

LEXAN™ EM3110 resin

Polycarbonate

SABIC Innovative Plastics

Message:

Automotive interiors. Optimizes flow/processability for cost effective thinner wall design uses.

General Information			
Features	Good liquidity		
Uses	Car interior parts		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.19	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	20	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm)	0.50 - 0.70	%	Internal method
Water Absorption (24 hr)	0.16	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield)	57.2	MPa	ASTM D638
Tensile Elongation ² (Break)	110	%	ASTM D638
Flexural Modulus ³ (50.0 mm Span)	2030	MPa	ASTM D790
Flexural Strength ⁴ (Yield, 50.0 mm Span)	81.4	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-30°C	210	J/m	ASTM D256
-20°C	590	J/m	ASTM D256
23°C	640	J/m	ASTM D256
23°C, 6.40 mm	210	J/m	ASTM D256
Instrumented Dart Impact (23°C, Energy at Peak Load)	56.5	J	ASTM D3763
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, unannealed, 6.40mm	127	°C	ASTM D648
1.8 MPa, unannealed, 3.20mm	118	°C	ASTM D648
1.8 MPa, unannealed, 6.40mm	124	°C	ASTM D648
CLTE - Flow (-40 to 95°C)	6.5E-5	cm/cm/°C	ASTM E831
RTI Elec	80.0	°C	UL 746
RTI Imp	80.0	°C	UL 746
RTI	80.0	°C	UL 746
Flammability	Nominal Value	Test Method	
Flame Rating (1.47 mm)	HB	UL 94	
Injection	Nominal Value	Unit	

Drying Temperature	121	°C
Drying Time	3.0 - 4.0	hr
Drying Time, Maximum	10	hr
Suggested Max Moisture	0.020	%
Suggested Shot Size	40 - 60	%
Rear Temperature	254 - 277	°C
Middle Temperature	266 - 288	°C
Front Temperature	277 - 299	°C
Nozzle Temperature	271 - 293	°C
Processing (Melt) Temp	277 - 299	°C
Mold Temperature	71.1 - 93.3	°C
Back Pressure	0.345 - 0.689	MPa
Screw Speed	40 - 70	rpm
Vent Depth	0.025 - 0.076	mm

NOTE

- | | |
|----|------------------|
| 1. | Type 1, 50mm/min |
| 2. | Type 1, 50mm/min |
| 3. | 1.3 mm/min |
| 4. | 1.3 mm/min |

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