

Product Texts

LEXAN HFD4211 is a 10% glass filled, injection moldable grade designed for high flow and superior surface appearance. Internal mold release.

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	12	cm ³ /10min	ISO 1133
Temperature	300	°C	-
Load	1.2	kg	-
ASTM Data			
Melt Flow Index, MFI	18	g/10min	ASTM D 1238
Temperature	300	°C	-
Load	1.2	kg	-

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Yield stress	68	MPa	ISO 527
Yield strain	2.7	%	ISO 527
Stress at break	59	MPa	ISO 527
Strain at break	3.2	%	ISO 527
Charpy impact strength, +23°C, 3mm	75	kJ/m ²	ISO 179/1eU
Charpy impact strength, -30°C, 3mm	81	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, +23°C, 3mm	6	kJ/m ²	ISO 179/1eA
Charpy notched impact strength, -30°C, 3mm	7	kJ/m ²	ISO 179/1eA
Izod impact strength, +23°C	64	kJ/m ²	ISO 180/1U
Izod notched impact strength, +23°C, 3mm	6	kJ/m ²	ISO 180/1A
Izod notched impact strength, -30°C, 3mm	6	kJ/m ²	ISO 180/1A
ASTM Data			
Tensile Modulus	4120	MPa	ASTM D 638
Tensile Strength at Yield	60	MPa	ASTM D 638
Tensile Strength at Break	46	MPa	ASTM D 638
Elongation at Yield	3.1	%	ASTM D 638
Flexural Modulus	3690	MPa	ASTM D 790
Izod Impact notched, 1/8 in	120	J/m	ASTM D 256
Izod Impact unnotched, 1/8 in	1260	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	126	°C	ISO 75-1/-2
Vicat softening temperature, 120°C/h 50N	141	°C	ISO 306
ASTM Data			
DTUL @ 66 psi	129	°C	ASTM D 648
DTUL @ 264 psi	123	°C	ASTM D 648

Other properties	Value	Unit	Test Standard
Water absorption	0.3	%	Sim. to ISO 62
Humidity absorption	0.12	%	Sim. to ISO 62
Density	1250	kg/m ³	ISO 1183
Density	1270	kg/m ³	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	120	°C	-
Pre-drying - Time	3 - 4	h	-
Processing humidity	≤0.02	%	-
Melt temperature	290 - 310	°C	-
Mold temperature	70 - 95	°C	-
Zone 1	265 - 290	°C	-
Zone 2	275 - 300	°C	-
Zone 3	290 - 310	°C	-

LEXAN™ Copolymer HFD4211 - Europe

PC-GF10

Saudi Basic Industries Corporation (SABIC)

Screw speed	40 - 70	rpm	-
Back pressure	0.3 - 0.7	MPa	-

Characteristics**Processing**

Injection Molding

Regional Availability

Europe