

LEXAN™ LUX2619 resin

Polycarbonate
SABIC Innovative Plastics

Message:

LEXAN LUX2619 Polycarbonate resin is an extrusion grade. It is UL94 V-2 rated at 1.5 mm. It was designed for high light reflectance.

General Information			
UL YellowCard	E121562-101272789		
Features	High Reflectivity		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.34	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	7.5	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm)	0.80 to 1.0	%	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	57.0	MPa	
Break	50.0	MPa	
Tensile Elongation ²			ASTM D638
Yield	6.0	%	
Break	74	%	
Flexural Modulus ³ (50.0 mm Span)	2730	MPa	ASTM D790
Flexural Strength ⁴ (Yield, 50.0 mm Span)	97.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-30°C	140	J/m	
23°C	640	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	141	°C	
1.8 MPa, Unannealed, 3.20 mm	129	°C	
Vicat Softening Temperature	147	°C	ASTM D1525 ⁵
CLTE			ASTM E831
Flow : -40 to 40°C	6.1E-5	cm/cm/°C	

Transverse : -40 to 40°C	6.4E-5	cm/cm/°C	
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.50 mm)	V-2		UL 94
Glow Wire Flammability Index (1.00 to 3.00 mm)	960	°C	IEC 60695-2-12
Glow Wire Ignition Temperature			IEC 60695-2-13
1.00 mm	875	°C	
3.00 mm	850	°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	288 to 310	°C	
Middle Temperature	299 to 321	°C	
Front Temperature	310 to 332	°C	
Nozzle Temperature	304 to 327	°C	
Processing (Melt) Temp	310 to 332	°C	
Mold Temperature	82.2 to 116	°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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