



LEXAN™ Resin 3413HF
Americas: COMMERCIAL

30% glass reinforced, high flow PC.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, brk, Type I, 5 mm/min	1010	kgf/cm ²	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	2	%	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	1560	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	67400	kgf/cm ²	ASTM D 790
IMPACT			
Izod Impact, notched, 23°C	7	cm-kgf/cm	ASTM D 256
THERMAL			
HDT, 1.82 MPa, 6.4 mm, unannealed	137	°C	ASTM D 648
Relative Temp Index, Elec	80	°C	UL 746B
Relative Temp Index, Mech w/impact	80	°C	UL 746B
Relative Temp Index, Mech w/o impact	80	°C	UL 746B
PHYSICAL			
Specific Gravity	1.44	-	ASTM D 792
Melt Flow Rate, 300°C/5.0 kgf	40	g/10 min	ASTM D 1238
ELECTRICAL			
Hot Wire Ignition {PLC}	1	PLC Code	UL 746A
High Ampere Arc Ign, surface {PLC}	4	PLC Code	UL 746A
Comparative Tracking Index (UL) {PLC}	3	PLC Code	UL 746A
FLAME CHARACTERISTICS			
UL Recognized, 94V-1 Flame Class Rating (3)	1.47	mm	UL 94
UL Recognized, 94V-0 Flame Class Rating (3)	2.99	mm	UL 94



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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	120	°C
Drying Time	3 - 4	hrs
Drying Time (Cumulative)	48	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	310 - 330	°C
Nozzle Temperature	305 - 325	°C
Front - Zone 3 Temperature	310 - 330	°C
Middle - Zone 2 Temperature	300 - 320	°C
Rear - Zone 1 Temperature	290 - 310	°C
Mold Temperature	80 - 115	°C
Back Pressure	0.3 - 0.7	MPa
Screw Speed	40 - 70	rpm
Shot to Cylinder Size	40 - 60	%
Vent Depth	0.025 - 0.076	mm