

LEXANT™ RESIN LUX1619

REGION AMERICAS

DESCRIPTION

LEXANT™ LUX1619 resin is a 7.5 MFR polycarbonate, UL94 HB rated. For high light reflectance. Extrudable and injection moldable.

TYPICAL PROPERTY VALUES

Revision 20201125

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	57	MPa	ASTM D638
Tensile Stress, brk, Type I, 50 mm/min	50	MPa	ASTM D638
Tensile Strain, yld, Type I, 50 mm/min	6	%	ASTM D638
Tensile Strain, brk, Type I, 50 mm/min	74	%	ASTM D638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	97	MPa	ASTM D790
Flexural Modulus, 1.3 mm/min, 50 mm span	2730	MPa	ASTM D790
IMPACT			
Izod Impact, unnotched, 23°C	2130	J/m	ASTM D4812
Izod Impact, notched, 23°C	640	J/m	ASTM D256
Izod Impact, notched, -30°C	135	J/m	ASTM D256
Instrumented Dart Impact Total Energy, 23°C	69	J	ASTM D3763
THERMAL			
Vicat Softening Temp, Rate B/50	147	°C	ASTM D1525
HDT, 0.45 MPa, 3.2 mm, unannealed	141	°C	ASTM D648
HDT, 1.82 MPa, 3.2mm, unannealed	129	°C	ASTM D648
CTE, -40°C to 40°C, flow	6.1E-05	1 / °C	ASTM E831
CTE, -40°C to 40°C, xflow	6.4E-05	1 / °C	ASTM E831
PHYSICAL			
Specific Gravity	1.34	-	ASTM D792
Mold Shrinkage, flow, 3.2 mm	0.8 – 1	%	SABIC method
Melt Flow Rate, 300°C/1.2 kgf	7.5	g/10 min	ASTM D1238
Density	1.34	g/cm³	ISO 1183
Water Absorption, (23°C/saturated)	0.35	%	ISO 62-1
Moisture Absorption (23°C / 50% RH)	0.15	%	ISO 62
FLAME CHARACTERISTICS			
UL Yellow Card Link	E121562-101056760	-	-
UL Recognized, 94HB Flame Class Rating	1.5	mm	UL 94
Glow Wire Flammability Index 960°C, passes at	1.5 – 3	mm	IEC 60695-2-12
Glow Wire Ignitability Temperature, 1.5 mm	850	°C	IEC 60695-2-13
Glow Wire Ignitability Temperature, 3.0 mm	850	°C	IEC 60695-2-13
INJECTION MOLDING			
Drying Temperature	120	°C	
Drying Time	3 – 4	Hrs	
Drying Time (Cumulative)	48	Hrs	
Maximum Moisture Content	0.02	%	

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CHEMISTRY THAT MATTERS™



PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
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	

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