

LEXAN™ FR RESINS 3413HF

REGION AMERICAS

DESCRIPTION

LEXAN™ 3413HF resin is a 30% glass fiber filled, 8 MFR polycarbonate. Mold release. Flame retardant, UL94 V1 and V0 rated. Available in natural and opaque colors.

TYPICAL PROPERTY VALUES

Revision 20201126

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, brk, Type I, 5 mm/min	99	MPa	ASTM D638
Tensile Strain, brk, Type I, 5 mm/min	2	%	ASTM D638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	153	MPa	ASTM D790
Flexural Modulus, 1.3 mm/min, 50 mm span	6610	MPa	ASTM D790
IMPACT			
Izod Impact, notched, 23°C	69	J/m	ASTM D256
THERMAL			
HDT, 1.82 MPa, 6.4 mm, unannealed	137	°C	ASTM D648
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 D792
Melt Flow Rate, 300°C/5.0 kgf	40	g/10 min	ASTM D1238
Melt Flow Rate, 300°C/1.2 kgf	8	g/10 min	ASTM D1238
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 Yellow Card Link	E121562-220882	-	-
UL Recognized, 94V-1 Flame Class Rating	1.47	mm	UL 94
UL Recognized, 94V-0 Flame Class Rating	2.99	mm	UL 94
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	

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
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	

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