



LEXANT™ RESIN EM3110

REGION AMERICAS

DESCRIPTION

LEXANT™ EM3110 resin is a 20 MFR polycarbonate. Impact resistant at -20oC. UL94 HB rated. Optimized flow and processability for cost effective thinner wall designs. Suitable for automotive interiors.

TYPICAL PROPERTY VALUES

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	57	MPa	ASTM D638
Tensile Strain, brk, Type I, 50 mm/min	110	%	ASTM D638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	81	MPa	ASTM D790
Flexural Modulus, 1.3 mm/min, 50 mm span	2030	MPa	ASTM D790
IMPACT			
Izod Impact, notched, 23°C	640	J/m	ASTM D256
Izod Impact, notched, -20°C	587	J/m	ASTM D256
Izod Impact, notched, -30°C	213	J/m	ASTM D256
Izod Impact, notched, 23°C, 6.4mm	213	J/m	ASTM D256
Instrumented Dart Impact Energy @ peak, 23°C	56	J	ASTM D3763
THERMAL			
HDT, 1.82 MPa, 3.2mm, unannealed	118	°C	ASTM D648
HDT, 0.45 MPa, 6.4 mm, unannealed	126	°C	ASTM D648
HDT, 1.82 MPa, 6.4 mm, unannealed	123	°C	ASTM D648
CTE, -40°C to 95°C, flow	6.48E-05	1/°C	ASTM E831
Relative Temp Index, Elec	80	°C	UL 746B
Relative Temp Index, Mech w/impact	80	°C	UL 746B
Relative Temp Index, Mech w/o impact	80	°C	UL 746B
PHYSICAL			
Specific Gravity	1.19	-	ASTM D792
Water Absorption, (23°C/24hrs)	0.16	%	ASTM D570
Mold Shrinkage, flow, 3.2 mm	0.5 – 0.7	%	SABIC method
Melt Flow Rate, 300°C/ 1.2 kgf	20	g/10 min	ASTM D1238
FLAME CHARACTERISTICS			
UL Yellow Card Link	E121562-220914	-	-
UL Recognized, 94HB Flame Class Rating	1.47	mm	UL 94
INJECTION MOLDING			
Drying Temperature	120	°C	
Drying Time	3 – 4	Hrs	
Drying Time (Cumulative)	10	Hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	275 – 300	°C	
Nozzle Temperature	270 – 295	°C	
Front - Zone 3 Temperature	275 – 300	°C	



PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Middle - Zone 2 Temperature	265 – 290	°C	
Rear - Zone 1 Temperature	255 – 275	°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	