

LEXAN™ LUX2619 resin

Polycarbonate

SABIC Innovative Plastics

Message:

LEXAN LUX2619 Polycarbonate resin is an extrusion grade. It is UL94 V-2 rated at 1.5 mm. It was designed for high light reflectance.

General Information			
UL YellowCard	E45329-101345863		
Features	High reflectivity		
RoHS Compliance	RoHS compliance		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.34	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	7.5	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm)	0.80 - 1.0	%	Internal method
Water Absorption			ISO 62
Saturated, 23°C	0.35	%	ISO 62
Equilibrium, 23°C, 50% RH	0.15	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2500	MPa	ISO 527-2/1
Tensile Strength			
Yield ¹	57.0	MPa	ASTM D638
Yield	60.0	MPa	ISO 527-2/50
Fracture ²	50.0	MPa	ASTM D638
Fracture	50.0	MPa	ISO 527-2/50
Tensile Elongation			
Yield ³	6.0	%	ASTM D638
Yield	6.0	%	ISO 527-2/50
Fracture ⁴	74	%	ASTM D638
Fracture	75	%	ISO 527-2/50
Flexural Modulus			
50.0mm span ⁵	2730	MPa	ASTM D790
-- ⁶	2500	MPa	ISO 178
Flexural Stress			
--	90.0	MPa	ISO 178
Yield, 50.0mm span ⁷	97.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ⁸			ISO 179/1eA
-30°C	10	kJ/m ²	ISO 179/1eA
23°C	60	kJ/m ²	ISO 179/1eA

Charpy Unnotched Impact Strength ⁹			ISO 179/1eU
-30°C	140	kJ/m ²	ISO 179/1eU
23°C	140	kJ/m ²	ISO 179/1eU
Notched Izod Impact			
-30°C	140	J/m	ASTM D256
23°C	640	J/m	ASTM D256
-30°C ¹⁰	42	kJ/m ²	ISO 180/1A
23°C ¹¹	64	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	2100	J/m	ASTM D4812
-30°C ¹²	180	kJ/m ²	ISO 180/1U
23°C ¹³	180	kJ/m ²	ISO 180/1U
Instrumented Dart Impact (23°C, Total Energy)	69.0	J	ASTM D3763
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, unannealed, 3.20mm	141	°C	ASTM D648
1.8 MPa, unannealed, 3.20mm	129	°C	ASTM D648
1.8 MPa, annealed ¹⁴	141	°C	ISO 75-2/Ae
Vicat Softening Temperature			
--	147	°C	ASTM D1525, ISO 306/B50 10 ¹⁵
--	148	°C	ISO 306/B120
Linear thermal expansion coefficient			ASTM E831
Flow: -40 to 40°C	6.1E-5	cm/cm/°C	ASTM E831
Lateral: -40 to 40°C	6.4E-5	cm/cm/°C	ASTM E831
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.50 mm)	V-2		UL 94
Glow Wire Flammability Index (1.00 to 3.00 mm)	960	°C	IEC 60695-2-12
Glow Wire Ignition Temperature			IEC 60695-2-13
1.00 mm	875	°C	IEC 60695-2-13
3.00 mm	850	°C	IEC 60695-2-13
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	288 - 310	°C	
Middle Temperature	299 - 321	°C	
Front Temperature	310 - 332	°C	
Nozzle Temperature	304 - 327	°C	

Processing (Melt) Temp	310 - 332	°C
Mold Temperature	82.2 - 116	°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.	Type 1, 50mm/min	
4.	Type 1, 50mm/min	
5.	1.3 mm/min	
6.	2.0 mm/min	
7.	1.3 mm/min	
8.	80*10*3 sp=62mm	
9.	80*10*3 sp=62mm	
10.	80*10*3	
11.	80*10*3	
12.	80*10*3	
13.	80*10*3	
14.	2 hr, 120°C	
15.	标准 B (120°C/h), 载荷2 (50N)	

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