



LEXAN™ Resin ML7667

Americas: COMMERCIAL

LEXAN ML7667 specialty polycarbonate (PC) resin is a 9% GF reinforced, UV stabilized, flame retarded injection molding grade. This medium flow specialty PC resin combines UL94 V0 @ 1.5mm, 5VB @ 3.0mm flame retardancy based on non-chlorine, non-bromine FR agents with excellent processability, improved release performance and good impact performance. This product is available in limited opaque colors only and may be an excellent candidate for a broad range of applications, i.e. electrical and electronic enclosure applications.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	560	kgf/cm ²	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	440	kgf/cm ²	ASTM D 638
Tensile Strain, yld, Type I, 5 mm/min	4.4	%	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	15	%	ASTM D 638
Tensile Modulus, 5 mm/min	35600	kgf/cm ²	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	980	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	32100	kgf/cm ²	ASTM D 790
Tensile Stress, yield, 5 mm/min	54	MPa	ISO 527
Tensile Stress, break, 5 mm/min	46	MPa	ISO 527
Tensile Strain, yield, 5 mm/min	4.4	%	ISO 527
Tensile Strain, break, 5 mm/min	13	%	ISO 527
Tensile Modulus, 1 mm/min	3600	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	96	MPa	ISO 178
Flexural Modulus, 2 mm/min	3400	MPa	ISO 178
IMPACT			
Izod Impact, notched, 23°C	34	cm-kgf/cm	ASTM D 256
Izod Impact, notched, -30°C	15	cm-kgf/cm	ASTM D 256
Instrumented Impact Total Energy, 23°C	407	cm-kgf	ASTM D 3763
Izod Impact, unnotched 80*10*3 +23°C	NB	kJ/m ²	ISO 180/1U
Izod Impact, unnotched 80*10*3 -30°C	NB	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*3 +23°C	25	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*3 -30°C	10	kJ/m ²	ISO 180/1A



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TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
IMPACT			
Charpy 23°C, V-notch Edgew 80*10*3 sp=62mm	25	kJ/m ²	ISO 179/1eA
Charpy -30°C, V-notch Edgew 80*10*3 sp=62mm	15	kJ/m ²	ISO 179/1eA
Charpy 23°C, Unnotch Edgew 80*10*3 sp=62mm	NB	kJ/m ²	ISO 179/1eU
Charpy -30°C, Unnotch Edgew 80*10*3 sp=62mm	NB	kJ/m ²	ISO 179/1eU
THERMAL			
Vicat Softening Temp, Rate B/50	146	°C	ASTM D 1525
HDT, 1.82 MPa, 3.2mm, unannealed	135	°C	ASTM D 648
CTE, -40°C to 40°C, flow	4.7E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	7.E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, flow	4.7E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	7.E-05	1/°C	ISO 11359-2
Ball Pressure Test, 125°C +/- 2°C	passes	-	IEC 60695-10-2
Vicat Softening Temp, Rate B/50	145	°C	ISO 306
Vicat Softening Temp, Rate B/120	146	°C	ISO 306
HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm	132	°C	ISO 75/Ae
PHYSICAL			
Specific Gravity	1.26	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm (5)	0.2 - 0.6	%	SABIC Method
Melt Flow Rate, 300°C/1.2 kgf	9	g/10 min	ASTM D 1238
Density	1.26	g/cm ³	ISO 1183
Water Absorption, (23°C/sat)	0.15	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.4	%	ISO 62
Melt Volume Rate, MVR at 300°C/1.2 kg	8	cm ³ /10 min	ISO 1133
ELECTRICAL			
Comparative Tracking Index (UL) {PLC}	3	PLC Code	UL 746A
Comparative Tracking Index	175	V	IEC 60112



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FLAME CHARACTERISTICS			
UL Compliant, 94HB Flame Class Rating 2nd value (3)(4)	0.75	mm	UL 94 by SABIC-IP
UL Compliant, 94V-0 Flame Class Rating (3)(4)	1.5	mm	UL 94 by SABIC-IP
UL Compliant, 94-5VB Rating (3)(4)	3	mm	UL 94 by SABIC-IP
Glow Wire Flammability Index 960°C, passes at	1.1	mm	IEC 60695-2-12
Glow Wire Ignitability Temperature, 1.0 mm	825	°C	IEC 60695-2-13
Glow Wire Ignitability Temperature, 2.0 mm	825	°C	IEC 60695-2-13
Glow Wire Ignitability Temperature, 2.5 mm	825	°C	IEC 60695-2-13
Glow Wire Ignitability Temperature, 3.0 mm	825	°C	IEC 60695-2-13



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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	120	°C
Drying Time	3 - 4	hrs
Drying Time (Cumulative)	48	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	310 - 330	°C
Nozzle Temperature	305 - 325	°C
Front - Zone 3 Temperature	310 - 330	°C
Middle - Zone 2 Temperature	300 - 320	°C
Rear - Zone 1 Temperature	290 - 310	°C
Mold Temperature	80 - 115	°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



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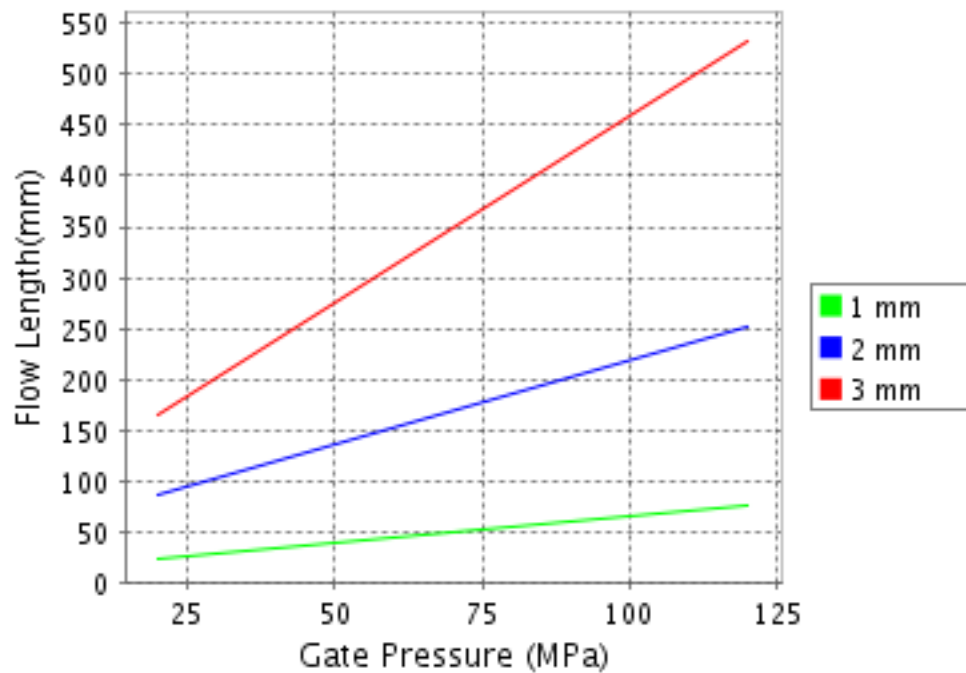
CALCULATED FLOW LENGTH INDICATION

Moldflow® Radial Flow Analysis

LEXAN® ML7667

Melt Temperature : 320°C

Mold Temperature : 100°C



Note: Technical support is recommended if Gate Pressure is greater than 80 MPa. Contact your local representative.

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