

LEXANT™ RESIN HFR1723

REGION AMERICAS

DESCRIPTION

LEXANT™ HFR1723 resin is a 25 MFR polycarbonate. UV stabilized. Mold release. UL94 V2 rated. Available in transparent, limited package types, and must meet minimum order quantity requirements.

TYPICAL PROPERTY VALUES

Revision 20201125

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	62	MPa	ASTM D638
Tensile Stress, brk, Type I, 50 mm/min	65	MPa	ASTM D638
Tensile Strain, brk, Type I, 50 mm/min	110	%	ASTM D638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	93	MPa	ASTM D790
Flexural Modulus, 1.3 mm/min, 50 mm span	2300	MPa	ASTM D790
IMPACT			
Izod Impact, notched, 23°C	640	J/m	ASTM D256
Tensile Impact Strength, Type S	378	kJ/m²	ASTM D1822
Instrumented Dart Impact Energy @ peak, 23°C	54	J	ASTM D3763
THERMAL			
HDT, 1.82 MPa, 6.4 mm, unannealed	126	°C	ASTM D648
Relative Temp Index, Elec	130	°C	UL 746B
Relative Temp Index, Mech w/impact	130	°C	UL 746B
Relative Temp Index, Mech w/o impact	130	°C	UL 746B
PHYSICAL			
Specific Gravity	1.2	-	ASTM D792
Mold Shrinkage, flow, 3.2 mm	0.5 – 0.7	%	SABIC method
Melt Flow Rate, 300°C/1.2 kgf	25	g/10 min	ASTM D1238
OPTICAL			
Light Transmission, 2.54 mm	88	%	ASTM D1003
Haze, 2.54 mm	1	%	ASTM D1003
FLAME CHARACTERISTICS			
UL Yellow Card Link	E121562-220946	-	-
UL Recognized, 94V-2 Flame Class Rating	1.2	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	270 – 295	°C	
Nozzle Temperature	265 – 290	°C	
Front - Zone 3 Temperature	270 – 295	°C	
Middle - Zone 2 Temperature	260 – 280	°C	
Rear - Zone 1 Temperature	250 – 270	°C	

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Mold Temperature	70 – 95	°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	

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