

LEXAN™ OQ2720 resin

Polycarbonate
SABIC Innovative Plastics

Message:
Ophthalmic/safety lens market. OQ2xxx series in all transparent tints. Dedicated equipment, stringent production control conditions.

General Information			
Uses	Lenses		
	Safety Equipment		
Appearance	Clear/Transparent		
	Colors Available		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.20	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	7.5	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm)	0.50 to 0.70	%	Internal Method
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹			ASTM D638
Yield	62.1	MPa	
Break	68.9	MPa	
Tensile Elongation ² (Break)	140	%	ASTM D638
Flexural Modulus ³ (50.0 mm Span)	2340	MPa	ASTM D790
Flexural Strength ⁴ (Yield, 50.0 mm Span)	96.5	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	910	J/m	ASTM D256
Instrumented Dart Impact (23°C, Energy at Peak Load)	65.1	J	ASTM D3763
Tensile Impact Strength ⁵	641	kJ/m ²	ASTM D1822
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 6.40 mm)	132	°C	ASTM D648
Optical	Nominal Value	Unit	Test Method
Refractive Index	1.586		ASTM D542
Transmittance (2540 µm)	89.0	%	ASTM D1003
Haze (2540 µm)	0.60	%	ASTM D1003
Yellowness Index	0.50	YI	ASTM D1925
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. | Type S |

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