



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	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
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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