

LEXAN™ EM3110 resin

Polycarbonate

SABIC Innovative Plastics

Message:

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

General Information	
UL YellowCard	E121562-220914
Features	Good Flow
Uses	Automotive Interior Parts
Processing Method	Injection Molding
Multi-Point Data	Coefficient of Thermal Expansion vs. Temperature (ASTM E831)
	Compressive Stress vs. Strain (ASTM D695)
	Elastic Modulus vs Temperature (ASTM D4065)
	Flexural DMA (ASTM D4065)
	Pressure-Volume-Temperature (PVT - Zoller Method)
	Shear DMA (ASTM D4065)
	Specific Heat vs. Temperature (ASTM D3417)
	Tensile Creep (ASTM D2990)
	Tensile Fatigue
	Tensile Stress vs. Strain (ASTM D638)
	Thermal Conductivity vs. Temperature (ASTM E1530)
	Viscosity vs. Shear Rate (ASTM D3835)

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)	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	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
RTI Elec	80.0	°C	UL 746
RTI Imp	80.0	°C	UL 746
RTI Str	80.0	°C	UL 746
Flammability	Nominal Value		Test Method
Flame Rating (1.47 mm)	HB		UL 94
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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