

# LEXAN<sup>\*</sup> HPXXS Film

## Product Datasheet

### DESCRIPTION

LEXAN<sup>\*</sup> HPXXS graphic films are high-performance coated films offering very good chemical and abrasion resistance together with unique processing characteristics. These highly durable, easily printed films create new opportunities in graphic design with a unique package of benefits:

- Flexible UV processing
- Multiple topside selective texturing
- Color topside texturing
- Durability of coating and texture adhesion when exposed to strong household chemicals such as Wisk<sup>®</sup> or Formula 409<sup>®</sup>

### Typical Property Values<sup>1</sup>

Property	ASTM (ISO) Test Method	Units USCS (SI)	HP12S	HP40S	HP60S	HP92S
<b>Mechanical</b>						
Tensile Strength						
@ Yield	ASTM D882 (ISO 527)	psi (MPa)	8800 (60)	8800 (60)	8800 (60)	8800 (60)
Ultimate	ASTM D882 (ISO 527)	psi (MPa)	9000 (62)	9000 (62)	9000 (62)	9000 (62)
Tear Strength						
Initiation	ASTM D1004	lb/mil (kN/m)	1.51 (264)	1.51 (264)	1.51 (264)	1.51 (264)
Propogation	ASTM D1922	g/mil (kN/m)	38.7 (40)	38.7 (40)	38.7 (40)	38.7 (40)
<b>Thermal</b>						
Vicat Softening Temperature, B	ASTM 1525	°F (°C)	320 (160)	320 (160)	320 (160)	320 (160)
Heat Deflection Temp. by TMA at 1.8 MPa	ISO 75 Modified	°F (°C)	290 (143)	290 (143)	290 (143)	290 (143)
Shrinkage at 302 °F (150 °C)	ASTM D1204	%	1.40%	1.40%	1.40%	1.40%
<b>Physical</b>						
Density	ASTM D792 (ISO 1183)	slug/ft <sup>3</sup> (kg/m <sup>3</sup> )	75 (1200)	75 (1200)	75 (1200)	75 (1200)
Surface Energy (1st surface / 2nd surface)	ASTM D5946-01	-	44/34	38/34	38/34	36/34
Surface Tension (1st surface / 2nd surface)	Dyne Pens	Dyne	>44/38-40	40-42/38-40	32-34/38-40	38-40/38-40
Pencil Hardness (1st surface / 2nd surface)	ASTM D3363	-	hb-f/b-hb	hb-f/b-hb	hb-f/b-hb	hb-f/b-hb
Taber Abrasion	ASTM D1044	delta Haze	<2	4	3	4
<b>Optical</b>						
Refractive Index @ 77 °F (25 °C)	ASTM D542A	-	1.5	1.5	1.5	1.5
Light Transmission	ASTM D1003	%	91	92	92	92
Yellowness Index	ASTM D1925	%	0.9	0.8	0.8	0.5
Haze	ASTM D1003	%	45	12	6	0.5
Gloss over Flat Black min/max @ 60°	ASTM D523-60 (ISO 2813)	-	12	40	60	92

### Manufacturing Specifications

Nominal Gauge Ranges	Min./Max Limit of Nominal
0.007" (0.175 mm)	± 10%
0.010-0.015" (0.250-0.375 mm)	± 5%
0.020-0.030" (0.500-0.750 mm)	± 3%



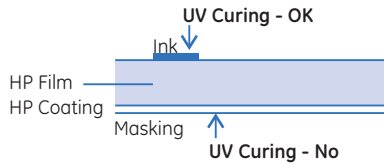
<sup>1</sup> These are typical properties and are not intended for specification purposes. If minimum certifiable properties are required, please contact your local GE Advanced Materials, Specialty Film & Sheet representative or the GE Advanced Materials, Specialty Film & Sheet Quality Services Department. Reported values are based on 0.010" (0.250 mm) thickness unless otherwise noted.

\* LEXAN is a trademark of General Electric Company.

# GE Advanced Materials Specialty Film & Sheet

## MASKING

The standard masking on HP film is not designed to have UV radiation (for curing) passed through it. If this is required, alternate masking is available. Please contact your sales representative for more details.



## CHEMICAL AND ABRASION RESISTANCE

A unique feature of LEXAN® HPXXS films is receptivity to multiplepass, first-surface decoration for selective textures and/or color graphics. This feature requires that the coating be chemically sensitive to a variety of ink formulations. As a result, the coating is subject to attack by aggressive industrial chemicals and some strong household cleaners. Both the chemical resistance and the hardness of the coating can be enhanced by exposing the coated surface of the film to UV curing conditions.

### Taber Abrasion Resistance (ASTM D1044) LEXAN HPXXW Graphic Film

Condition	Units	As Manufactured	Post Cured***
CS10F Wheel 500 grams			
25	Change in % Haze	1.7	1
50	Change in % Haze	3.2	2
100	Change in % Haze	6.5	4.1
200	Change in % Haze	12.9	9

\*\*\* Post cure conditions: One elliptical focused medium pressure mercury vapor lamp at 300 watts/inch and a conveyor speed of 20 feet/minute.

- \* Wisk is a registered trademark of Lever Brothers Company
- \* Formula 409 is a registered trademark of Clorox Company
- \* Top Job, Downy, and Mr. Clean are registered trademarks of Procter & Gamble
- \* Fantastik and Spray 'N Wash are registered trademarks of Texize, Division of Norton Norwich Products, Inc.
- \* Windex w/Ammonia D is a registered trademark of Drackett Products Company

Chemical	Results*	
	As Manufactured	Post Cured**
<b>One Hour Continuous Surface Contact at 73 °F</b>		
Acetone	Failed	Passed
MEK	Failed	Passed
Toluene	Failed	Passed
Methylene Chloride	Failed	Passed
Isopropyl Alcohol	Passed	Passed
Cyclohexanone	Failed	Passed
Ethyl Acetate	Failed	Passed
Xylene	Failed	Passed
40% NaOH	Failed	Passed
Concentrated HCl	Passed	Passed
Gasoline (Regular)	Passed	Passed
Gasoline (Unleaded)	Passed	Passed
Butyl Cellosolve	Failed	Passed
<b>24 Hour Surface Exposure at 120 °F</b>		
Coffee	Passed	Passed
Top Job*	Passed	Passed
Fantastik*	Passed	Passed
Formula 409*	Passed	Passed
Windex w/Ammonia D*	Passed	Passed
Wisk*	Passed	Passed
Downy*	Passed	Passed
Spray N Wash*	Passed	Passed
Clorox*	Passed	Passed
Mustard	Passed	Passed
Mr. Clean*	Passed	Passed
Ketchup	Passed	Passed
Tea	Passed	Passed
Tomato Juice	Passed	Passed
Lemon Juice	Passed	Passed
Grape Juice	Passed	Passed
Vinegar	Passed	Passed
Milk	Passed	Passed

\* Failure constitutes any of the following: non-removable stain or cloudiness, blistering, delamination, or cracking of the coating or failure to pass crosshatch tape adhesion.

\*\* Post cure conditions: One elliptical focused medium pressure mercury vapor lamp at 300 watts/inch and a conveyor speed of 20 feet/minute.



## GE Advanced Materials Specialty Film & Sheet

Europe:  
GE Advanced Materials  
Specialty Film & Sheet  
Plasticslaan 1  
PO Box 112  
NL - 4600 AC Bergen op Zoom  
The Netherlands  
Tel. +31 (164) 292742  
Fax. +31 (164) 291986

Americas:  
GE Advanced Materials  
Specialty Film & Sheet  
One Plastics Avenue  
Pittsfield, MA 01201  
USA  
Tel. +1 (413) 448 7110  
Fax. +1 (413) 448 7506

Pacific:  
GE Advanced Materials  
Specialty Film & Sheet  
1266 Nanjing Road (W)  
16th Floor, Plaza 66  
200040 Shanghai  
China  
Tel. +86 21 6288 1088  
Fax. +86 21 6288 0818

For more information call: (800) 451-3147

Visit us online at: [www.geadvancedmaterials.com](http://www.geadvancedmaterials.com)

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