

**Product Texts**

LEXAN ML7689 polycarbonate (PC) siloxane copolymer resin IS a high viscosity injection molding (IM) grade WITH good processability, offering opportunities FOR shorter IM CYCLE times compared TO standard PC resins. This resin offers extreme low temperature (-40 degree C) ductility. LEXAN ML7689resin IS FDA/EU FC compliant available IN OPAQUE colors ONLY AND IS an excellent candidate FOR food contact applications.

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ISO Data</b>			
Melt volume-flow rate, MVR	6	cm <sup>3</sup> /10min	ISO 1133
Temperature	300	°C	-
Load	1.2	kg	-

<b>ASTM Data</b>			
Melt Flow Index, MFI	6	g/10min	ASTM D 1238
Temperature	300	°C	-
Load	1.2	kg	-

Mechanical properties	Value	Unit	Test Standard
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<b>ISO Data</b>			
Tensile Modulus	2150	MPa	ISO 527
Yield stress	57	MPa	ISO 527
Yield strain	6	%	ISO 527
Stress at break	60	MPa	ISO 527
Strain at break	50	%	ISO 527
Flexural modulus	2250	MPa	ISO 178

<b>ASTM Data</b>			
Tensile Modulus	2050	MPa	ASTM D 638
Tensile Strength at Yield	56	MPa	ASTM D 638
Tensile Strength at Break	50	MPa	ASTM D 638
Elongation at Yield	6	%	ASTM D 638
Elongation at Break	100	%	ASTM D 638
Flexural Modulus	2250	MPa	ASTM D 790
Izod Impact notched, 1/8 in	850	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
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<b>ISO Data</b>			
Vicat softening temperature, 120°C/h 50N	146	°C	ISO 306

<b>ASTM Data</b>			
DTUL @ 66 psi	139	°C	ASTM D 648
DTUL @ 264 psi	124	°C	ASTM D 648

Other properties	Value	Unit	Test Standard
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Density	1190	kg/m <sup>3</sup>	ISO 1183
Density	1180	kg/m <sup>3</sup>	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
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Pre-drying - Temperature	120	°C	-
Pre-drying - Time	3 - 4	h	-
Processing humidity	≤0.02	%	-
Melt temperature	295 - 315	°C	-
Mold temperature	70 - 95	°C	-
Zone 1	270 - 295	°C	-
Zone 2	280 - 305	°C	-
Zone 3	295 - 315	°C	-
Screw speed	40 - 70	rpm	-
Back pressure	0.3 - 0.7	MPa	-

**Characteristics**

**Processing**

Injection Molding

**Regional Availability**

Asia Pacific

**Certifications**

Food contact, Food approval FDA 21 CFR