

LEXAN™ MLS43R resin

Polycarbonate

SABIC Innovative Plastics Asia Pacific

Message:

Medium viscosity. UV-stabilized.

General Information			
Additive	UV Stabilizer		
Features	Good UV Resistance		
	Medium Viscosity		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.20	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	11	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm)	0.50 to 0.70	%	Internal Method
Water Absorption (24 hr)	0.15	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield)	62.1	MPa	ASTM D638
Tensile Elongation ² (Break)	130	%	ASTM D638
Flexural Modulus ³ (50.0 mm Span)	2340	MPa	ASTM D790
Flexural Strength ⁴ (Yield, 50.0 mm Span)	96.5	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	800	J/m	ASTM D256
Instrumented Dart Impact (23°C, Energy at Peak Load)	63.8	J	ASTM D3763
Gardner Impact (23°C)	169	J	Internal Method
Tensile Impact Strength ⁵	578	kJ/m ²	ASTM D1822
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 6.40 mm)	132	°C	ASTM D648
RTI Elec	100	°C	UL 746
RTI Imp	100	°C	UL 746
RTI Str	100	°C	UL 746
Electrical	Nominal Value	Test Method	
Comparative Tracking Index (CTI)	PLC 2	UL 746	
High Amp Arc Ignition (HAI)	PLC 1	UL 746	
High Voltage Arc Tracking Rate (HVTR)	PLC 2	UL 746	
Hot-wire Ignition (HWI)	PLC 4	UL 746	
Optical	Nominal Value	Unit	Test Method
Transmittance (2540 µm)	88.0	%	ASTM D1003

Injection	Nominal Value	Unit
Drying Temperature	121	°C
Drying Time	3.0 to 4.0	hr
Drying Time, Maximum	48	hr
Suggested Max Moisture	0.020	%
Suggested Shot Size	40 to 60	%
Rear Temperature	271 to 293	°C
Middle Temperature	282 to 304	°C
Front Temperature	293 to 316	°C
Nozzle Temperature	288 to 310	°C
Processing (Melt) Temp	293 to 316	°C
Mold Temperature	71.1 to 93.3	°C
Back Pressure	0.345 to 0.689	MPa
Screw Speed	40 to 70	rpm
Vent Depth	0.025 to 0.076	mm

NOTE

- | | |
|----|-------------------|
| 1. | Type I, 50 mm/min |
| 2. | Type I, 50 mm/min |
| 3. | 1.3 mm/min |
| 4. | 1.3 mm/min |
| 5. | Type S |

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