



LEXAN™ Resin HFD1731
Americas: COMMERCIAL

25 MFR LEXAN High Flow Ductile Copolymer UV-stabilized

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	600	kgf/cm ²	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	610	kgf/cm ²	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	6	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	132	%	ASTM D 638
Tensile Modulus, 5 mm/min	22700	kgf/cm ²	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	1000	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	22600	kgf/cm ²	ASTM D 790
Hardness, Rockwell R	120	-	ASTM D 785
Tensile Stress, yield, 50 mm/min	62	MPa	ISO 527
Tensile Stress, break, 50 mm/min	65	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	6	%	ISO 527
Tensile Strain, break, 50 mm/min	123	%	ISO 527
Tensile Modulus, 1 mm/min	2180	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	90	MPa	ISO 178
Flexural Modulus, 2 mm/min	2180	MPa	ISO 178
IMPACT			
Izod Impact, notched, 23°C	82	cm-kgf/cm	ASTM D 256
Izod Impact, notched, 0°C	80	cm-kgf/cm	ASTM D 256
Izod Impact, notched, -30°C	12	cm-kgf/cm	ASTM D 256
Multiaxial Impact	1121	cm-kgf	ISO 6603
Instrumented Impact Total Energy, 23°C	688	cm-kgf	ASTM D 3763
Izod Impact, unnotched 80*10*3 +23°C	NB	kJ/m ²	ISO 180/1U



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IMPACT			
Izod Impact, unnotched 80*10*3 -30°C	NB	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*3 +23°C	64	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*3 -30°C	13	kJ/m ²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*3 sp=62mm	73	kJ/m ²	ISO 179/1eA
Charpy -30°C, V-notch Edgew 80*10*3 sp=62mm	13	kJ/m ²	ISO 179/1eA
Charpy 23°C, Unnotch Edgew 80*10*3 sp=62mm	NB	kJ/m ²	ISO 179/1eU
Charpy -30°C, Unnotch Edgew 80*10*3 sp=62mm	NB	kJ/m ²	ISO 179/1eU
THERMAL			
Vicat Softening Temp, Rate B/50	135	°C	ASTM D 1525
HDT, 0.45 MPa, 3.2 mm, unannealed	122	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	111	°C	ASTM D 648
CTE, -40°C to 40°C, flow	8.E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	8.E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, flow	8.E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	8.E-05	1/°C	ISO 11359-2
Ball Pressure Test, 125°C +/- 2°C	PASS	-	IEC 60695-10-2
Vicat Softening Temp, Rate B/50	129	°C	ISO 306
Vicat Softening Temp, Rate B/120	130	°C	ISO 306
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	115	°C	ISO 75/Af
Relative Temp Index, Elec	105	°C	UL 746B
Relative Temp Index, Mech w/impact	105	°C	UL 746B
Relative Temp Index, Mech w/o impact	105	°C	UL 746B
PHYSICAL			
Specific Gravity	1.2	-	ASTM D 792
Density	1.2	g/cm ³	ASTM D 792



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PHYSICAL			
Mold Shrinkage, flow, 3.2 mm (5)	0.5 - 0.7	%	SABIC Method
Melt Flow Rate, 300°C/1.2 kgf	25	g/10 min	ASTM D 1238
Density	1.2	g/cm ³	ISO 1183
Water Absorption, (23°C/sat)	0.3	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.15	%	ISO 62
Melt Volume Rate, MVR at 300°C/1.2 kg	23	cm ³ /10 min	ISO 1133
OPTICAL			
Light Transmission, 2.54 mm	88	%	ASTM D 1003
Haze, 2.54 mm	<1	%	ASTM D 1003
Refractive Index	1.582	-	ASTM D 542
FLAME CHARACTERISTICS			
UL Recognized, 94HB Flame Class Rating (3)	0.8	mm	UL 94



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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	105 - 110	°C
Drying Time	3 - 4	hrs
Drying Time (Cumulative)	24	hrs
Melt Temperature	260 - 305	°C
Nozzle Temperature	255 - 300	°C
Front - Zone 3 Temperature	260 - 305	°C
Middle - Zone 2 Temperature	250 - 295	°C
Rear - Zone 1 Temperature	240 - 280	°C
Mold Temperature	50 - 80	°C
Back Pressure	0.3 - 0.7	MPa
Screw Speed	35 - 75	rpm
Shot to Cylinder Size	40 - 60	%
Vent Depth	0.038 - 0.076	mm



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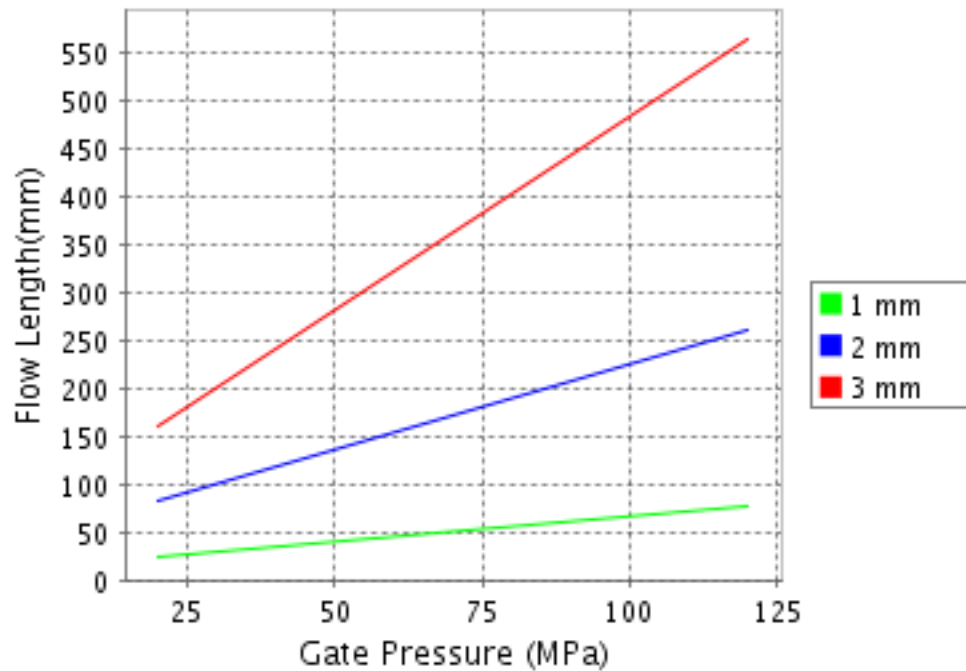
CALCULATED FLOW LENGTH INDICATION

Moldflow® Radial Flow Analysis

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Melt Temperature : 285°C

Mold Temperature : 65°C



Note: Technical support is recommended if Gate Pressure is greater than 80 MPa. Contact your local representative.

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