

LEXANT™ RESIN HF1 140R

REGION EUROPE

DESCRIPTION

LEXANT™ HF1 140R resin is a 25 MFR polycarbonate, MVR of 26. Mold release, UL94 V2 rated. This material is food contact compliant in most jurisdictions – exceptions may exist, request a declaration for details.

TYPICAL PROPERTY VALUES

Revision 20260507

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Taber Abrasion, CS-17, 1 kg	10	mg/1000cy	SABIC method
Tensile Stress, yield, 50 mm/min	63	MPa	ISO 527
Tensile Stress, break, 50 mm/min	50	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	6	%	ISO 527
Tensile Strain, break, 50 mm/min	70	%	ISO 527
Tensile Modulus, 1 mm/min	2350	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	90	MPa	ISO 178
Flexural Modulus, 2 mm/min	2300	MPa	ISO 178
Ball Indentation Hardness, H358/30	95	MPa	ISO 2039-1
IMPACT			
Izod Impact, unnotched 80°10°3 +23°C	NB	kJ/m²	ISO 180/1U
Izod Impact, unnotched 80°10°3 -30°C	NB	kJ/m²	ISO 180/1U
Izod Impact, notched 80°10°3 +23°C	60	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	60	kJ/m²	ISO 179/1eA
Charpy -30°C, V-notch Edgew 80°10°3 sp=62mm	12	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			
Thermal Conductivity	0.2	W/m·°C	ISO 8302
CTE, 23°C to 80°C, flow	7.E-05	1/°C	ISO 11359-2
Ball Pressure Test, 125°C +/- 2°C	PASSES	-	IEC 60695-10-2
Vicat Softening Temp, Rate A/50	145	°C	ISO 306
Vicat Softening Temp, Rate B/50	139	°C	ISO 306
Vicat Softening Temp, Rate B/120	140	°C	ISO 306
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
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
PHYSICAL			
Mold Shrinkage on Tensile Bar, flow	0.5 – 0.7	%	SABIC method
Density	1.2	g/cm³	ISO 1183
Water Absorption, (23°C/saturated)	0.35	%	ISO 62-1

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CHEMISTRY THAT MATTERS™



PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Moisture Absorption (23°C / 50% RH)	0.15	%	ISO 62
Melt Volume Rate, MVR at 300°C/ 1.2 kg	26	cm ³ /10 min	ISO 1133
OPTICAL			
Light Transmission, 2.54 mm	88 – 90	%	ASTM D1003
Haze, 2.54 mm	<0.8	%	ASTM D1003
Refractive Index	1.586	-	ISO 489
ELECTRICAL			
Volume Resistivity	>1.E+15	Ω.cm	IEC 60093
Surface Resistivity, ROA	>1.E+15	Ω	IEC 60093
Dielectric Strength, in oil, 3.2 mm	17	kV/mm	IEC 60243-1
Relative Permittivity, 1 MHz	2.7	-	IEC 60250
Dissipation Factor, 50/60 Hz	0.001	-	IEC 60250
Dissipation Factor, 1 MHz	0.01	-	IEC 60250
Relative Permittivity, 50/60 Hz	2.7	-	IEC 60250
FLAME CHARACTERISTICS			
UL Recognized, 94V-2 Flame Class Rating	1.1	mm	UL 94
Glow Wire Flammability Index 850°C, passes at	1	mm	IEC 60695-2-12
Oxygen Index (LOI)	25	%	ISO 4589
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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