

# 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
<b>MECHANICAL</b>			
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
<b>IMPACT</b>			
Izod Impact, notched, 23°C	69	J/m	ASTM D256
<b>THERMAL</b>			
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
<b>PHYSICAL</b>			
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
<b>ELECTRICAL</b>			
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
<b>FLAME CHARACTERISTICS</b>			
UL Yellow Card Link	<a href="#">E121562-220882</a>	-	-
UL Recognized, 94V-1 Flame Class Rating	1.47	mm	UL 94
UL Recognized, 94V-0 Flame Class Rating	2.99	mm	UL 94
<b>INJECTION MOLDING</b>			
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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