

LEXAN™ EM1210 resin

Polycarbonate

SABIC Innovative Plastics

Message:

Automotive interiors. Excellent heat/impact resistance and outstanding property retention over wide temperature range/severe automotive conditions

General Information	
Features	Good Impact Resistance
	High Heat Resistance
Uses	Automotive Interior Parts
Processing Method	Injection Molding
Multi-Point Data	Specific Heat vs. Temperature (ASTM D3417)
	Tensile Creep (ASTM D2990)
	Tensile Fatigue
	Tensile Stress vs. Strain (ASTM D638)

Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.19	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	13	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm)	0.50 to 0.70	%	Internal Method
Water Absorption (24 hr)	0.16	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield)	57.2	MPa	ASTM D638
Tensile Elongation ² (Break)	110	%	ASTM D638
Flexural Modulus ³ (50.0 mm Span)	2030	MPa	ASTM D790
Flexural Strength ⁴ (Yield, 50.0 mm Span)	81.4	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-30°C	690	J/m	
23°C	770	J/m	
23°C, 6.40 mm	690	J/m	
Instrumented Dart Impact			ASTM D3763
-30°C, Energy at Peak Load	65.5	J	
23°C, Energy at Peak Load	61.0	J	
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed, 6.40 mm	135	°C	
1.8 MPa, Unannealed, 6.40 mm	128	°C	
CLTE - Flow (-40 to 95°C)	6.5E-5	cm/cm/°C	ASTM E831

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	271 to 293	°C
Middle Temperature	282 to 304	°C
Front Temperature	293 to 316	°C
Nozzle Temperature	288 to 310	°C
Processing (Melt) Temp	293 to 316	°C
Mold Temperature	71.1 to 93.3	°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 |

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