

# LEXAN™ RESIN LUX1814N

REGION AMERICAS

## TYPICAL PROPERTY VALUES

Revision 20170816

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
<b>MECHANICAL</b>			
Tensile Stress, yld, Type I, 50 mm/min	62	MPa	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	60	MPa	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	7	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	91	%	ASTM D 638
Tensile Modulus, 50 mm/min	2300	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	98	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	2370	MPa	ASTM D 790
<b>IMPACT</b>			
Izod Impact, notched, 23°C	826	J/m	ASTM D 256
Izod Impact, notched, -30°C	112	J/m	ASTM D 256
Instrumented Impact Energy @ peak, 23°C	72	J	ASTM D 3763
<b>THERMAL</b>			
Vicat Softening Temp, Rate B/50	145	°C	ASTM D 1525
HDT, 0.45 MPa, 6.4 mm, unannealed	141	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	127	°C	ASTM D 648
CTE, -40°C to 40°C, flow	6.6E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	6.7E-05	1/°C	ASTM E 831
<b>PHYSICAL</b>			
Specific Gravity	1.2	-	ASTM D 792
Density	1.2	g/cm <sup>3</sup>	ASTM D 792
Mold Shrinkage, flow, 3.2 mm (5)	0.6 – 0.9	%	SABIC method
Melt Flow Rate, 300°C/1.2 kgf	3.2	g/10 min	ASTM D 1238
<b>EXTRUSION</b>			
Drying Temperature	75 – 90	°C	
Drying Time	2 – 4	hrs	
Minimum Moisture Content	0.04	%	
Melt Temperature	180 – 200	°C	
Barrel - Zone 1 Temperature	165	°C	
Barrel - Zone 2 Temperature	170	°C	
Barrel - Zone 3 Temperature	175	°C	

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Barrel - Zone 4 Temperature	180	°C	
Roll Stack Temperature - Top	175 – 180	°C	
Roll Stack Temperature - Middle	175 – 180	°C	
Roll Stack Temperature - Bottom	175 – 180	°C	

## DISCLAIMER

The information contained herein may include typical properties of our products or their typical performances when used in certain typical applications. Actual properties of our products, in particular when used in conjunction with any third party material(s) or for any non-typical applications, may differ from typical properties.

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