

LEXAN™ ML7672 resin

Polycarbonate

SABIC Innovative Plastics Asia Pacific

Message:

Non FR PC + GF, UV-Stabilizer, balanced flow & impact. Available in Opaque only.

General Information			
UL YellowCard	E207780-100169213		
Filler / Reinforcement	Glass Fiber		
Additive	UV Stabilizer		
Features	Good Flow		
	Good Impact Resistance		
Appearance	Opaque		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.33	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	4.5	g/10 min	ASTM D1238
Melt Volume-Flow Rate (MVR) (300°C/1.2 kg)	5.00	cm ³ /10min	ISO 1133
Molding Shrinkage - Flow (3.20 mm)	0.20 to 0.60	%	Internal Method
Water Absorption			ISO 62
Saturation, 23°C	0.20	%	
Equilibrium, 23°C, 50% RH	0.30	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	5200	MPa	ASTM D638
--	5630	MPa	ISO 527-2/1
Tensile Stress			
Yield	11.0	MPa	ISO 527-2/5
Break ²	52.0	MPa	ASTM D638
Break	57.0	MPa	ISO 527-2/5
Tensile Strain			
Yield	0.30	%	ISO 527-2/5
Break ³	5.0	%	ASTM D638
Break	1.8	%	ISO 527-2/5
Flexural Modulus			
50.0 mm Span ⁴	4860	MPa	ASTM D790
-- ⁵	5480	MPa	ISO 178
Flexural Stress			

--	100	MPa	ISO 178
Yield, 50.0 mm Span ⁶	99.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ⁷ (23°C)	19	kJ/m ²	ISO 179/1eA
Notched Izod Impact			
23°C	240	J/m	ASTM D256
23°C ⁸	19	kJ/m ²	ISO 180/1A
Instrumented Dart Impact (23°C, Total Energy)	28.2	J	ASTM D3763
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
1.8 MPa, Unannealed, 3.20 mm	138	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ⁹	140	°C	ISO 75-2/Af
Vicat Softening Temperature			
--	143	°C	ASTM D1525, ISO 306/B50 11 ¹⁰
--	145	°C	ISO 306/B120
CLTE			ASTM E831, ISO 11359-2
Flow : -40 to 40°C	2.7E-5	cm/cm/°C	
Transverse : -40 to 40°C	6.9E-5	cm/cm/°C	
Injection	Nominal Value	Unit	
Drying Temperature	121	°C	
Drying Time	3.0 to 4.0	hr	
Drying Time, Maximum	48	hr	
Suggested Max Moisture	0.020	%	
Suggested Shot Size	40 to 60	%	
Rear Temperature	293 to 316	°C	
Middle Temperature	304 to 327	°C	
Front Temperature	316 to 338	°C	
Nozzle Temperature	310 to 332	°C	
Processing (Melt) Temp	316 to 338	°C	
Mold Temperature	82.2 to 116	°C	
Back Pressure	0.345 to 0.689	MPa	
Screw Speed	40 to 70	rpm	
Vent Depth	0.025 to 0.076	mm	
NOTE			
1.	5.0 mm/min		
2.	Type I, 5.0 mm/min		
3.	Type I, 5.0 mm/min		
4.	1.3 mm/min		
5.	2.0 mm/min		
6.	1.3 mm/min		
7.	80*10*4 sp=62mm		

8.	80*10*4
9.	80*10*4 mm
10.	Rate B (120°C/h), Loading 2 (50 N)

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