

Product Texts

25 MFR LEXAN High Flow Ductile Copolymer

UL Yellow Card Link [E121562-100911705](https://www.ul.com/lexan-hfd1711)

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	23	cm ³ /10min	ISO 1133
Temperature	300	°C	-
Load	1.2	kg	-
ASTM Data			
Melt Flow Index, MFI	25	g/10min	ASTM D 1238
Temperature	300	°C	-
Load	1.2	kg	-

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	2180	MPa	ISO 527
Yield stress	62	MPa	ISO 527
Yield strain	6	%	ISO 527
Stress at break	65	MPa	ISO 527
Strain at break	50	%	ISO 527
Flexural modulus	2180	MPa	ISO 178
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	73	kJ/m ²	ISO 179/1eA
Charpy notched impact strength, -30°C, 3mm	13	kJ/m ²	ISO 179/1eA
Izod impact strength, +23°C	N	kJ/m ²	ISO 180/1U
Izod notched impact strength, +23°C, 3mm	64	kJ/m ²	ISO 180/1A
Izod notched impact strength, -30°C, 3mm	13	kJ/m ²	ISO 180/1A
ASTM Data			
Tensile Modulus	2230	MPa	ASTM D 638
Tensile Strength at Yield	59	MPa	ASTM D 638
Tensile Strength at Break	60	MPa	ASTM D 638
Elongation at Yield	6	%	ASTM D 638
Elongation at Break	132	%	ASTM D 638
Flexural Modulus	2220	MPa	ASTM D 790
Rockwell Hardness	R 120	-	ASTM D 785
Izod Impact notched, 1/8 in	812	J/m	ASTM D 256
Izod Impact notched, Low-Temperature	125	J/m	ASTM D 256
Temperature	-30	°C	-

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	115	°C	ISO 75-1/-2
Vicat softening temperature, B	129	°C	ISO 306
Vicat softening temperature, 120°C/h 50N	130	°C	ISO 306
Burning behav. at thickness h	HB	class	IEC 60695-11-10
Thickness tested	0.7	mm	-
ASTM Data			
DTUL @ 66 psi	122	°C	ASTM D 648
DTUL @ 264 psi	111	°C	ASTM D 648
Vicat Temperature	135	°C	ASTM D 1525

Other properties	Value	Unit	Test Standard
Water absorption	0.3	%	Sim. to ISO 62
Humidity absorption	0.15	%	Sim. to ISO 62
Density	1200	kg/m ³	ISO 1183
Density	1200	kg/m ³	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	105 - 110	°C	-
Pre-drying - Time	3 - 4	h	-
Melt temperature	260 - 305	°C	-
Mold temperature	50 - 80	°C	-
Zone 1	240 - 280	°C	-
Zone 2	250 - 295	°C	-
Zone 3	260 - 305	°C	-
Screw speed	35 - 75	rpm	-
Back pressure	0.3 - 0.7	MPa	-

Characteristics**Processing**

Injection Molding

Regional Availability

North America