



LEXAN™ Resin XHT2146
Americas: COMMERCIAL

XHT2146 resin is a high flow, high heat polycarbonate copolymer with improved release performance compared to LEXAN XHT2141 resin. It is available in a range of opaque and limited transparent colors.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	710	kgf/cm ²	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	610	kgf/cm ²	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	6.5	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	90	%	ASTM D 638
Tensile Modulus, 5 mm/min	26500	kgf/cm ²	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	1120	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	26000	kgf/cm ²	ASTM D 790
Tensile Stress, yield, 50 mm/min	70	MPa	ISO 527
Tensile Stress, break, 50 mm/min	60	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	6.5	%	ISO 527
Tensile Strain, break, 50 mm/min	90	%	ISO 527
Tensile Modulus, 1 mm/min	2600	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	100	MPa	ISO 178
Flexural Modulus, 2 mm/min	2450	MPa	ISO 178
IMPACT			
Izod Impact, notched, 23°C	11	cm-kgf/cm	ASTM D 256
Izod Impact, notched, -30°C	7	cm-kgf/cm	ASTM D 256
Instrumented Impact Total Energy, 23°C	693	cm-kgf	ASTM D 3763
Izod Impact, unnotched 80*10*3 +23°C	NB	kJ/m ²	ISO 180/1U
Izod Impact, unnotched 80*10*3 -30°C	NB	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*3 +23°C	10	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*3 -30°C	9	kJ/m ²	ISO 180/1A



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TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
IMPACT			
Charpy 23°C, V-notch Edgew 80*10*3 sp=62mm	12	kJ/m ²	ISO 179/1eA
Charpy -30°C, V-notch Edgew 80*10*3 sp=62mm	9	kJ/m ²	ISO 179/1eA
Charpy 23°C, Unnotch Edgew 80*10*3 sp=62mm	NB	kJ/m ²	ISO 179/1eU
Charpy -30°C, Unnotch Edgew 80*10*3 sp=62mm	NB	kJ/m ²	ISO 179/1eU
THERMAL			
Vicat Softening Temp, Rate B/50	161	°C	ASTM D 1525
HDT, 0.45 MPa, 3.2 mm, unannealed	155	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	145	°C	ASTM D 648
CTE, -40°C to 40°C, flow	6.E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	6.E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, flow	6.E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	6.E-05	1/°C	ISO 11359-2
Vicat Softening Temp, Rate B/50	160	°C	ISO 306
Vicat Softening Temp, Rate B/120	162	°C	ISO 306
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	142	°C	ISO 75/Af
PHYSICAL			
Specific Gravity	1.2	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm (5)	0.6 - 0.9	%	SABIC Method
Melt Flow Rate, 330°C/2.16 kgf	46	g/10 min	ASTM D 1238
Density	1.2	g/cm ³	ISO 1183
Water Absorption, (23°C/sat)	0.3	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.23	%	ISO 62
Melt Volume Rate, MVR at 330°C/2.16kg	43	cm ³ /10 min	ISO 1133



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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	125	°C
Drying Time	4 - 6	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	290 - 330	°C
Nozzle Temperature	285 - 330	°C
Front - Zone 3 Temperature	290 - 330	°C
Middle - Zone 2 Temperature	280 - 320	°C
Rear - Zone 1 Temperature	270 - 300	°C
Mold Temperature	85 - 130	°C
Back Pressure	0.3 - 0.7	MPa
Screw Speed	40 - 90	rpm
Shot to Cylinder Size	40 - 60	%
Vent Depth	0.025 - 0.08	mm