

LEXAN™ EM3110R resin

Polycarbonate

SABIC Innovative Plastics Asia Pacific

Message:

Automotive interiors. Optimizes flow/processability for cost effective thinner wall design uses. Internal mold release.

General Information			
Additive	Mold Release		
Features	Good Flow		
Uses	Automotive Interior Parts		
Processing Method	Injection Molding		
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)	20	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)	55.2	MPa	ASTM D638
Tensile Elongation ² (Break)	90	%	ASTM D638
Flexural Modulus ³ (50.0 mm Span)	2170	MPa	ASTM D790
Flexural Strength ⁴ (Yield, 50.0 mm Span)	82.7	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-30°C	210	J/m	
-20°C	590	J/m	
23°C	640	J/m	
23°C, 6.40 mm	210	J/m	
Instrumented Dart Impact (23°C, Energy at Peak Load)	56.5	J	ASTM D3763
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed, 6.40 mm	127	°C	
1.8 MPa, Unannealed, 3.20 mm	118	°C	
1.8 MPa, Unannealed, 6.40 mm	124	°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	10	hr	
Suggested Max Moisture	0.020	%	

Suggested Shot Size	40 to 60	%
Rear Temperature	254 to 277	°C
Middle Temperature	266 to 288	°C
Front Temperature	277 to 299	°C
Nozzle Temperature	271 to 293	°C
Processing (Melt) Temp	277 to 299	°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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