

Product Texts

LEXAN HFD4471 is a 10% glass filled, medium flow, impact modified, injection moldable grade designed for high flow and superior surface appearance. HFD4471 has enhanced mold release, impact ductility and broad color space.

UL Yellow Card Link [E207780-101177310](https://www.ul.com/yellow-card/E207780-101177310)

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	9	cm ³ /10min	ISO 1133
Temperature	300	°C	-
Load	1.2	kg	-
ASTM Data			
Melt Flow Index, MFI	10	g/10min	ASTM D 1238
Temperature	300	°C	-
Load	1.2	kg	-

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Yield stress	58	MPa	ISO 527
Yield strain	3	%	ISO 527
Stress at break	41	MPa	ISO 527
Strain at break	10	%	ISO 527
Charpy impact strength, +23°C, 3mm	N	kJ/m ²	ISO 179/1eU
Charpy impact strength, -30°C, 3mm	N	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, +23°C, 3mm	29	kJ/m ²	ISO 179/1eA
Charpy notched impact strength, -30°C, 3mm	10	kJ/m ²	ISO 179/1eA
Izod impact strength, +23°C	175	kJ/m ²	ISO 180/1U
Izod notched impact strength, +23°C, 3mm	30	kJ/m ²	ISO 180/1A
Izod notched impact strength, -30°C, 3mm	13	kJ/m ²	ISO 180/1A
ASTM Data			
Tensile Modulus	3700	MPa	ASTM D 638
Tensile Strength at Yield	54	MPa	ASTM D 638
Tensile Strength at Break	37	MPa	ASTM D 638
Elongation at Yield	3	%	ASTM D 638
Flexural Modulus	3300	MPa	ASTM D 790
Izod Impact notched, 1/8 in	290	J/m	ASTM D 256
Izod Impact unnotched, 1/8 in	2100	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
ISO Data			
Vicat softening temperature, 120°C/h 50N	135	°C	ISO 306
Burning behav. at thickness h	HB	class	IEC 60695-11-10
Thickness tested	0.4	mm	-
Glow Wire Flammability Index (GWFI)	930	°C	IEC 60695-2-12
Glow Wire Flammability Index (GWFI)	960	°C	IEC 60695-2-12
Glow Wire Flammability Index (GWFI)	960	°C	IEC 60695-2-12
Glow Wire Ignition Temperature (GWIT)	930	°C	IEC 60695-2-13
GWIT - thickness tested (1)	1	mm	-
Glow Wire Ignition Temperature (GWIT)	900	°C	IEC 60695-2-13
GWIT - thickness tested (2)	2	mm	-
Glow Wire Ignition Temperature (GWIT)	900	°C	IEC 60695-2-13
GWIT - thickness tested (3)	3	mm	-
ASTM Data			
DTUL @ 66 psi	131	°C	ASTM D 648
DTUL @ 264 psi	125	°C	ASTM D 648

Other properties	Value	Unit	Test Standard
Water absorption	0.14	%	Sim. to ISO 62
Humidity absorption	0.04	%	Sim. to ISO 62

LEXAN™ Copolymer HFD4471 - Americas

PC-GF10

Saudi Basic Industries Corporation (SABIC)

Density	1250	kg/m ³	ISO 1183
Density	1260	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	-
Screw speed	40 - 70	rpm	-
Back pressure	0.3 - 0.7	MPa	-

Characteristics**Processing**

Injection Molding

Regional Availability

North America

Special Characteristics

High impact or impact modified