

LEXAN™ LUX2289 resin

Polycarbonate

SABIC Innovative Plastics

Message:

LEXAN LUX2289 resin is an injection molding grade with high light reflectance

General Information			
UL YellowCard	E121562-101123425		
Features	High Reflectivity		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
--	1.34	g/cm ³	ASTM D792
--	1.31	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	17	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm)	0.50 to 0.70	%	Internal Method
Water Absorption			ISO 62
Saturation, 23°C	0.35	%	
Equilibrium, 23°C, 50% RH	0.15	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹			ASTM D638
Yield	60.0	MPa	
Break	61.0	MPa	
Tensile Elongation ²			ASTM D638
Yield	6.0	%	
Break	120	%	
Flexural Modulus ³ (50.0 mm Span)	2670	MPa	ASTM D790
Flexural Strength ⁴ (Yield, 50.0 mm Span)	98.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-30°C	170	J/m	
23°C	650	J/m	
Unnotched Izod Impact (23°C)	2100	J/m	ASTM D4812
Instrumented Dart Impact (23°C, Total Energy)	69.0	J	ASTM D3763
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed, 3.20 mm	136	°C	
1.8 MPa, Unannealed, 3.20 mm	124	°C	
Vicat Softening Temperature	142	°C	ASTM D1525 ⁵

CLTE		ASTM E831
Flow : -40 to 40°C	6.0E-5	cm/cm/°C
Transverse : -40 to 40°C	6.3E-5	cm/cm/°C
Injection	Nominal Value	Unit
Drying Temperature	121	°C
Drying Time	3.0 to 4.0	hr
Drying Time, Maximum	48	hr
Suggested Max Moisture	0.020	%
Suggested Shot Size	40 to 60	%
Rear Temperature	260 to 282	°C
Middle Temperature	271 to 293	°C
Front Temperature	282 to 304	°C
Nozzle Temperature	277 to 299	°C
Processing (Melt) Temp	282 to 304	°C
Mold Temperature	71.0 to 93.0	°C
Back Pressure	0.345 to 0.689	MPa
Screw Speed	40 to 70	rpm
Vent Depth	0.025 to 0.076	mm
NOTE		
1.	Type I, 50 mm/min	
2.	Type I, 50 mm/min	
3.	1.3 mm/min	
4.	1.3 mm/min	
5.	Rate B (120°C/h), Loading 2 (50 N)	

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