GE Plastics

Lexan* Resin ML6622

Americas: COMMERCIAL

UL rated HB as of 10/97. 200 series recommended when V-2 rating required. Nonhalogenated. For thicker sections without sinks. UV-stabilized for outdoor and lighting. Sheet extrusion market.

TYPICAL PROPERTIES [1]	TYPICAL VALUE	UNIT	STANDARD
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	630	kgf/cm²	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	7	%	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	940	kgf/cm²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	23900	kgf/cm²	ASTM D 790
Hardness, Rockwell R	118	-	ASTM D 785
IMPACT			
Izod Impact, unnotched, 23°C	326	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	92	cm-kgf/cm	ASTM D 256
THERMAL			
HDT, 0.45 MPa, 6.4 mm, unannealed	137	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	132	°C	ASTM D 648
Relative Temp Index, Elec	130	°C	UL 746B
Relative Temp Index, Mech w/impact	130	°C	UL 746B
Relative Temp Index, Mech w/o impact	130	°C	UL 746B
PHYSICAL			
Specific Gravity	1.2	-	ASTM D 792
Water Absorption, 24 hours	0.15	%	ASTM D 570
Mold Shrinkage, flow, 3.2 mm	0.5 - 0.7	%	GE Method
Melt Flow Rate, 300°C/1.2 kgf	7	g/10 min	ASTM D 1238
ELECTRICAL			
Hot Wire Ignition {PLC}	4	PLC Code	UL 746A
High Voltage Arc Track Rate {PLC}	2	PLC Code	UL 746A
High Ampere Arc Ign, surface {PLC}	1	PLC Code	UL 746A
Comparative Tracking Index (UL) {PLC}	2	PLC Code	UL 746A
FLAME CHARACTERISTICS			
UL Recognized, 94HB Flame Class Rating (3)	0.73	mm	UL 94
UV-light, water exposure/immersion	F1	-	UL 746C

1) Typical values only. Variations within normal tolerances are possible for variose colours.All values are measured at least after 48 hours storage at 230C/50% relative humidity.
All properties, expect the melt volume rate are measured on injection moulded samples.
All samples are prepared according to ISO 294.

2) Only typical data for material selection purpose.Not to be used for part or tool design.
3) This rating is not intended to reflect hazards presented by this or any other material under actual fire conditions.
4) Own measurement according to UL.

Source, GMD, Last Update:02/24/2004

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PROCESSING PARAMETERS	TYPICAL VALUE	UNIT
Injection Molding		
Drying Temperature	120	°C
Drying Time	3 - 4	hrs
Drying Time (Cumulative)	48	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	320 - 345	°C
Nozzle Temperature	315 - 340	°C
Front - Zone 3 Temperature	320 - 345	°C
Middle - Zone 2 Temperature	310 - 330	°C
Rear - Zone 1 Temperature	300 - 320	°C
Mold Temperature	80 - 115	°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

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