



LEXAN™ Resin LUX2110T

Americas: COMMERCIAL

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.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	610	kgf/cm ²	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	690	kgf/cm ²	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	7	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	143	%	ASTM D 638
Tensile Modulus, 50 mm/min	22600	kgf/cm ²	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	970	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	24000	kgf/cm ²	ASTM D 790
IMPACT			
Izod Impact, unnotched, 23°C	218	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	80	cm-kgf/cm	ASTM D 256
Izod Impact, notched, -30°C	14	cm-kgf/cm	ASTM D 256
Instrumented Impact Energy @ peak, 23°C	734	cm-kgf	ASTM D 3763
THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	142	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	129	°C	ASTM D 648
CTE, -40°C to 95°C, flow	6.5E-05	1/°C	ASTM E 831
CTE, -40°C to 95°C, xflow	6.4E-05	1/°C	ASTM E 831
Vicat Softening Temp, Rate B/120	145	°C	ISO 306
PHYSICAL			
Specific Gravity	1.2	-	ASTM D 792
Density	1.2	g/cm ³	ASTM D 792
Mold Shrinkage on Tensile Bar, flow (2) (5)	0.6 - 0.9	%	SABIC Method
Melt Flow Rate, 300°C/1.2 kgf	19	g/10 min	ASTM D 1238
OPTICAL			
Light Transmission, 2.54 mm	>90	%	ASTM D 1003

(1) Typical values only. Variations within normal tolerances are possible for various colors. All values are measured after at least 48 hours storage at 23°C/50% relative humidity. All properties, except the melt volume and melt flow rates, are measured on injection molded samples. All samples tested under ISO test standards are prepared according to ISO 294.

(2) Only typical data for selection purposes. Not to be used for part or tool design.

(3) This rating is not intended to reflect hazards presented by this or any other material under actual fire conditions.

(4) Internal measurements according to UL standards.

(5) Measurements made from laboratory test coupon. Actual shrinkage may vary outside of range due to differences in processing conditions, equipment, part geometry and tool design. It is recommended that mold shrinkage studies be performed with surrogate or legacy tooling prior to cutting tools for new molded article.

(6) Needs hard coat to consistently pass 60 sec Vertical Burn.

Source GMD, last updated:

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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	120	°C
Drying Time	3 - 4	hrs
Drying Time (Cumulative)	48	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	295 - 315	°C
Nozzle Temperature	290 - 310	°C
Front - Zone 3 Temperature	295 - 315	°C
Middle - Zone 2 Temperature	280 - 305	°C
Rear - Zone 1 Temperature	270 - 295	°C
Mold Temperature	70 - 95	°C
Back Pressure	0.3 - 0.7	MPa
Screw Speed	40 - 70	rpm
Shot to Cylinder Size	40 - 60	%
Vent Depth	0.025 - 0.076	mm

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