LEXAN™ RESIN OQ2720

REGION ASIA

DESCRIPTION

LEXAN™ OQ2720 resin is a 7.5 MFR polycarbonate. UV stabilized. Produced in dedicated equipment with stringent production control conditions. For ophthalmic or safety lens market. Available in transparent and translucent colors.

TYPICAL PROPERTY VALUES

Revision 20201125

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	62	MPa	ASTM D638
Tensile Stress, brk, Type I, 50 mm/min	68	MPa	ASTM D638
Tensile Strain, brk, Type I, 50 mm/min	135	%	ASTM D638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	96	MPa	ASTM D790
Flexural Modulus, 1.3 mm/min, 50 mm span	2340	MPa	ASTM D790
IMPACT			
Izod Impact, notched, 23°C	907	J/m	ASTM D256
Tensile Impact Strength, Type S	640	kJ/m²	ASTM D1822
Instrumented Dart Impact Energy @ peak, 23°C	65	J	ASTM D3763
THERMAL			
HDT, 1.82 MPa, 6.4 mm, unannealed	132	°C	ASTM D648
PHYSICAL			
Specific Gravity	1.2	-	ASTM D792
Mold Shrinkage, flow, 3.2 mm	0.5 – 0.7	%	SABIC method
Melt Flow Rate, 300°C/1.2 kgf	7.5	g/10 min	ASTM D1238
OPTICAL			
Light Transmission, 2.54 mm	89	%	ASTM D1003
Haze, 2.54 mm	0.6	%	ASTM D1003
Refractive Index	1.586	-	ASTM D542
Yellowness Index	0	-	ASTM D1925
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	%	

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Vent Depth	0.025 – 0.076	mm	

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