

LEXAN™ ML3400 resin

Polycarbonate
SABIC Innovative Plastics Europe

Message:

LEXAN ML3400 is a medium viscosity, impact modified grade with improved chemical resistance. It passes the British Standard 2495 and 5361 solvent tests.

General Information			
Additive	Impact Modifier		
Features	Good Chemical Resistance		
	Impact Modified		
	Medium Viscosity		
RoHS Compliance	RoHS Compliant		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.20	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (300°C/1.2 kg)	8.00	cm ³ /10min	ISO 1133
Molding Shrinkage - Flow ¹	0.60 to 0.80	%	Internal Method
Water Absorption			ISO 62
Saturation, 23°C	0.35	%	
Equilibrium, 23°C, 50% RH	0.15	%	
Hardness	Nominal Value	Unit	Test Method
Ball Indentation Hardness (H 358/30)	85.0	MPa	ISO 2039-1
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2100	MPa	ISO 527-2/1
Tensile Stress			ISO 527-2/50
Yield	55.0	MPa	
Break	57.0	MPa	
Tensile Strain			ISO 527-2/50
Yield	6.0	%	
Break	100	%	
Flexural Modulus ²	2150	MPa	ISO 178
Flexural Stress	80.0	MPa	ISO 178
Taber Abrasion Resistance (1000 Cycles, 1000 g, CS-17 Wheel)	10.0	mg	Internal Method
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			
-30°C ³	55	kJ/m ²	ISO 179/1eA
23°C ⁴	60	kJ/m ²	ISO 179/1eA

23°C	40	kJ/m ²	ISO 179/2C
Charpy Unnotched Impact Strength ⁵			ISO 179/1eU
-30°C	No Break		
23°C	No Break		
Notched Izod Impact Strength ⁶			ISO 180/1A
-30°C	55	kJ/m ²	
23°C	60	kJ/m ²	
Unnotched Izod Impact Strength ⁷			ISO 180/1U
-30°C	No Break		
23°C	No Break		
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature ⁸			
0.45 MPa, Unannealed, 100 mm Span	133	°C	ISO 75-2/Be
1.8 MPa, Unannealed, 100 mm Span	121	°C	ISO 75-2/Ae
Vicat Softening Temperature			
--	140	°C	ISO 306/B50
--	142	°C	ISO 306/B120
Ball Pressure Test (125°C)	Pass		IEC 60695-10-2
CLTE - Flow (23 to 80°C)	7.0E-5	cm/cm/°C	ISO 11359-2
Thermal Conductivity	0.20	W/m/K	ISO 8302
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	> 1.0E+15	ohms	IEC 60093
Volume Resistivity	> 1.0E+15	ohms · cm	IEC 60093
Electric Strength (3.20 mm, in Oil)	17	kV/mm	IEC 60243-1
Relative Permittivity			IEC 60250
50 Hz	2.70		
60 Hz	2.70		
1 MHz	2.70		
Dissipation Factor			IEC 60250
50 Hz	1.0E-3		
60 Hz	1.0E-3		
1 MHz	0.010		
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.60 mm, Testing by SABIC)	V-2		UL 94
Glow Wire Flammability Index (1.00 mm)	850	°C	IEC 60695-2-12
Oxygen Index	25	%	ISO 4589-2
Injection	Nominal Value	Unit	
Drying Temperature	120	°C	
Drying Time	2.0 to 4.0	hr	
Suggested Max Moisture	0.020	%	
Hopper Temperature	60.0 to 80.0	°C	
Rear Temperature	260 to 280	°C	

Middle Temperature	270 to 290	°C
Front Temperature	280 to 310	°C
Nozzle Temperature	270 to 290	°C
Processing (Melt) Temp	280 to 310	°C
Mold Temperature	80.0 to 110	°C

NOTE

1.	Tensile Bar
2.	2.0 mm/min
3.	80*10*3 sp=62mm
4.	80*10*3 sp=62mm
5.	80*10*3 sp=62mm
6.	80*10*3
7.	80*10*3
8.	120*10*4 mm

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