

LEXANTM COPOLYMER ML0992

REGION ASIA

DESCRIPTION

LEXAN ML0992 is a translucent impact modified polycarbonate injection molding (IM) grade with release properties. This resin offers good low temperature ductility in combination with medium flow characteristics, excellent surface aesthetics, excellent knit line strength, and excellent processability with opportunities for shorter IM cycle times compared to standard IM PC resins. LEXAN ML0992 resin is a general purpose product available for wide range of opaque colors and may be an excellent candidate for a broad range of applications.

TYPICAL PROPERTY VALUES

Revision 20190607

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	58	MPa	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	57	MPa	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	5	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	85	%	ASTM D 638
Tensile Modulus, 50 mm/min	2300	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	85	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	2100	MPa	ASTM D 790
IMPACT			
Izod Impact, notched, 23°C	750	J/m	ASTM D 256
Izod Impact, notched, -30°C	500	J/m	ASTM D 256
THERMAL			
HDT, 1.82 MPa, 3.2mm, unannealed	118	°C	ASTM D 648
Relative Temp Index, Elec ⁽¹⁾	80	°C	UL 746B
Relative Temp Index, Mech w/impact ⁽¹⁾	80	°C	UL 746B
Relative Temp Index, Mech w/o impact ⁽¹⁾	80	°C	UL 746B
PHYSICAL			
Mold Shrinkage, flow, 3.2 mm	0.4 – 0.8	%	SABIC method
Mold Shrinkage, xflow, 3.2 mm	0.4 – 0.8	%	SABIC method
Melt Flow Rate, 300°C/1.2 kgf	14	g/10 min	ASTM D 1238
Density	1.2	g/cm ³	ISO 1183
Moisture Absorption (23°C / 50% RH)	0.1	%	ISO 62
Melt Volume Rate, MVR at 300°C/1.2 kg	13	cm ³ /10 min	ISO 1133
FLAME CHARACTERISTICS ⁽¹⁾			
UL Yellow Card Link	E207780-103670399	-	-
UL Recognized, 94HB Flame Class Rating	0.5	mm	UL 94
INJECTION MOLDING			
Drying Temperature	120	°C	
Drying Time	3 – 4	hrs	
Drying Time (Cumulative)	48	hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	295 – 315	°C	

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Nozzle Temperature	290 – 310	°C	
Front - Zone 3 Temperature	295 – 315	°C	
Middle - Zone 2 Temperature	280 – 305	°C	
Rear - Zone 1 Temperature	270 – 295	°C	
Mold Temperature	70 – 95	°C	
Back Pressure	0.3 – 0.7	MPa	
Screw Speed	40 – 70	rpm	
Shot to Cylinder Size	40 – 60	%	
Vent Depth	0.025 – 0.076	mm	

(1) UL Ratings shown on the technical datasheet might not cover the full range of thicknesses and colors. For details, please see the UL Yellow Card.

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