

**Product Texts**

XHT1141 is a high flow, high heat polycarbonate copolymer. It is the lowest heat product in the LEXAN XHT portfolio. It is available in a range of opaque and limited transparent colors.

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ISO Data</b>			
Melt volume-flow rate, MVR	70	cm <sup>3</sup> /10min	ISO 1133
Temperature	330	°C	-
Load	2.16	kg	-

Mechanical properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Tensile Modulus	2400	MPa	ISO 527
Yield stress	65	MPa	ISO 527
Yield strain	6.5	%	ISO 527
Stress at break	60	MPa	ISO 527
Strain at break	50	%	ISO 527
Flexural modulus	2400	MPa	ISO 178
Charpy impact strength, +23°C, 3mm	N	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy impact strength, -30°C, 3mm	N	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy notched impact strength, +23°C, 3mm	16	kJ/m <sup>2</sup>	ISO 179/1eA
Charpy notched impact strength, -30°C, 3mm	12	kJ/m <sup>2</sup>	ISO 179/1eA
Izod impact strength, +23°C	N	kJ/m <sup>2</sup>	ISO 180/1U
Izod notched impact strength, +23°C, 3mm	14	kJ/m <sup>2</sup>	ISO 180/1A
Izod notched impact strength, -30°C, 3mm	10	kJ/m <sup>2</sup>	ISO 180/1A

Thermal properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Temp. of deflection under load, 1.80 MPa	132	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	144	°C	ISO 75-1/-2
Vicat softening temperature, B	150	°C	ISO 306
Vicat softening temperature, 120°C/h 50N	152	°C	ISO 306

Other properties	Value	Unit	Test Standard
Water absorption	0.3	%	Sim. to ISO 62
Humidity absorption	0.3	%	Sim. to ISO 62
Density	1200	kg/m <sup>3</sup>	ISO 1183

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	125	°C	-
Pre-drying - Time	4 - 6	h	-
Processing humidity	≤0.02	%	-
Melt temperature	290 - 335	°C	-
Mold temperature	85 - 130	°C	-
Zone 1	270 - 315	°C	-
Zone 2	280 - 325	°C	-
Zone 3	290 - 335	°C	-
Screw speed	40 - 90	rpm	-
Back pressure	0.3 - 0.7	MPa	-

**Characteristics****Processing**

Injection Molding

**Special Characteristics**

Transparent

**Applications**

Automotive

**Regional Availability**

Asia Pacific