

**Product Texts**

High heat specialty polycarbonate. For medical devices and pharmaceutical applications. Healthcare management of change, biocompatible (ISO10993 of USP Class VI). EtO, steam, gamma and e-beam sterilizable.

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ISO Data</b>			
Melt volume-flow rate, MVR	12	cm <sup>3</sup> /10min	ISO 1133
Temperature	330	°C	-
Load	2.16	kg	-
<b>ASTM Data</b>			
Melt Flow Index, MFI	3	g/10min	ASTM D 1238
Temperature	300	°C	-
Load	1.2	kg	-

Mechanical properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Tensile Modulus	2260	MPa	ISO 527
Yield stress	65	MPa	ISO 527
Yield strain	7	%	ISO 527
Stress at break	65	MPa	ISO 527
Strain at break	50	%	ISO 527
Flexural modulus	2120	MPa	ISO 178
Charpy notched impact strength, +23°C	15	kJ/m <sup>2</sup>	ISO 179/1eA
Izod notched impact strength, +23°C, 4mm	13	kJ/m <sup>2</sup>	ISO 180/1A
Izod notched impact strength, -30°C, 4mm	11	kJ/m <sup>2</sup>	ISO 180/1A
<b>ASTM Data</b>			
Tensile Modulus	2090	MPa	ASTM D 638
Tensile Strength at Yield	65	MPa	ASTM D 638
Tensile Strength at Break	71	MPa	ASTM D 638
Elongation at Yield	7	%	ASTM D 638
Elongation at Break	122	%	ASTM D 638
Flexural Modulus	2020	MPa	ASTM D 790
Rockwell Hardness	R 122	-	ASTM D 785
Izod Impact notched, 1/8 in	640	J/m	ASTM D 256
Izod Impact notched, Low-Temperature	144	J/m	ASTM D 256
Temperature	-30	°C	-
Izod Impact unnotched, 1/8 in	3200	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Temp. of deflection under load, 1.80 MPa	132	°C	ISO 75-1/-2
Vicat softening temperature, B	154	°C	ISO 306
Vicat softening temperature, 120°C/h 50N	155	°C	ISO 306
<b>ASTM Data</b>			
DTUL @ 264 psi	143	°C	ASTM D 648
Vicat Temperature	160	°C	ASTM D 1525
Thermal Conductivity, solid state	0.0303	W/(m K)	ASTM C 177
Specific Heat	1260	J/(kg K)	ASTM C 351

Electrical properties	Value	Unit	Test Standard
<b>ASTM Data</b>			
Dissipation Factor, 60 Hz	0.0012	-	ASTM D 150
Dielectric Constant, 60 Hz	3.15	-	ASTM D 150
Dielectric Constant, 1 MHz	3	-	ASTM D 150
Volume Resistivity	>1E15	Ohm*cm	ASTM D 257

Other properties	Value	Unit	Test Standard
Water absorption	0.16	%	Sim. to ISO 62
Humidity absorption	0.35	%	Sim. to ISO 62

**LEXAN™ Copolymer HPH4504 - Asia**

PC

Saudi Basic Industries Corporation (SABIC)

Density	<b>1200</b>	kg/m <sup>3</sup>	ISO 1183
Density	<b>1200</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>340 - 360</b>	°C	-
Mold temperature	<b>80 - 115</b>	°C	-
Zone 1	<b>315 - 340</b>	°C	-
Zone 2	<b>325 - 350</b>	°C	-
Zone 3	<b>340 - 360</b>	°C	-
Screw speed	<b>40 - 70</b>	rpm	-
Back pressure	<b>0.3 - 0.7</b>	MPa	-

**Characteristics****Processing**

Injection Molding

**Applications**

Medical

**Special Characteristics**

Ethylene Oxide (EtO) Sterilization, Steam sterilization, Gamma irradiation sterilization, Electron beam (e-beam) sterilization

**Regional Availability**

Asia Pacific

**Certifications**

US Pharmacopeia Class VI Approved