



LEXAN® HF1110
Americas: COMMERCIAL

General purpose grade. Good clarity, heat resistance, property retention and dimensional stability.

Table with 4 columns: TYPICAL PROPERTIES 1, TYPICAL VALUE, UNIT, STANDARD. Rows include MECHANICAL, IMPACT, THERMAL, PHYSICAL, OPTICAL, ELECTRICAL, and FLAME CHARACTERISTICS.

1) Typical values only. Variations within normal tolerances are possible for various colours. All values are measured at least after 48 hours storage at 23°C/50% relative humidity.

2) Only typical data for material selection purpose. Not to be used for part or tool design.
3) This rating is not intended to reflect hazards presented by this or any other material under actual fire conditions.
4) Own measurement according to UL.

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TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
CSA (See File for complete listing)	LS88480	File No.	CSA LISTED

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PROCESSING PARAMETERS	TYPICAL VALUE	UNIT
Injection Molding		
Drying Temperature	250	°F
Drying Time	3 - 4	hrs
Drying Time (Cumulative)	48	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	520 - 560	°F
Nozzle Temperature	510 - 550	°F
Front - Zone 3 Temperature	520 - 560	°F
Middle - Zone 2 Temperature	500 - 540	°F
Rear - Zone 1 Temperature	480 - 520	°F
Mold Temperature	160 - 200	°F
Back Pressure	50 - 100	psi
Screw Speed	40 - 70	rpm
Shot to Cylinder Size	40 - 60	%
Vent Depth	0.001 - 0.003	in

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