

LEXAN™ COPOLYMER XHT3146

REGION ASIA

DESCRIPTION

XHT3146 is a high mold release version of XHT3141 high heat polycarbonate copolymer. It is available in a range of opaque and limited transparent colors.

TYPICAL PROPERTY VALUES

Revision 20200610

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	70	MPa	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	55	MPa	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	6	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	70	%	ASTM D 638
Tensile Modulus, 50 mm/min	2700	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	120	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	2600	MPa	ASTM D 790
Tensile Stress, yield, 50 mm/min	70	MPa	ISO 527
Tensile Stress, break, 50 mm/min	60	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	6	%	ISO 527
Tensile Strain, break, 50 mm/min	70	%	ISO 527
Tensile Modulus, 1 mm/min	2500	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	80	MPa	ISO 178
Flexural Modulus, 2 mm/min	2500	MPa	ISO 178
IMPACT			
Izod Impact, notched, 23°C	97	J/m	ASTM D 256
Izod Impact, notched, -30°C	55	J/m	ASTM D 256
Instrumented Impact Total Energy, 23°C	68	J	ASTM D 3763
Izod Impact, unnotched 80*10*3 +23°C	NB	kJ/m ²	ISO 180/1U
Izod Impact, unnotched 80*10*3 -30°C	NB	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*3 +23°C	9	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*3 -30°C	9	kJ/m ²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*3 sp=62mm	11	kJ/m ²	ISO 179/1eA
Charpy -30°C, V-notch Edgew 80*10*3 sp=62mm	9	kJ/m ²	ISO 179/1eA
Charpy 23°C, Unnotch Edgew 80*10*3 sp=62mm	NB	kJ/m ²	ISO 179/1eU
Charpy -30°C, Unnotch Edgew 80*10*3 sp=62mm	NB	kJ/m ²	ISO 179/1eU
THERMAL			
Vicat Softening Temp, Rate B/50	170	°C	ASTM D 1525
HDT, 0.45 MPa, 3.2 mm, unannealed	166	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	156	°C	ASTM D 648
CTE, -40°C to 40°C, flow	6.E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	6.E-05	1/°C	ASTM E 831
Thermal Conductivity @ 25 °C	0.2	W/m-°C	ASTM C177
CTE, -40°C to 40°C, flow	6.E-05	1/°C	ISO 11359-2

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CTE, -40°C to 40°C, xflow	6.E-05	1/°C	ISO 11359-2
Vicat Softening Temp, Rate B/50	168	°C	ISO 306
Vicat Softening Temp, Rate B/120	170	°C	ISO 306
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	164	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	152	°C	ISO 75/Af
PHYSICAL			
Specific Gravity	1.2	-	ASTM D 792
Density	1.2	g/cm ³	ISO 1183
Water Absorption, (23°C/saturated)	0.3	%	ISO 62-1
Moisture Absorption (23°C / 50% RH)	0.3	%	ISO 62
Melt Volume Rate, MVR at 300°C/1.2 kg	16	cm ³ /10 min	ISO 1133
Melt Volume Rate, MVR at 330°C/2.16kg	30	cm ³ /10 min	ISO 1133
INJECTION MOLDING			
Drying Temperature	135	°C	
Drying Time	4 – 6	hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	290 – 350	°C	
Nozzle Temperature	285 – 345	°C	
Front - Zone 3 Temperature	290 – 350	°C	
Middle - Zone 2 Temperature	280 – 340	°C	
Rear - Zone 1 Temperature	270 – 330	°C	
Mold Temperature	95 – 130	°C	
Back Pressure	0.3 – 0.7	MPa	
Screw Speed	40 – 90	rpm	
Shot to Cylinder Size	40 – 60	%	
Vent Depth	0.025 – 0.08	mm	

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