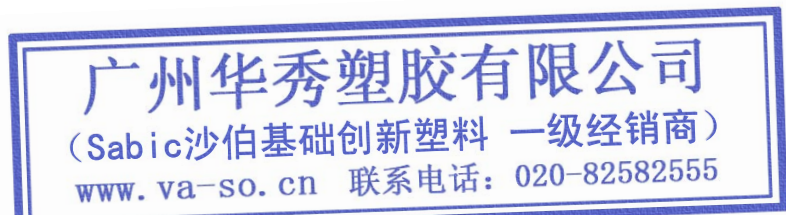




**LEXAN™ Resin HFD1930**  
**Americas: COMMERCIAL**

55 MFR LEXAN High Flow Ductile Copolymer, Natural color only

TYPICAL PROPERTIES <sup>1</sup>	TYPICAL VALUE	Unit	Standard
<b>MECHANICAL</b>			
Tensile Stress, yld, Type I, 50 mm/min	610	kgf/cm <sup>2</sup>	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	580	kgf/cm <sup>2</sup>	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	5.5	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	114	%	ASTM D 638
Tensile Modulus, 5 mm/min	23400	kgf/cm <sup>2</sup>	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	1010	kgf/cm <sup>2</sup>	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	23200	kgf/cm <sup>2</sup>	ASTM D 790
Hardness, Rockwell R	120	-	ASTM D 785
Tensile Stress, yield, 50 mm/min	61	MPa	ISO 527
Tensile Stress, break, 50 mm/min	56	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	2200	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	90	MPa	ISO 178
Flexural Modulus, 2 mm/min	2200	MPa	ISO 178
<b>IMPACT</b>			
Izod Impact, notched, 23°C	68	cm-kgf/cm	ASTM D 256
Izod Impact, notched, 0°C	33	cm-kgf/cm	ASTM D 256
Izod Impact, notched, -30°C	11	cm-kgf/cm	ASTM D 256
Multiaxial Impact	938	cm-kgf	ISO 6603
Instrumented Impact Total Energy, 23°C	571	cm-kgf	ASTM D 3763
Izod Impact, unnotched 80°10'3 +23°C	NB	kJ/m <sup>2</sup>	ISO 180/1U



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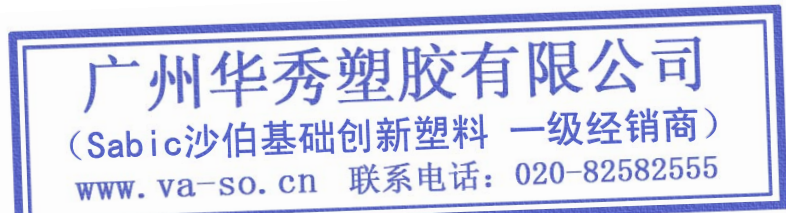
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**LEXAN™ Resin HFD1930**  
**Americas: COMMERCIAL**

TYPICAL PROPERTIES <sup>1</sup>	TYPICAL VALUE	Unit	Standard
<b>IMPACT</b>			
Izod Impact, unnotched 80*10*3 -30°C	NB	kJ/m <sup>2</sup>	ISO 180/1U
Izod Impact, notched 80*10*3 +23°C	55	kJ/m <sup>2</sup>	ISO 180/1A
Izod Impact, notched 80*10*3 -30°C	10	kJ/m <sup>2</sup>	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*3 sp=62mm	60	kJ/m <sup>2</sup>	ISO 179/1eA
Charpy -30°C, V-notch Edgew 80*10*3 sp=62mm	11	kJ/m <sup>2</sup>	ISO 179/1eA
Charpy 23°C, Unnotch Edgew 80*10*3 sp=62mm	NB	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy -30°C, Unnotch Edgew 80*10*3 sp=62mm	NB	kJ/m <sup>2</sup>	ISO 179/1eU
<b>THERMAL</b>			
Vicat Softening Temp, Rate B/50	141	°C	ASTM D 1525
HDT, 0.45 MPa, 3.2 mm, unannealed	124	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	110	°C	ASTM D 648
CTE, -40°C to 40°C, flow	8.E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	8.E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, flow	8.E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	8.E-05	1/°C	ISO 11359-2
Ball Pressure Test, 125°C +/- 2°C	PASS	-	IEC 60695-10-2
Vicat Softening Temp, Rate B/50	135	°C	ISO 306
Vicat Softening Temp, Rate B/120	136	°C	ISO 306
HDT/af, 1.8 MPa Flatw 80*10*4 sp=64mm	120	°C	ISO 75/af
<b>PHYSICAL</b>			
Specific Gravity	1.2	-	ASTM D 792
Density	1.2	g/cm <sup>3</sup>	ASTM D 792
Mold Shrinkage, flow, 3.2 mm (5)	0.5 - 0.7	%	SABIC Method
Melt Flow Rate, 300°C/1.2 kgf	55	g/10 min	ASTM D 1238
Density	1.2	g/cm <sup>3</sup>	ISO 1183



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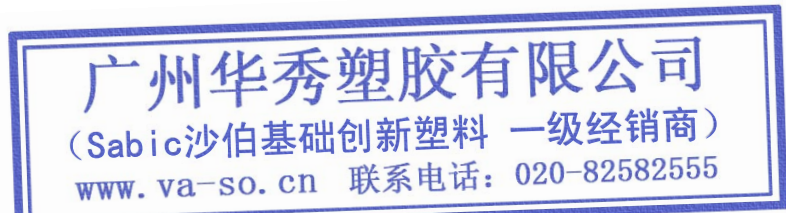
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**LEXAN™ Resin HFD1930**  
**Americas: COMMERCIAL**

TYPICAL PROPERTIES <sup>1</sup>	TYPICAL VALUE	Unit	Standard
<b>PHYSICAL</b>			
Water Absorption, (23°C/sat)	0.3	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.15	%	ISO 62
Melt Volume Rate, MVR at 300°C/1.2 kg	51	cm <sup>3</sup> /10 min	ISO 1133
<b>OPTICAL</b>			
Light Transmission, 2.54 mm	88	%	ASTM D 1003
Haze, 2.54 mm	<1	%	ASTM D 1003
Refractive Index	1.582	-	ASTM D 542
<b>FLAME CHARACTERISTICS</b>			
UL Recognized, 94HB Flame Class Rating (3)	0.3	mm	UL 94



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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
<b>Injection Molding</b>		
Drying Temperature	105 - 110	°C
Drying Time	3 - 4	hrs
Drying Time (Cumulative)	24	hrs
Melt Temperature	260 - 305	°C
Nozzle Temperature	255 - 300	°C
Front - Zone 3 Temperature	260 - 305	°C
Middle - Zone 2 Temperature	250 - 295	°C
Rear - Zone 1 Temperature	240 - 280	°C
Mold Temperature	50 - 80	°C
Back Pressure	0.3 - 0.7	MPa
Screw Speed	35 - 75	rpm
Shot to Cylinder Size	40 - 60	%
Vent Depth	0.038 - 0.076	mm



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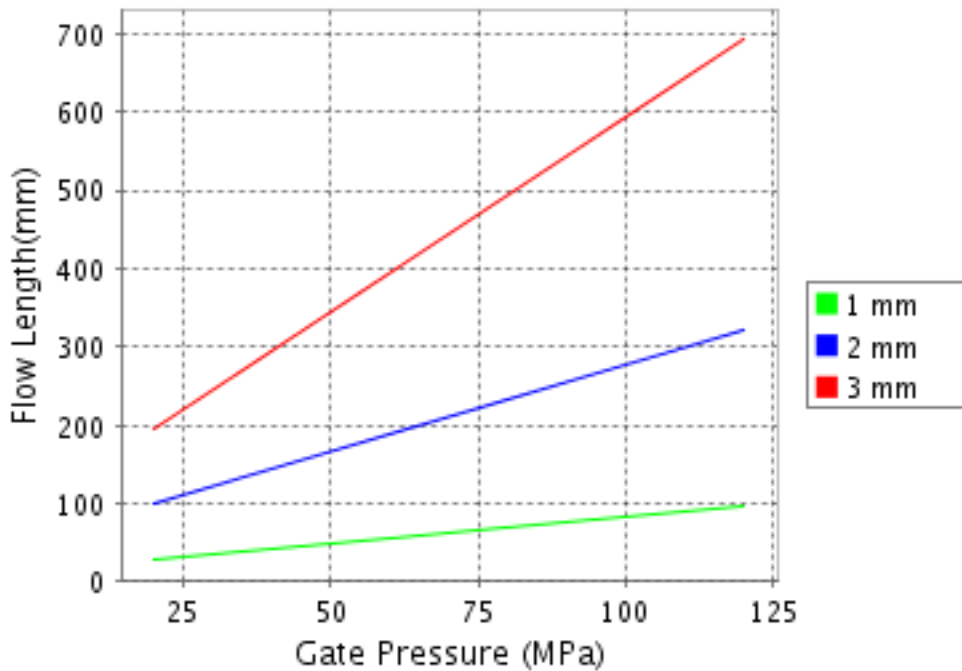
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**CALCULATED FLOW LENGTH INDICATION**  
**Moldflow® Radial Flow Analysis**  
**LEXAN® HFD1930**  
**Melt Temperature : 285°C**  
**Mold Temperature : 65°C**



**Note: Technical support is recommended if Gate Pressure is greater than 80 MPa. Contact your local representative.**

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