

LEXANT™ COPOLYMER XHT1171

REGION AMERICAS

DESCRIPTION

XHT1171 is an 85 MVR high flow, high heat polycarbonate copolymer enabling high aesthetics, thin wall and complex designs. It is available in a range of opaque colors.

TYPICAL PROPERTY VALUES

Revision 20231130

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL ⁽¹⁾			
Tensile Stress, yld, Type I, 50 mm/min	70	MPa	ASTM D638
Tensile Stress, brk, Type I, 50 mm/min	60	MPa	ASTM D638
Tensile Strain, yld, Type I, 50 mm/min	7	%	ASTM D638
Tensile Strain, brk, Type I, 50 mm/min	>25	%	ASTM D638
Tensile Modulus, 50 mm/min	2450	MPa	ASTM D638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	110	MPa	ASTM D790
Flexural Modulus, 1.3 mm/min, 50 mm span	2600	MPa	ASTM D790
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	7	%	ISO 527
Tensile Strain, break, 50 mm/min	>55	%	ISO 527
Tensile Modulus, 1 mm/min	2400	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	105	MPa	ISO 178
Flexural Modulus, 2 mm/min	2350	MPa	ISO 178
Ball Indentation Hardness, H358/30	145	MPa	ISO 2039-1
Hardness, Rockwell R	125	-	ISO 2039-2
IMPACT ⁽¹⁾			
Izod Impact, unnotched, 23°C	NB	J/m	ASTM D4812
Izod Impact, unnotched, -30°C	NB	J/m	ASTM D4812
Izod Impact, notched, 23°C	80	J/m	ASTM D256
Izod Impact, notched, -30°C	75	J/m	ASTM D256
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	10	kJ/m ²	ISO 179/1eA
Charpy -30°C, V-notch Edgew 80*10*3 sp=62mm	10	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 ⁽¹⁾			
Vicat Softening Temp, Rate B/50	155	°C	ASTM D1525
Vicat Softening Temp, Rate B/120	156	°C	ASTM D1525
HDT, 0.45 MPa, 3.2 mm, unannealed	150	°C	ASTM D648
HDT, 1.82 MPa, 3.2mm, unannealed	138	°C	ASTM D648

© 2023 Copyright by SABIC. All rights reserved

CHEMISTRY THAT MATTERS™

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
CTE, -40°C to 40°C, flow	6.E-05	1/°C	ASTM E83 1
CTE, -40°C to 40°C, xflow	6.E-05	1/°C	ASTM E83 1
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
CTE, -40°C to 40°C, xflow	6.E-05	1/°C	ISO 11359-2
Ball Pressure Test, 125°C +/- 2°C	PASSES	-	IEC 60695-10-2
Vicat Softening Temp, Rate B/50	155	°C	ISO 306
Vicat Softening Temp, Rate B/120	158	°C	ISO 306
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	150	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	138	°C	ISO 75/Af
Metallized Haze pass at 1.5mm	145	°C	SABIC method
PHYSICAL ⁽¹⁾			
Specific Gravity	1.2	-	ASTM D792
Mold Shrinkage, flow, 3.2 mm ⁽²⁾	0.6 – 0.9	%	SABIC method
Melt Flow Rate, 300°C/2.16 kgf	37	g/10 min	ASTM D1238
Melt Flow Rate, 330°C/2.16 kgf	90	g/10 min	ASTM D1238
Density	1.2	g/cm³	ISO 1183
Water Absorption, (23°C/saturated)	0.25	%	ISO 62-1
Moisture Absorption (23°C / 50% RH)	0.25	%	ISO 62
Melt Volume Rate, MVR at 300°C/2.16 kg	33	cm³/10 min	ISO 1133
Melt Volume Rate, MVR at 330°C/2.16kg	85	cm³/10 min	ISO 1133
INJECTION MOLDING ⁽³⁾			
Drying Temperature	130	°C	
Drying Time	4 – 6	Hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	290 – 335	°C	
Nozzle Temperature	285 – 330	°C	
Front - Zone 3 Temperature	290 – 335	°C	
Middle - Zone 2 Temperature	280 – 325	°C	
Rear - Zone 1 Temperature	270 – 315	°C	
Mold Temperature	85 – 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	

(1) The information stated on Technical Datasheets should be used as indicative only for material selection purposes and not be utilized as specification or used for part or tool design.

(2) Measurements made from laboratory test coupon. Actual shrinkage may vary outside of range due to differences in processing conditions, equipment, part geometry and tool design. It is recommended that mold shrinkage studies be performed with surrogate or legacy tooling prior to cutting tools for new molded article. The information stated on Technical Datasheets should be used as indicative only for material selection purposes and not be utilized as specification or used for part or tool design.

(3) Injection Molding parameters are only mentioned as general guidelines. These may not apply or may need adjustment in specific situations such as low shot sizes, large part molding, thin wall molding and gas-assist molding.

MORE INFORMATION

For curve data and CAE cards, please visit and register at <https://materialfinder.sabic-specialties.com>

© 2023 Copyright by SABIC. All rights reserved

CHEMISTRY THAT MATTERS™



ADDITIONAL PRODUCT NOTES

No PFAS intentionally added: The grade listed in this document does not contain PFAS intentionally added during Seller's manufacturing process and is not expected to contain unintentional PFAS impurities. Each user is responsible for evaluating the presence of unintentional PFAS impurities.

DISCLAIMER

Any sale by SABIC, its subsidiaries and affiliates (each a "seller"), is made exclusively under seller's standard conditions of sale (available upon request) unless agreed otherwise in writing and signed on behalf of the seller. While the information contained herein is given in good faith, SELLER MAKES NO WARRANTY, EXPRESS OR IMPLIED, INCLUDING MERCHANTABILITY AND NONINFRINGEMENT OF INTELLECTUAL PROPERTY, NOR ASSUMES ANY LIABILITY, DIRECT OR INDIRECT, WITH RESPECT TO THE PERFORMANCE, SUITABILITY OR FITNESS FOR INTENDED USE OR PURPOSE OF THESE PRODUCTS IN ANY APPLICATION. Each customer must determine the suitability of seller materials for the customer's particular use through appropriate testing and analysis. No statement by seller concerning a possible use of any product, service or design is intended, or should be construed, to grant any license under any patent or other intellectual property right.