

**Product Texts**

25 MFR LEXAN High Flow Ductile Copolymer Healthcare Grade

**Processing/Physical Characteristics**

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

**Mechanical properties**

	Value	Unit	Test Standard
<b>ISO Data</b>			
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 <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	73	kJ/m <sup>2</sup>	ISO 179/1eA
Charpy notched impact strength, -30°C, 3mm	13	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	64	kJ/m <sup>2</sup>	ISO 180/1A
Izod notched impact strength, -30°C, 3mm	13	kJ/m <sup>2</sup>	ISO 180/1A
<b>ASTM Data</b>			
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
<b>ISO Data</b>			
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
<b>ASTM Data</b>			
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 <sup>3</sup>	ISO 1183
Density	1200	kg/m <sup>3</sup>	ASTM D 792

**Processing Recommendation Injection Molding**

	Value	Unit	Test Standard
Pre-drying - Temperature	105 - 110	°C	-
Pre-drying - Time	3 - 4	h	-

**LEXAN™ Copolymer HPF1 - Americas**

PC

Saudi Basic Industries Corporation (SABIC)

Melt temperature	<b>260 - 305</b>	°C	-
Mold temperature	<b>50 - 80</b>	°C	-
Zone 1	<b>240 - 280</b>	°C	-
Zone 2	<b>250 - 295</b>	°C	-
Zone 3	<b>260 - 305</b>	°C	-
Screw speed	<b>35 - 75</b>	rpm	-
Back pressure	<b>0.3 - 0.7</b>	MPa	-

**Characteristics****Processing**

Injection Molding

**Regional Availability**

North America