

**Product Texts**

LEXAN HFD4413 is a 30% glass filled, injection moldable grade designed for high flow and superior surface appearance. Internal mold release.

UL Yellow Card Link [E207780-100921642](https://www.ulprospector.com/lexan/lexan-hfd4413)

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ISO Data</b>			
Melt volume-flow rate, MVR	18	cm <sup>3</sup> /10min	ISO 1133
Temperature	300	°C	-
Load	1.2	kg	-
<b>ASTM Data</b>			
Melt Flow Index, MFI	16	g/10min	ASTM D 1238
Temperature	300	°C	-
Load	1.2	kg	-

Mechanical properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Yield stress	115	MPa	ISO 527
Yield strain	2.5	%	ISO 527
Stress at break	125	MPa	ISO 527
Strain at break	2.1	%	ISO 527
Charpy impact strength, +23°C, 3mm	40	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy impact strength, -30°C, 3mm	49	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy notched impact strength, +23°C, 3mm	12	kJ/m <sup>2</sup>	ISO 179/1eA
Charpy notched impact strength, -30°C, 3mm	11	kJ/m <sup>2</sup>	ISO 179/1eA
Izod impact strength, +23°C	37	kJ/m <sup>2</sup>	ISO 180/1U
Izod notched impact strength, +23°C, 3mm	10	kJ/m <sup>2</sup>	ISO 180/1A
Izod notched impact strength, -30°C, 3mm	10	kJ/m <sup>2</sup>	ISO 180/1A
<b>ASTM Data</b>			
Tensile Modulus	7870	MPa	ASTM D 638
Tensile Strength at Yield	111	MPa	ASTM D 638
Tensile Strength at Break	111	MPa	ASTM D 638
Elongation at Yield	3	%	ASTM D 638
Flexural Modulus	7760	MPa	ASTM D 790
Izod Impact notched, 1/8 in	133	J/m	ASTM D 256
Izod Impact unnotched, 1/8 in	852	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Temp. of deflection under load, 1.80 MPa	129	°C	ISO 75-1/-2
Vicat softening temperature, 120°C/h 50N	143	°C	ISO 306
Burning behav. at thickness h	HB	class	IEC 60695-11-10
Thickness tested	0.3	mm	-
Glow Wire Flammability Index (GWFI)	900	°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)	850	°C	IEC 60695-2-13
GWIT - thickness tested (1)	1	mm	-
Glow Wire Ignition Temperature (GWIT)	875	°C	IEC 60695-2-13
GWIT - thickness tested (2)	2	mm	-
Glow Wire Ignition Temperature (GWIT)	850	°C	IEC 60695-2-13
GWIT - thickness tested (3)	3	mm	-
<b>ASTM Data</b>			
DTUL @ 66 psi	130	°C	ASTM D 648
DTUL @ 264 psi	125	°C	ASTM D 648

Other properties	Value	Unit	Test Standard
Water absorption	0.3	%	Sim. to ISO 62

**LEXAN™ Copolymer HFD4413 - Asia**

PC-GF30

Saudi Basic Industries Corporation (SABIC)

Humidity absorption	<b>0.12</b>	%	Sim. to ISO 62
Density	<b>1440</b>	kg/m <sup>3</sup>	ISO 1183
Density	<b>1430</b>	kg/m <sup>3</sup>	ASTM D 792

<b>Processing Recommendation Injection Molding</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
Pre-drying - Temperature	<b>120</b>	°C	-
Pre-drying - Time	<b>3 - 4</b>	h	-
Processing humidity	<b>≤0.02</b>	%	-
Melt temperature	<b>290 - 310</b>	°C	-
Mold temperature	<b>70 - 95</b>	°C	-
Zone 1	<b>265 - 290</b>	°C	-
Zone 2	<b>275 - 300</b>	°C	-
Zone 3	<b>290 - 310</b>	°C	-
Screw speed	<b>40 - 70</b>	rpm	-
Back pressure	<b>0.3 - 0.7</b>	MPa	-

**Characteristics****Processing**

Injection Molding

**Regional Availability**

Asia Pacific