



LEXAN™ Resin XHT1141

Americas: COMMERCIAL

XHT1141 is a high flow, high heat polycarbonate copolymer. It is the lowest heat product in the LEXAN XHT portfolio. It is available in a range of opaque and limited transparent colors.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yield, 50 mm/min	65	MPa	ISO 527
Tensile Stress, break, 50 mm/min	60	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	6.5	%	ISO 527
Tensile Strain, break, 50 mm/min	80	%	ISO 527
Tensile Modulus, 1 mm/min	2400	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	100	MPa	ISO 178
Flexural Modulus, 2 mm/min	2400	MPa	ISO 178
IMPACT			
Izod Impact, unnotched 80*10*3 +23°C	NB	kJ/m ²	ISO 180/1U
Izod Impact, unnotched 80*10*3 -30°C	NB	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*3 +23°C	14	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*3 -30°C	10	kJ/m ²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*3 sp=62mm	16	kJ/m ²	ISO 179/1eA
Charpy -30°C, V-notch Edgew 80*10*3 sp=62mm	12	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			
CTE, -40°C to 40°C, flow	7.E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	7.E-05	1/°C	ISO 11359-2
Vicat Softening Temp, Rate B/50	150	°C	ISO 306
Vicat Softening Temp, Rate B/120	152	°C	ISO 306
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	144	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	132	°C	ISO 75/Af



LEXAN™ Resin XHT1141
Americas: COMMERCIAL

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
PHYSICAL			
Mold Shrinkage, flow, 3.2 mm (5)	0.6 - 0.9	%	SABIC Method
Density	1.2	g/cm ³	ISO 1183
Water Absorption, (23°C/sat)	0.3	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.3	%	ISO 62
Melt Volume Rate, MVR at 300°C/1.2 kg	16	cm ³ /10 min	ISO 1133
Melt Volume Rate, MVR at 330°C/2.16kg	70	cm ³ /10 min	ISO 1133



LEXAN™ Resin XHT1141

Americas: COMMERCIAL

PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	125	°C
Drying Time	4 - 6	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	290 - 335	°C
Nozzle Temperature	285 - 330	°C
Front - Zone 3 Temperature	290 - 335	°C
Middle - Zone 2 Temperature	280 - 325	°C
Rear - Zone 1 Temperature	270 - 305	°C
Mold Temperature	85 - 130	°C
Back Pressure	0.3 - 0.7	MPa
Screw Speed	40 - 90	rpm
Shot to Cylinder Size	40 - 60	%
Vent Depth	0.025 - 0.08	mm