



LEXANT[™] HEALTHCARE RESIN HP1 HF

REGION ASIA

DESCRIPTION

LEXANT[™] HP1 HF resin is a 39 MFR polycarbonate, MVR of 36. Mold release. Biocompatible (ISO10993 or USP Class VI) grade for medical devices and pharmaceutical applications. It is EtO sterilizable. Subject to SABIC healthcare management of change process.

TYPICAL PROPERTY VALUES

Revision 20201125

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	63	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	108	%	ASTM D638
Tensile Modulus, 50 mm/min	2410	MPa	ASTM D638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	102	MPa	ASTM D790
Flexural Modulus, 1.3 mm/min, 50 mm span	2410	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	5.7	%	ISO 527
Tensile Strain, break, 50 mm/min	110	%	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			
Charpy Impact, unnotched, -30°C	5	kJ/m ²	ISO 179/2C
Izod Impact, notched, 23°C	687	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, unnotched 80*10*3 +23°C	NB	kJ/m ²	ISO 180/1U
Izod Impact, unnotched 80*10*3 -30°C	NB	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*3 +23°C	60	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*3 -30°C	10	kJ/m ²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*3 sp=62mm	65	kJ/m ²	ISO 179/1eA
Charpy -30°C, V-notch Edgew 80*10*3 sp=62mm	10	kJ/m ²	ISO 179/1eA
Charpy 23°C, Unnotch Edgew 80*10*3 sp=62mm	NB	kJ/m ²	ISO 179/1eU
Charpy -30°C, Unnotch Edgew 80*10*3 sp=62mm	NB	kJ/m ²	ISO 179/1eU
THERMAL			
Vicat Softening Temp, Rate B/50	140	°C	ASTM D1525
HDT, 1.82 MPa, 3.2mm, unannealed	125	°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
CTE, -40°C to 40°C, flow	7.2E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	7.8E-05	1/°C	ISO 11359-2



PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
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/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm	121	°C	ISO 75/Ae
PHYSICAL			
Specific Gravity	1.18	-	ASTM D792
Mold Shrinkage, flow, 3.2 mm	0.5 – 0.7	%	SABIC method
Melt Flow Rate, 300°C/ 1.2 kgf	39	g/10 min	ASTM D1238
Density	1.19	g/cm ³	ISO 1183
Water Absorption, (23°C/saturated)	0.27	%	ISO 62-1
Moisture Absorption (23°C / 50% RH)	0.09	%	ISO 62
Melt Volume Rate, MVR at 300°C/ 1.2 kg	36	cm ³ /10 min	ISO 1133
OPTICAL			
Light Transmission, 2.54 mm	88	%	ASTM D1003
Haze, 2.54 mm	<1	%	ASTM D1003
FLAME CHARACTERISTICS			
UL Compliant, 94V-2 Flame Class Rating	3	mm	UL 94 by SABIC-IP
INJECTION MOLDING			
Drying Temperature	120	°C	
Drying Time	2 – 4	Hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	280 – 300	°C	
Nozzle Temperature	270 – 290	°C	
Front - Zone 3 Temperature	280 – 300	°C	
Middle - Zone 2 Temperature	270 – 290	°C	
Rear - Zone 1 Temperature	260 – 280	°C	
Hopper Temperature	60 – 80	°C	
Mold Temperature	80 – 100	°C	

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