



LEXAN™ Resin LUX2719
Americas: COMMERCIAL

Lexan™ LUX2719 Polycarbonate resin is an extrusion grade. It is UL94 V-2 rated at 1.5 mm. It was designed for high light reflectance.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	600	kgf/cm ²	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	570	kgf/cm ²	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	6	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	100	%	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	26000	kgf/cm ²	ASTM D 790
IMPACT			
Izod Impact, unnotched, 23°C	218	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	71	cm-kgf/cm	ASTM D 256
Izod Impact, notched, -30°C	50	cm-kgf/cm	ASTM D 256
Instrumented Impact Total Energy, 23°C	642	cm-kgf	ASTM D 3763
THERMAL			
Vicat Softening Temp, Rate B/50	147	°C	ASTM D 1525
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 40°C, flow	6.2E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	6.4E-05	1/°C	ASTM E 831
PHYSICAL			
Specific Gravity	1.31	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm (5)	0.8 - 1	%	SABIC Method
Melt Flow Rate, 300°C/1.2 kgf	5	g/10 min	ASTM D 1238
Density	1.3	g/cm ³	ISO 1183
Water Absorption, (23°C/sat)	0.35	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.15	%	ISO 62



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FLAME CHARACTERISTICS			
UL Recognized, 94V-2 Flame Class Rating (3)	1.5	mm	UL 94
Glow Wire Flammability Index 960°C, passes at	1 - 3	mm	IEC 60695-2-12
Glow Wire Ignitability Temperature, 1.0 mm	825	°C	IEC 60695-2-13
Glow Wire Ignitability Temperature, 3.0 mm	825	°C	IEC 60695-2-13



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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	310 - 330	°C
Nozzle Temperature	305 - 325	°C
Front - Zone 3 Temperature	310 - 330	°C
Middle - Zone 2 Temperature	300 - 320	°C
Rear - Zone 1 Temperature	290 - 310	°C
Mold Temperature	80 - 115	°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