



SABIC® PPCOMPOUND ML7682

REGION ASIA

DESCRIPTION

LEXAN ML7682 resin is a flame retardant polycarbonate blend featuring high flow, good processability, good impact, good heat resistance, and UV stability. It is of non-chlorine and non-bromine flame retardant systems with UL-94 listing of V0 and 5V. LEXAN ML7682 resin offers limited opaque colors for aesthetics needs.

TYPICAL PROPERTY VALUES

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	60	MPa	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	59	MPa	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	5.6	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	93	%	ASTM D 638
Tensile Modulus, 50 mm/min	2500	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	89	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	2400	MPa	ASTM D 790
Tensile Stress, yield, 50 mm/min	60	MPa	ISO 527
Tensile Stress, break, 50 mm/min	57	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	5.3	%	ISO 527
Tensile Strain, break, 50 mm/min	91	%	ISO 527
Tensile Modulus, 1 mm/min	2460	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	90	MPa	ISO 178
Flexural Modulus, 2 mm/min	2430	MPa	ISO 178
IMPACT			
Izod Impact, unnotched, 23°C	2150	J/m	ASTM D 4812
Izod Impact, unnotched, -30°C	2100	J/m	ASTM D 4812
Izod Impact, notched, 23°C	760	J/m	ASTM D 256
Izod Impact, notched, -30°C	130	J/m	ASTM D 256
Instrumented Impact Total Energy, 23°C	62	J	ASTM D 3763
Izod Impact, unnotched 80*10*3 +23°C	181	kJ/m ²	ISO 180/1U
Izod Impact, unnotched 80*10*3 -30°C	180	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*3 +23°C	63	kJ/m ²	ISO 180/1A

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Izod Impact, notched 80*10*3 -30°C	15	kJ/m ²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*3 sp=62mm	62	kJ/m ²	ISO 179/1eA
Charpy -30°C, V-notch Edgew 80*10*3 sp=62mm	16	kJ/m ²	ISO 179/1eA
Charpy 23°C, Unnotch Edgew 80*10*3 sp=62mm	133	kJ/m ²	ISO 179/1eU
Charpy -30°C, Unnotch Edgew 80*10*3 sp=62mm	132	kJ/m ²	ISO 179/1eU
THERMAL			
Vicat Softening Temp, Rate B/50	138	°C	ASTM D 1525
HDT, 0.45 MPa, 3.2 mm, unannealed	131	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	119	°C	ASTM D 648
CTE, -40°C to 40°C, flow	6.4E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	6.8E-05	1/°C	ASTM E 831
CTE, 23°C to 80°C, flow	6.7E-05	1/°C	ISO 11359-2
CTE, 23°C to 80°C, xflow	7.4E-05	1/°C	ISO 11359-2
Ball Pressure Test, 125°C +/- 2°C	Pass	-	IEC 60695-10-2
Vicat Softening Temp, Rate B/50	138	°C	ISO 306
Vicat Softening Temp, Rate B/120	141	°C	ISO 306
HDT/Be, 0.45MPa Edgew 120*10*4 sp=100mm	132	°C	ISO 75/Be
HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm	120	°C	ISO 75/Ae
Relative Temp Index, Elec	125	°C	UL 746B
Relative Temp Index, Mech w/impact	110	°C	UL 746B
Relative Temp Index, Mech w/o impact	120	°C	UL 746B
PHYSICAL			
Specific Gravity	1.22	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm (5)	0.6 – 0.8	%	SABIC method
Mold Shrinkage, xflow, 3.2 mm (5)	0.6 – 0.8	%	SABIC method
Melt Flow Rate, 300°C/1.2 kgf	22	g/10 min	ASTM D 1238
Density	1.21	g/cm ³	ISO 1183
Water Absorption, (23°C/sat)	0.36	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.17	%	ISO 62
Melt Volume Rate, MVR at 300°C/1.2 kg	21	cm ³ /10 min	ISO 1133
ELECTRICAL			
Volume Resistivity	1000000000000000 – 10000000000000000	Ohm-cm	ASTM D 257
Surface Resistivity	1.E+15 – 1.E+16	Ohm	ASTM D 257
FLAME CHARACTERISTICS			
UL Recognized, 94V-0 Flame Class Rating (3)	1.8	mm	UL 94
UL Recognized, 94-5VA Rating (3)	2.5	mm	UL 94

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
UL Recognized, 94-5VB Rating (3)	1.8	mm	UL 94
Glow Wire Flammability Index 960°C, passes at	3	mm	IEC 60695-2-12
Glow Wire Ignitability Temperature, 1.0 mm	850	°C	IEC 60695-2-13
UV-light, water exposure/immersion	F1	-	UL 746C
INJECTION MOLDING			
Drying Temperature	120	°C	
Drying Time	3 – 4	hrs	
Drying Time (Cumulative)	48	hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	290 – 310	°C	
Nozzle Temperature	280 – 305	°C	
Front - Zone 3 Temperature	290 – 310	°C	
Middle - Zone 2 Temperature	275 – 300	°C	
Rear - Zone 1 Temperature	265 – 290	°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	