

LEXAN™ LUX1169 resin

Polycarbonate

SABIC Innovative Plastics Europe

Message:

LEXAN LUX1169

General Information			
RoHS Compliance	RoHS Compliant		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.33	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (300°C/1.2 kg)	21.0	cm ³ /10min	ISO 1133
Water Absorption			ISO 62
Saturation, 23°C	0.35	%	
Equilibrium, 23°C, 50% RH	0.15	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2500	MPa	ISO 527-2/1
Tensile Stress			ISO 527-2/50
Yield	60.0	MPa	
Break	50.0	MPa	
Tensile Strain			ISO 527-2/50
Yield	6.0	%	
Break	60	%	
Flexural Modulus ¹	2400	MPa	ISO 178
Flexural Stress	90.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ²			ISO 179/1eA
-30°C	10	kJ/m ²	
23°C	60	kJ/m ²	
Charpy Unnotched Impact Strength ³			ISO 179/1eU
-30°C	No Break		
23°C	No Break		
Notched Izod Impact Strength ⁴			ISO 180/1A
-30°C	10	kJ/m ²	
23°C	60	kJ/m ²	
Unnotched Izod Impact Strength ⁵			ISO 180/1U
-30°C	No Break		
23°C	No Break		
Thermal	Nominal Value	Unit	Test Method

Vicat Softening Temperature			
--	140	°C	ISO 306/B50
--	141	°C	ISO 306/B120
CLTE - Transverse (-40 to 40°C)	6.0E-5	cm/cm/°C	ISO 11359-2
Injection	Nominal Value	Unit	
Drying Temperature	120	°C	
Drying Time	2.0 to 4.0	hr	
Suggested Max Moisture	0.020	%	
Hopper Temperature	60.0 to 80.0	°C	
Rear Temperature	260 to 280	°C	
Middle Temperature	270 to 290	°C	
Front Temperature	280 to 300	°C	
Nozzle Temperature	270 to 290	°C	
Processing (Melt) Temp	280 to 300	°C	
Mold Temperature	80.0 to 100	°C	
NOTE			
1.	2.0 mm/min		
2.	80*10*3 sp=62mm		
3.	80*10*3 sp=62mm		
4.	80*10*3		
5.	80*10*3		

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