



LEXAN™ Resin LUX2010T

Americas: COMMERCIAL

Global grade. LEXAN LUX2010T is an injection molding grade especially designed for manufacturing optical parts requiring excellent 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	630	kgf/cm ²	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	640	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	130	%	ASTM D 638
Tensile Modulus, 50 mm/min	22300	kgf/cm ²	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	990	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	68	cm-kgf/cm	ASTM D 256
Izod Impact, notched, -30°C	8	cm-kgf/cm	ASTM D 256
Instrumented Impact Energy @ peak, 23°C	642	cm-kgf	ASTM D 3763
THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	139	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	127	°C	ASTM D 648
CTE, -40°C to 95°C, flow	6.4E-05	1/°C	ASTM E 831
CTE, -40°C to 95°C, xflow	6.7E-05	1/°C	ASTM E 831
Vicat Softening Temp, Rate B/120	143	°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	38	g/10 min	ASTM D 1238
OPTICAL			
Light Transmission, 2.54 mm	>90	%	ASTM D 1003



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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