



# LEXANT™ RESIN HF1110R

REGION AMERICAS

## DESCRIPTION

LEXANT™ HF1110R resin is a 25 MFR polycarbonate, MVR of 26. Mold release. UL94 V2 rated.

## TYPICAL PROPERTY VALUES

Revision 20201125

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
<b>MECHANICAL</b>			
Tensile Stress, yld, Type I, 50 mm/min	62	MPa	ASTM D638
Tensile Stress, brk, Type I, 50 mm/min	65	MPa	ASTM D638
Tensile Strain, brk, Type I, 50 mm/min	120	%	ASTM D638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	93	MPa	ASTM D790
Flexural Modulus, 1.3 mm/min, 50 mm span	2300	MPa	ASTM D790
<b>IMPACT</b>			
Izod Impact, notched, 23°C	640	J/m	ASTM D256
Tensile Impact Strength, Type S	378	kJ/m <sup>2</sup>	ASTM D1822
Instrumented Dart Impact Energy @ peak, 23°C	54	J	ASTM D3763
<b>THERMAL</b>			
HDT, 1.82 MPa, 3.2mm, unannealed	126	°C	ASTM D648
Relative Temp Index, Elec	130	°C	UL 746B
Relative Temp Index, Mech w/impact	130	°C	UL 746B
Relative Temp Index, Mech w/o impact	130	°C	UL 746B
<b>PHYSICAL</b>			
Specific Gravity	1.2	-	ASTM D792
Mold Shrinkage, flow, 3.2 mm	0.5 – 0.7	%	SABIC method
Melt Flow Rate, 300°C/1.2 kgf	25	g/10 min	ASTM D1238
<b>OPTICAL</b>			
Light Transmission, 2.54 mm	88	%	ASTM D1003
Haze, 2.54 mm	1	%	ASTM D1003
<b>ELECTRICAL</b>			
Hot Wire Ignition {PLC}	2	PLC Code	UL 746A
High Voltage Arc Track Rate {PLC}	2	PLC Code	UL 746A
High Ampere Arc Ign, surface {PLC}	1	PLC Code	UL 746A
Comparative Tracking Index (UL) {PLC}	2	PLC Code	UL 746A
<b>FLAME CHARACTERISTICS</b>			
UL Yellow Card Link	<a href="#">E121562-103028708</a>	-	-
UL Recognized, 94V-2 Flame Class Rating	1.09	mm	UL 94
<b>INJECTION MOLDING</b>			
Drying Temperature	120	°C	
Drying Time	3 – 4	Hrs	
Drying Time (Cumulative)	48	Hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	270 – 295	°C	



PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
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	
Mold Temperature	70 – 95	°C	
Back Pressure	0.3 – 0.7	MPa	
Screw Speed	40 – 70	rpm	
Shot to Cylinder Size	40 – 60	%	
Vent Depth	0.025 – 0.076	mm	

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