

Lexan* Resin ML6339R

Americas: LIMITED USE

Superior performance. Unique combination of excellent flow and low- temperature impact. Internal mold release.

Property

| TYPICAL PROPERTIES ⁽¹⁾ | | | |
|--|-----------|----------|--------------|
| MECHANICAL | Value | Unit | Standard |
| Tensile Stress, yld, Type I, 50 mm/min | 57 | MPa | ASTM D 638 |
| Tensile Stress, brk, Type I, 50 mm/min | 53 | MPa | ASTM D 638 |
| Tensile Strain, brk, Type I, 50 mm/min | 120 | % | ASTM D 638 |
| Flexural Stress, yld, 1.3 mm/min, 50 mm span | 77 | MPa | ASTM D 790 |
| Flexural Modulus, 1.3 mm/min, 50 mm span | 1930 | MPa | ASTM D 790 |
| IMPACT | Value | Unit | Standard |
| Izod Impact, notched, 23°C | 801 | J/m | ASTM D 256 |
| Izod Impact, notched, -30°C | 587 | J/m | ASTM D 256 |
| Izod Impact, notched, 23°C, 6.4mm | 640 | J/m | ASTM D 256 |
| Instrumented Impact Energy @ peak, 23°C | 70 | J | ASTM D 3763 |
| Instrumented Impact Total Energy, 23°C | 61 | J | ASTM D 3763 |
| THERMAL | Value | Unit | Standard |
| HDT, 1.82 MPa, 3.2mm, unannealed | 105 | °C | ASTM D 648 |
| HDT, 1.82 MPa, 6.4 mm, unannealed | 110 | °C | ASTM D 648 |
| Relative Temp Index, Elec | 80 | °C | UL 746B |
| Relative Temp Index, Mech w/impact | 80 | °C | UL 746B |
| Relative Temp Index, Mech w/o impact | 80 | °C | UL 746B |
| PHYSICAL | Value | Unit | Standard |
| Specific Gravity | 1.17 | - | ASTM D 792 |
| Water Absorption, 24 hours | 0.13 | % | ASTM D 570 |
| Water Absorption, equilibrium, 23C | 0.3 | % | ASTM D 570 |
| Mold Shrinkage, flow, 3.2 mm | 0.5 - 0.7 | % | SABIC Method |
| Melt Flow Rate, 300°C/1.2 kgf | 10 | g/10 min | ASTM D 1238 |
| ELECTRICAL | Value | Unit | Standard |
| Hot Wire Ignition {PLC} | 2 | PLC Code | UL 746A |
| High Ampere Arc Ign, surface {PLC} | 0 | PLC Code | UL 746A |
| Comparative Tracking Index (UL) {PLC} | 2 | PLC Code | UL 746A |
| FLAME CHARACTERISTICS | Value | Unit | Standard |
| UL Recognized, 94HB Flame Class Rating (3) | 1.09 | mm | UL 94 |

Source GMD, last updated:01/04/2000

Processing

| Parameter | Value | Unit |
|--------------------------|-----------|------|
| Injection Molding | | |
| Drying Temperature | 105 - 110 | °C |
| Drying Time | 3 - 4 | hrs |
| Drying Time (Cumulative) | 24 | hrs |
| Melt Temperature | 260 - 305 | °C |
| Nozzle Temperature | 255 - 300 | °C |

| | | |
|-----------------------------|---------------|-----|
| Front - Zone 3 Temperature | 260 - 305 | °C |
| Middle - Zone 2 Temperature | 250 - 295 | °C |
| Rear - Zone 1 Temperature | 240 - 280 | °C |
| Mold Temperature | 50 - 80 | °C |
| Back Pressure | 0.3 - 0.7 | MPa |
| Screw Speed | 35 - 75 | rpm |
| Shot to Cylinder Size | 40 - 60 | % |
| Vent Depth | 0.038 - 0.076 | mm |

Source GMD, last updated:01/04/2000

THESE PROPERTY VALUES ARE NOT INTENDED FOR SPECIFICATION PURPOSES.

PLEASE CHECK WITH YOUR [\(LOCAL SALES OFFICE\)](#) FOR AVAILABILITY IN YOUR REGION

(1) Typical values only. Variations within normal tolerances are possible for various colors. All values are measured after at least 48 hours storage at 23°C/50% relative humidity. All properties, except the melt volume and melt flow rates, are measured on injection molded samples. All samples tested under ISO test standards are prepared according to ISO 294.

(2) Only typical data for selection purposes. Not to be used for part or tool design.

(3) This rating is not intended to reflect hazards presented by this or any other material under actual fire conditions.

(4) Internal measurements according to UL standards.

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