

LEXAN™ EM1210 resin

Polycarbonate

SABIC Innovative Plastics

Message:

Automotive interiors. Excellent heat/impact resistance and outstanding property retention over wide temperature range/severe automotive conditions

General Information			
Features	Impact resistance, good		
	Heat resistance, high		
Uses	Car 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)	13	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm)	0.50 - 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	690	J/m	ASTM D256
23°C	770	J/m	ASTM D256
23°C, 6.40 mm	690	J/m	ASTM D256
Instrumented Dart Impact			ASTM D3763
-30°C, Energy at Peak Load	65.5	J	ASTM D3763
23°C, Energy at Peak Load	61.0	J	ASTM D3763
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, unannealed, 6.40mm	135	°C	ASTM D648
1.8 MPa, unannealed, 6.40mm	128	°C	ASTM D648
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 - 4.0	hr	
Drying Time, Maximum	48	hr	
Suggested Max Moisture	0.020	%	

Suggested Shot Size	40 - 60	%
Rear Temperature	271 - 293	°C
Middle Temperature	282 - 304	°C
Front Temperature	293 - 316	°C
Nozzle Temperature	288 - 310	°C
Processing (Melt) Temp	293 - 316	°C
Mold Temperature	71.1 - 93.3	°C
Back Pressure	0.345 - 0.689	MPa
Screw Speed	40 - 70	rpm
Vent Depth	0.025 - 0.076	mm

NOTE

1. Type 1, 50mm/min
2. Type 1, 50mm/min
3. 1.3 mm/min
4. 1.3 mm/min

The information and data on this page are provided by manufacturers and document providers. SHANGHAI SUSHENG assumes no legal liability. It is strongly recommended to verify all technical data with material suppliers before final material selection. All rights belong to the original authors. If any infringement occurs, please contact us immediately.

Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China



WECHAT