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LEXAN* ML1010 Resin

Polycarbonate

SABIC Innovative Plastics Europe

Product Description
Superior performance, improved flow over standard grades at lower temperatures. Internal mold release.

General	
Additive	• Mold Release
RoHS Compliance	• RoHS Compliant
Forms	• Pellets
Processing Method	• Injection Molding

Physical	Nominal Value	Unit	Test Method
Density	1.19	g/cm³	ISO 1183
Melt Volume-Flow Rate (MVR)			ISO 1133
250°C/1.2 kg	12.0	cm³/10min	
300°C/1.2 kg	48.0	cm³/10min	
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	2350	MPa	ISO 527-2/1
Tensile Stress			ISO 527-2/50
Yield	60.0	MPa	
Break	45.0	MPa	
Tensile Strain			ISO 527-2/50
Yield	5.0	%	
Break	70	%	
Flexural Modulus [2]	2400	MPa	ISO 178
Flexural Strength [2, 3]	90.0	MPa	ISO 178
Hardness	**Nominal Value**	**Unit**	**Test Method**
Ball Indentation Hardness (H 358/30)	100	MPa	ISO 2039-1
Thermal	**Nominal Value**	**Unit**	**Test Method**
Heat Deflection Temperature [4]			
0.45 MPa, Unannealed, 100 mm Span	115	°C	ISO 75-2/Be
1.8 MPa, Unannealed, 100 mm Span	100	°C	ISO 75-2/Ae
Vicat Softening Temperature			
--	120	°C	ISO 306/B50
--	122	°C	ISO 306/B120
Optical	**Nominal Value**	**Unit**	**Test Method**
Refractive Index	1.582		ISO 489
Transmittance (2540 µm)	88.0	%	ASTM D1003
Haze (2540 µm)	1.0	%	ASTM D1003

Injection	Nominal Value	Unit
Drying Temperature	105	°C
Drying Time	2.0 to 4.0	hr
Hopper Temperature	60.0 to 80.0	°C
Rear Temperature	250 to 270	°C
Middle Temperature	260 to 280	°C
Front Temperature	270 to 290	°C
Nozzle Temperature	260 to 280	°C
Processing (Melt) Temp	275 to 295	°C
Mold Temperature	65.0 to 85.0	°C