

LEXAN™ LUX2110T resin

Polycarbonate

SABIC Innovative Plastics

Message:

Global grade. LEXAN LUX2110T is an injection molding grade especially designed for manufacturing optical parts requiring easy flow properties combined with very high transmission and color stability.

General Information			
Features	Good Color Stability		
	Good Flow		
	High Light Transmission		
Uses	Optical Applications		
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)	19	g/10 min	ASTM D1238
Molding Shrinkage - Flow ¹	0.60 to 0.90	%	Internal Method
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ²	2220	MPa	ASTM D638
Tensile Strength ³			ASTM D638
Yield	60.0	MPa	
Break	68.0	MPa	
Tensile Elongation ⁴			ASTM D638
Yield	7.0	%	
Break	140	%	
Flexural Modulus ⁵ (50.0 mm Span)	2360	MPa	ASTM D790
Flexural Strength ⁶ (Yield, 50.0 mm Span)	96.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-30°C	140	J/m	
23°C	790	J/m	
Unnotched Izod Impact (23°C)	2100	J/m	ASTM D4812
Instrumented Dart Impact (23°C, Energy at Peak Load)	72.0	J	ASTM D3763
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed, 3.20 mm	142	°C	
1.8 MPa, Unannealed, 3.20 mm	129	°C	
Vicat Softening Temperature	145	°C	ISO 306/B120
CLTE			ASTM E831

Flow : -40 to 95°C	6.5E-5	cm/cm/°C	
Transverse : -40 to 95°C	6.4E-5	cm/cm/°C	
Optical	Nominal Value	Unit	Test Method
Transmittance (2540 μm)	> 90.0	%	ASTM D1003
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	271 to 293	°C	
Middle Temperature	282 to 304	°C	
Front Temperature	293 to 316	°C	
Nozzle Temperature	288 to 310	°C	
Processing (Melt) Temp	293 to 316	°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. | Tensile Bar |
| 2. | 50 mm/min |
| 3. | Type I, 50 mm/min |
| 4. | Type I, 50 mm/min |
| 5. | 1.3 mm/min |
| 6. | 1.3 mm/min |

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