type I, 50 mm/min       | 58             | MPa   | ASTM D638    |
| Tensile Strain, yld, Type I, 50 mm/min       | 6              | %     | ASTM D638    |
| Tensile Strain, brk, Type I, 50 mm/min       | 110            | %     | ASTM D638    |
| Tensile Modulus, 50 mm/min                   | 2400           | MPa   | ASTM D638    |
| Flexural Stress, yld, 1.3 mm/min, 50 mm span | 100            | MPa   | ASTM D790    |
| Flexural Modulus, 1.3 mm/min, 50 mm span     | 2400           | MPa   | ASTM D790    |
| Tensile Stress, yield, 50 mm/min             | 60             | MPa   | ISO 527      |
| Tensile Stress, break, 50 mm/min             | 55             | MPa   | ISO 527      |
| Tensile Strain, yield, 50 mm/min             | 6              | %     | ISO 527      |
| Tensile Strain, break, 50 mm/min             | 100            | %     | ISO 527      |
| Tensile Modulus, 1 mm/min                    | 2300           | MPa   | ISO 527      |
| Flexural Stress, yield, 2 mm/min             | 85             | MPa   | ISO 178      |
| Flexural Modulus, 2 mm/min                   | 2300           | MPa   | ISO 178      |
| IMPACT                                       |                |       |              |
| Izod Impact, notched, 23°C                   | 690            | J/m   | ASTM D256    |
| Izod Impact, notched, -30°C                  | 55             | J/m   | ASTM D256    |
| Instrumented Dart Impact Total Energy, 23°C  | 66             | J     | ASTM D3763   |
| Izod Impact, notched 80°10°4 +23°C           | 12             | kJ/m² | ISO 180/1A   |
| Izod Impact, notched 80°10°4 -30°C           | 4              | kJ/m² | ISO 180/1A   |
| Charpy 23°C, V-notch Edgew 80°10°4 sp=62mm   | 12             | kJ/m² | ISO 179/1eA  |
| Charpy -30°C, V-notch Edgew 80°10°4 sp=62mm  | 5              | kJ/m² | ISO 179/1eA  |
| Izod Impact, notched 80°10°3 +23°C           | 55             | kJ/m² | ISO 180/1A   |
| Izod Impact, notched 80°10°3 -30°C           | 11             | kJ/m² | ISO 180/1A   |
| Charpy 23°C, V-notch Edgew 80°10°3 sp=62mm   | 55             | kJ/m² | ISO 179/1eA  |
| Charpy -30°C, V-notch Edgew 80°10°3 sp=62mm  | 11             | kJ/m² | ISO 179/1eA  |
| Charpy 23°C, Unnotch Edgew 80°10°3 sp=62mm   | NB             | kJ/m² | ISO 179/1eU  |
| Charpy -30°C, Unnotch Edgew 80°10°3 sp=62mm  | NB             | kJ/m² | ISO 179/1eU  |
| THERMAL                                      |                |       |              |
| Vicat Softening Temp, Rate B/50              | 139            | °C    | ASTM D1525   |
| HDT, 0.45 MPa, 3.2 mm, unannealed            | 135            | °C    | ASTM D648    |
| HDT, 1.82 MPa, 3.2mm, unannealed             | 124            | °C    | ASTM D648    |
| CTE, -40°C to 40°C, flow                     | 7.2E-05        | 1/°C  | ASTM E831    |
| CTE, -40°C to 40°C, xflow                    | 7.8E-05        | 1/°C  | ASTM E831    |



| PROPERTIES                              | TYPICAL VALUES | UNITS       | TEST METHODS   |
|-----------------------------------------|----------------|-------------|----------------|
| CTE, -40°C to 40°C, xflow               | 7.8E-05        | 1 / °C      | ISO 11359-2    |
| Thermal Conductivity                    | 0.2            | W/m-°C      | ISO 8302       |
| CTE, 23°C to 80°C, flow                 | 7.0E-05        | 1 / °C      | ISO 11359-2    |
| Ball Pressure Test, 125°C +/- 2°C       | PASSES         | -           | IEC 60695-10-2 |
| Vicat Softening Temp, Rate B/50         | 139            | °C          | ISO 306        |
| Vicat Softening Temp, Rate B/120        | 140            | °C          | ISO 306        |
| HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm  | 130            | °C          | ISO 75 /Bf     |
| HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm   | 122            | °C          | ISO 75 /Af     |
| HDT/Be, 0.45MPa Edgew 120*10*4 sp=100mm | 133            | °C          | ISO 75 /Be     |
| HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm | 121            | °C          | ISO 75 /Ae     |
| PHYSICAL                                |                |             |                |
| Specific Gravity                        | 1.2            | -           | ASTM D792      |
| Mold Shrinkage, flow, 3.2 mm            | 0.5 – 0.7      | %           | SABIC method   |
| Mold Shrinkage, xflow, 3.2 mm           | 0.5 – 0.7      | %           | SABIC method   |
| Melt Flow Rate, 300°C/ 1.2 kgf          | 36             | g/ 10 min   | ASTM D1238     |
| Mold Shrinkage on Tensile Bar, flow     | 0.5 – 0.7      | %           | SABIC method   |
| Density                                 | 1.2            | g/ cm³      | ISO 1183       |
| Water Absorption, (23°C/saturated)      | 0.3            | %           | ISO 62-1       |
| Moisture Absorption (23°C / 50% RH)     | 0.1            | %           | ISO 62         |
| Melt Volume Rate, MVR at 300°C/ 1.2 kg  | 34             | cm³/ 10 min | ISO 1133       |
| 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          |                |
| Hopper Temperature                      | 60 – 80        | °C          |                |
| Mold Temperature                        | 80 – 100       | °C          |                |

DISCLAIMER

Any sale by SABIC, its subsidiaries and affiliates (each a "seller"), is made exclusively under seller's standard conditions of sale (available upon request) unless agreed otherwise in writing and signed on behalf of the seller. While the information contained herein is given in good faith, SELLER MAKES NO WARRANTY, EXPRESS OR IMPLIED, INCLUDING MERCHANTABILITY AND NONINFRINGEMENT OF INTELLECTUAL PROPERTY, NOR ASSUMES ANY LIABILITY, DIRECT OR INDIRECT, WITH RESPECT TO THE PERFORMANCE, SUITABILITY OR FITNESS FOR INTENDED USE OR PURPOSE OF THESE PRODUCTS IN ANY APPLICATION. Each customer must determine the suitability of seller materials for the customer's particular use through appropriate testing and analysis. No statement by seller concerning a possible use of any product, service or design is intended, or should be construed, to grant any license under any patent or other intellectual property right.