



Lexan* Resin ML3940

Europe-Africa-Middle East: COMMERCIAL

LEXAN ML3940 is a highly UV stabilised grade which has been developed as a coextrusion product exhibiting a low plate out behaviour and improved outdoor weathering of LEXAN sheet.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
MECHANICAL			
Tensile Stress, yield, 50 mm/min	63	MPa	ISO 527
Tensile Stress, break, 50 mm/min	70	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	6	%	ISO 527
Tensile Strain, break, 50 mm/min	120	%	ISO 527
Tensile Modulus, 1 mm/min	2350	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	90	MPa	ISO 178
Flexural Modulus, 2 mm/min	2300	MPa	ISO 178
THERMAL			
Vicat Softening Temp, Rate B/120	135	°C	ISO 306
PHYSICAL			
Density	1.2	g/cm ³	ISO 1183
Melt Volume Rate, MVR at 300°C/1.2 kg	10	cm ³ /10 min	ISO 1133



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PROCESSING PARAMETERS	TYPICAL VALUE	UNIT
Profile Extrusion		
Drying Temperature	105	°C
Drying Time	2 - 3	hrs
Melt Temperature	220 - 250	°C
Barrel - Zone 1 Temperature	240 - 280	°C
Barrel - Zone 2 Temperature	240 - 280	°C
Barrel - Zone 3 Temperature	220 - 240	°C
Barrel - Zone 4 Temperature	220 - 240	°C
Hopper Temperature	60 - 80	°C
Adapter Temperature	220 - 240	°C
Die Temperature	245 - 290	°C
Calibrator Temperature	60 - 100	°C