

# LEXAN™ COPOLYMER ML7664

REGION ASIA

## DESCRIPTION

LEXAN ML7664 polycarbonate (PC) siloxane resin, is a product targeting (profile) extrusion applications requiring extreme low temperature ductility. LEXAN ML7664 resin is a non-FR product available in opaque colors only.

## TYPICAL PROPERTY VALUES

Revision 20170913

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
<b>MECHANICAL</b>			
Tensile Stress, yld, Type I, 50 mm/min	60	MPa	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	56	MPa	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	6	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	86	%	ASTM D 638
Tensile Modulus, 5 mm/min	2200	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	97	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	2300	MPa	ASTM D 790
Tensile Stress, yield, 50 mm/min	59	MPa	ISO 527
Tensile Stress, break, 50 mm/min	59	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	6	%	ISO 527
Tensile Strain, break, 50 mm/min	76	%	ISO 527
Tensile Modulus, 1 mm/min	2300	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	90	MPa	ISO 178
Flexural Modulus, 2 mm/min	2100	MPa	ISO 178
<b>IMPACT</b>			
Izod Impact, notched, 23°C	847	J/m	ASTM D 256
Izod Impact, notched, -30°C	710	J/m	ASTM D 256
Instrumented Impact Total Energy, 23°C	72	J	ASTM D 3763
Izod Impact, notched 80*10*4 +23°C	64	kJ/m <sup>2</sup>	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	54	kJ/m <sup>2</sup>	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	77	kJ/m <sup>2</sup>	ISO 179/1eA
<b>THERMAL</b>			
Vicat Softening Temp, Rate B/50	144	°C	ASTM D 1525
HDT, 1.82 MPa, 3.2mm, unannealed	127	°C	ASTM D 648

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
CTE, -40°C to 40°C, flow	7.E-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	7.E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	7.E-05	1/°C	ISO 11359-2
Vicat Softening Temp, Rate B/50	143	°C	ISO 306
Vicat Softening Temp, Rate B/120	145	°C	ISO 306
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	125	°C	ISO 75/Af
<b>PHYSICAL</b>			
Specific Gravity	1.19	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm (5)	0.6 – 1	%	SABIC method
Melt Flow Rate, 300°C/1.2 kgf	2.7	g/10 min	ASTM D 1238
Density	1.19	g/cm <sup>3</sup>	ISO 1183
Water Absorption, (23°C/sat)	0.35	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.15	%	ISO 62
Melt Volume Rate, MVR at 300°C/1.2 kg	2	cm <sup>3</sup> /10 min	ISO 1133
<b>PROFILE EXTRUSION</b>			
Drying Temperature	120	°C	
Drying Time	2 – 4	hrs	
Melt Temperature	280 – 300	°C	
Barrel - Zone 1 Temperature	240 – 280	°C	
Barrel - Zone 2 Temperature	260 – 290	°C	
Barrel - Zone 3 Temperature	260 – 290	°C	
Barrel - Zone 4 Temperature	260 – 290	°C	
Hopper Temperature	100 – 120	°C	
Adapter Temperature	270 – 300	°C	
Die Temperature	260 – 290	°C	
Calibrator Temperature	80 – 100	°C	

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