

# LEXAN™ RESIN ML3400

REGION EUROPE

## DESCRIPTION

LEXAN ML3400 is a medium viscosity, impact modified grade with improved chemical resistance. It passes the British Standard 2495 and 5361 solvent tests.

## TYPICAL PROPERTY VALUES

Revision 20180905

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
<b>MECHANICAL</b>			
Taber Abrasion, CS-17, 1 kg	10	mg/1000cy	SABIC method
Tensile Stress, yield, 50 mm/min	55	MPa	ISO 527
Tensile Stress, break, 50 mm/min	57	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	6	%	ISO 527
Tensile Strain, break, 50 mm/min	100	%	ISO 527
Tensile Modulus, 1 mm/min	2100	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	80	MPa	ISO 178
Flexural Modulus, 2 mm/min	2150	MPa	ISO 178
Hardness, H358/30	85	MPa	ISO 2039-1
<b>IMPACT</b>			
Izod Impact, unnotched 80*10*3 +23°C	NB	kJ/m <sup>2</sup>	ISO 180/1U
Izod Impact, unnotched 80*10*3 -30°C	NB	kJ/m <sup>2</sup>	ISO 180/1U
Izod Impact, notched 80*10*3 +23°C	60	kJ/m <sup>2</sup>	ISO 180/1A
Izod Impact, notched 80*10*3 -30°C	55	kJ/m <sup>2</sup>	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*3 sp=62mm	60	kJ/m <sup>2</sup>	ISO 179/1eA
Charpy -30°C, V-notch Edgew 80*10*3 sp=62mm	55	kJ/m <sup>2</sup>	ISO 179/1eA
Charpy 23°C, Unnotch Edgew 80*10*3 sp=62mm	NB	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy -30°C, Unnotch Edgew 80*10*3 sp=62mm	NB	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy Impact, notched, 23°C	40	kJ/m <sup>2</sup>	ISO 179/2C
<b>THERMAL</b>			
Thermal Conductivity	0.2	W/m·°C	ISO 8302
CTE, 23°C to 80°C, flow	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	140	°C	ISO 306
Vicat Softening Temp, Rate B/120	142	°C	ISO 306
HDT/Be, 0.45MPa Edgew 120*10*4 sp=100mm	133	°C	ISO 75/Be
HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm	121	°C	ISO 75/Ae
<b>PHYSICAL</b>			
Mold Shrinkage on Tensile Bar, flow	0.6 – 0.8	%	SABIC method
Density	1.2	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	8	cm <sup>3</sup> /10 min	ISO 1133
<b>OPTICAL</b>			

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Haze, 2.54 mm	NA	%	ASTM D 1003
Refractive Index	NA	-	ISO 489
<b>ELECTRICAL</b>			
Volume Resistivity	>1.E+15	Ohm-cm	IEC 60093
Surface Resistivity, ROA	>1.E+15	Ohm	IEC 60093
Dielectric Strength, in oil, 3.2 mm	17	kV/mm	IEC 60243-1
Relative Permittivity, 1 MHz	2.7	-	IEC 60250
Dissipation Factor, 50/60 Hz	0.001	-	IEC 60250
Dissipation Factor, 1 MHz	0.01	-	IEC 60250
Relative Permittivity, 50/60 Hz	2.7	-	IEC 60250
<b>FLAME CHARACTERISTICS</b>			
UL Compliant, 94V-2 Flame Class Rating	1.6	mm	UL 94 by SABIC-IP
Glow Wire Flammability Index 850°C, passes at	1	mm	IEC 60695-2-12
Oxygen Index (LOI)	25	%	ISO 4589
<b>INJECTION MOLDING</b>			
Drying Temperature	120	°C	
Drying Time	2 – 4	hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	280 – 310	°C	
Nozzle Temperature	270 – 290	°C	
Front - Zone 3 Temperature	280 – 310	°C	
Middle - Zone 2 Temperature	270 – 290	°C	
Rear - Zone 1 Temperature	260 – 280	°C	
Hopper Temperature	60 – 80	°C	
Mold Temperature	80 – 110	°C	

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