

# LEXAN™ ML3260 resin

Polycarbonate

SABIC Innovative Plastics Europe

## Message:

LEXAN ML3260 is a medium viscosity, 15% glass reinforced, flame retardant grade especially designed for applications like computer cartridges.

| General Information                        |                                  |                  |                 |
|--------------------------------------------|----------------------------------|------------------|-----------------|
| UL YellowCard                              | E45329-236690                    | E45329-101843037 |                 |
| Filler / Reinforcement                     | Glass Fiber,15% Filler by Weight |                  |                 |
| Additive                                   | Flame Retardant                  |                  |                 |
| Features                                   | Flame Retardant                  |                  |                 |
|                                            | Medium Viscosity                 |                  |                 |
| Uses                                       | Computer Components              |                  |                 |
| RoHS Compliance                            | RoHS Compliant                   |                  |                 |
| Processing Method                          | Injection Molding                |                  |                 |
| Physical                                   | Nominal Value                    | Unit             | Test Method     |
| Density                                    | 1.31                             | g/cm³            | ISO 1183        |
| Melt Volume-Flow Rate (MVR) (300°C/1.2 kg) | 11.0                             | cm³/10min        | ISO 1133        |
| Molding Shrinkage - Flow <sup>1</sup>      | 0.20 to 0.50                     | %                | Internal Method |
| Water Absorption                           |                                  |                  | ISO 62          |
| Saturation, 23°C                           | 0.30                             | %                |                 |
| Equilibrium, 23°C, 50% RH                  | 0.12                             | %                |                 |
| Hardness                                   | Nominal Value                    | Unit             | Test Method     |
| Ball Indentation Hardness (H 358/30)       | 80.0                             | MPa              | ISO 2039-1      |
| Mechanical                                 | Nominal Value                    | Unit             | Test Method     |
| Tensile Modulus                            | 4500                             | MPa              | ISO 527-2/1     |
| Tensile Stress                             |                                  |                  | ISO 527-2/5     |
| Yield                                      | 60.0                             | MPa              |                 |
| Break                                      | 45.0                             | MPa              |                 |
| Tensile Strain                             |                                  |                  | ISO 527-2/5     |
| Yield                                      | 3.5                              | %                |                 |
| Break                                      | 6.0                              | %                |                 |
| Flexural Modulus <sup>2</sup>              | 4000                             | MPa              | ISO 178         |
| Flexural Stress                            | 95.0                             | MPa              | ISO 178         |
| Impact                                     | Nominal Value                    | Unit             | Test Method     |
| Charpy Notched Impact Strength             |                                  |                  |                 |
| -30°C <sup>3</sup>                         | 6.0                              | kJ/m²            | ISO 179/1eA     |
| 23°C <sup>4</sup>                          | 8.0                              | kJ/m²            | ISO 179/1eA     |

| 23°C                                            | 6.0           | kJ/m <sup>2</sup> | ISO 179/2C     |
|-------------------------------------------------|---------------|-------------------|----------------|
| Charpy Unnotched Impact Strength <sup>5</sup>   |               |                   | ISO 179/1eU    |
| -30°C                                           | 100           | kJ/m <sup>2</sup> |                |
| 23°C                                            | 100           | kJ/m <sup>2</sup> |                |
| Notched Izod Impact Strength <sup>6</sup>       |               |                   | ISO 180/1A     |
| -30°C                                           | 7.0           | kJ/m <sup>2</sup> |                |
| 23°C                                            | 8.0           | kJ/m <sup>2</sup> |                |
| Unnotched Izod Impact Strength <sup>7</sup>     |               |                   | ISO 180/1U     |
| -30°C                                           | 80            | kJ/m <sup>2</sup> |                |
| 23°C                                            | 80            | kJ/m <sup>2</sup> |                |
| Thermal                                         | Nominal Value | Unit              | Test Method    |
| Heat Deflection Temperature                     |               |                   |                |
| 0.45 MPa, Unannealed, 100 mm Span <sup>8</sup>  | 143           | °C                | ISO 75-2/Be    |
| 0.45 MPa, Unannealed, 64.0 mm Span <sup>9</sup> | 143           | °C                | ISO 75-2/Bf    |
| 1.8 MPa, Unannealed, 100 mm Span <sup>10</sup>  | 137           | °C                | ISO 75-2/Ae    |
| 1.8 MPa, Unannealed, 64.0 mm Span <sup>11</sup> | 138           | °C                | ISO 75-2/Af    |
| Vicat Softening Temperature                     |               |                   |                |
| --                                              | 143           | °C                | ISO 306/B50    |
| --                                              | 144           | °C                | ISO 306/B120   |
| Ball Pressure Test (125°C)                      | Pass          |                   | IEC 60695-10-2 |
| CLTE - Flow (23 to 80°C)                        | 3.5E-5        | cm/cm/°C          | ISO 11359-2    |
| Thermal Conductivity                            | 0.22          | W/m/K             | ISO 8302       |
| RTI Elec                                        | 80.0          | °C                | UL 746         |
| RTI Imp                                         | 80.0          | °C                | UL 746         |
| RTI Str                                         | 80.0          | °C                | UL 746         |
| 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                               |               |                   | IEC 60243-1    |
| 0.800 mm, in Oil                                | 35            | kV/mm             |                |
| 1.60 mm, in Oil                                 | 27            | kV/mm             |                |
| 3.20 mm, in Oil                                 | 17            | kV/mm             |                |
| Relative Permittivity                           |               |                   | IEC 60250      |
| 50 Hz                                           | 2.90          |                   |                |
| 60 Hz                                           | 2.90          |                   |                |
| 1 MHz                                           | 2.80          |                   |                |
| Dissipation Factor                              |               |                   | IEC 60250      |
| 50 Hz                                           | 1.0E-3        |                   |                |
| 60 Hz                                           | 1.0E-3        |                   |                |
| 1 MHz                                           | 0.010         |                   |                |
| Comparative Tracking Index                      | 175           | V                 | IEC 60112      |
| Flammability                                    | Nominal Value | Unit              | Test Method    |

| Flame Rating                 |                 |      | UL 94          |
|------------------------------|-----------------|------|----------------|
| 1.50 mm                      | V-1             |      |                |
| 3.00 mm                      | V-0             |      |                |
| Glow Wire Flammability Index |                 |      | IEC 60695-2-12 |
| 1.00 mm                      | 850             | °C   |                |
| 3.20 mm                      | 960             | °C   |                |
| Oxygen Index                 | 31              | %    | 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     |      |                |
| 9.                           | 80*10*4 mm      |      |                |
| 10.                          | 120*10*4 mm     |      |                |
| 11.                          | 80*10*4 mm      |      |                |

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