

LEXANTM COPOLYMER ML6413

REGION EUROPE

DESCRIPTION

LEXAN ML6413 is based on Polycarbonate (PC) copolymer resin. It is an impact modified, flame retardant polycarbonate grade with Br- & Cl-free FR systems. It features improved light shielding capability with good flow, impact and thermal properties targeted for various applications.

TYPICAL PROPERTY VALUES

Revision 20231109

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL (1)			
Tensile Stress, yld, Type I, 50 mm/min	58	MPa	ASTM D638
Tensile Stress, brk, Type I, 50 mm/min	55	MPa	ASTM D638
Tensile Strain, yld, Type I, 50 mm/min	5	%	ASTM D638
Tensile Strain, brk, Type I, 50 mm/min	100	%	ASTM D638
Tensile Modulus, 5 mm/min	2500	MPa	ASTM D638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	85	MPa	ASTM D790
Flexural Modulus, 1.3 mm/min, 50 mm span	2250	MPa	ASTM D790
Tensile Stress, yield, 50 mm/min	62	MPa	ISO 527
Tensile Stress, break, 50 mm/min	58	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	5	%	ISO 527
Tensile Strain, break, 50 mm/min	100	%	ISO 527
Tensile Modulus, 1 mm/min	2350	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	90	MPa	ISO 178
Flexural Modulus, 2 mm/min	2350	MPa	ISO 178
IMPACT (1)			
Izod Impact, notched, 23°C	790	J/m	ASTM D256
Izod Impact, notched, -30°C	150	J/m	ASTM D256
Instrumented Dart Impact Total Energy, 23°C	72	J	ASTM D3763
Izod Impact, notched 80*10*3 +23°C	60	kJ/m²	ISO 180/1A
Izod Impact, notched 80*10*3 -30°C	15	kJ/m²	ISO 180/1A
THERMAL (1)			
Vicat Softening Temp, Rate B/50	134	°C	ASTM D1525
HDT, 1.82 MPa, 6.4 mm, unannealed	118	°C	ASTM D648
CTE, -40°C to 40°C, flow	5.90E-05	1/°C	ASTM E831
CTE, -40°C to 40°C, xflow	7.70E-05	1/°C	ASTM E831
CTE, -40°C to 40°C, flow	7.0E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	7.0E-05	1/°C	ISO 11359-2
Vicat Softening Temp, Rate B/50	134	°C	ISO 306
Vicat Softening Temp, Rate B/120	135	°C	ISO 306
HDT/Be, 0.45MPa Edgew 120*10*4 sp=100mm	125	°C	ISO 75/Be
HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm	115	°C	ISO 75/Ae
Relative Temp Index, Elec ⁽²⁾	100	°C	UL 746B
Relative Temp Index, Mech w/impact (2)	100	°C	UL 746B
Relative Temp Index, Mech w/o impact (2)	100	°C	UL 746B



PMSICAL (**) Specific Gravity 1.2				
Specific Gravity 1.2 AFTM D792 Modd Shrinkage, flow, 3.2 mm ⁶¹ 0.4 – 0.8 8 ARTM D728 Bensity 1.2 9 / m² MS D1183 Density 1.2 9 / m² 85 0 182 Water Absorption, (23°C/ Stat) 0.3 8 80 6 2-1 Melit Volume Rate, MVR at 280°C/5.0 kg 20 m²/10 ml \$0 1133 SELECTISCA.10** Volume Rate, MVR at 280°C/5.0 kg > 1.8 15 0.0m ATM 0257 Comparative Tracking Index (UL) (PLC) 2 0.0m ATM 0257 Comparative Tracking Index (UL) (PLC) 2.3 mm U. 746A Hot-Wire Ignition (HVI), PLC 2 2.3 mm U. 746A Hot-Wire Ignition (HVI), PLC 3 2.1 mm U. 746A Hot-Wire Ignition (HVI), PLC 3 2.5 mm U. 746A Live Seguitation (HVI), PLC 3 2.5 mm U. 746A U. Recognized, 94%V Flame Class Rating 2.5 mm U. 94 U. Recognized, 9	PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Model Shrinklage, flow, 3.2 mm (P) 0.4 − 0.8 % SABIC method Melt Flow Rate, 26°C (F.50 kgf) 24 g/10 min ATM D1238 Water Absorption, (23°C/saturated) 0.3 % 150 62 Moisture Absorption (23°C/saturated) 0.1 % 150 62 Moisture Absorption (23°C/so kg) 0.1 % 150 62 Melt Volume Rate, MYR at 260°C/5.0 kg 0.2 % 70 min 150 62 ELECTRICAL (T) TU V V V V V V 10 74 64 V	PHYSICAL (1)			
Mel Flow Rate, 260°C/5.0 kg/f 24 g/10 min ASTM D1238 Density 1.2 g/cm² SC 183 Water Absorption (23°C/50 kH) 0.1 % 50 62 Moliture Absorption (23°C/50 kH) 0.1 % 50 62 Melt Volume Rate, MVR at 260°C/5.0 kg 20 men'/10 min bio 133 CECETRICAL U Comparative Tacking Index (UL) (PLC) 2 Comparative Tacking Index (UL) (PLC) 2 6.0 ASIM D257 Comparative Tacking Index (UL) (PLC) 2 2 Command MT 766 ASIM D257 Hot-Wire Ignition (HM), PLC 2 2 1.6 mm U.746A 1.0 Hot-Wire Ignition (HM), PLC 3 2 1.0 <td>Specific Gravity</td> <td>1.2</td> <td>-</td> <td>ASTM D792</td>	Specific Gravity	1.2	-	ASTM D792
Density 1.2 g/cm² ISO 1183 Water Aksorption, (23°C/saturated) 0.3 % ISO 62-1 Molt Valume Rate, MWR at 260°C/5.0 kg 20 m² 10 min ISO 133 ELECTRICAL ¹³ Volume Resistivity > 1£+15 O.cm AS1M D257 Comparative Tracking Index (UL) (PLC) 2 RCC Code UL 746A Hot-Wire Ignition (HMI), PLC 2 23 mm UL 746A Hot-Wire Ignition (HMI), PLC 3 1.6 mm UL 746A HOK-Wire Ignition (HMI), PLC 0 2.16 mm UL 746A HOK-Wire Ignition (HMI), PLC 0 2.6 mm UL 746A HOK-Wire Ignition (HMI), PLC 0 2.6 mm UL 746A HOK-Wire Ignition (HMI), PLC 0 2.6 mm UL 746A HOK-Wire Ignition (HMI), PLC 0 2.6 mm UL 746A UL Recognized, 94-95 Al Fame Class Rating 2.5 mm UL 94 UL Recognized, 94-95 N Fame Class Rating 2.1.6 mm UL 94 UL Recognized, 94-95 N Fame Class Rating 2.1.6 EC 600952-13 <	Mold Shrinkage, flow, 3.2 mm ⁽³⁾	0.4 - 0.8	%	SABIC method
Moisture Absorption (23°C/saturated)	Melt Flow Rate, 260°C/5.0 kgf	24	g/10 min	ASTM D1238
Molt Volume Rates, MVR at 260°C (5.0 kg) 0.1 % ISO 62 Melt Volume Rates, MVR at 260°C (5.0 kg) 20 cm³/ I min 80 1133 ELECTRICAL. (1)** Volume Resistivity 2 AC ASTM D257 Comparative Tracking Index (UL) (PLC) 2 PLC code U.7 46A Hot-Wire Ignition (HWI), PLC 2 21.6 mm U.1 746A Hot-Wire Ignition (HMI), PLC 3 21.6 mm U.1 746A Hot-Wire Ignition (HMI), PLC 3 21.6 mm U.1 746A Hot-Wire Ignition (HMI), PLC 3 2.16 mm U.1 746A Hot-Wire Ignition (HMI), PLC 3 2.16 mm U.1 746A Hot-Wire Ignition (HMI), PLC 3 2.16 mm U.1 746A U.1 6.0 2.1 mm U.1 746A Hot-Wire Ignition (HMI), PLC 3 2.1 2.0 2.0 2.0 U.1 8.0 2.0 2.0 2.0 2.0 2.0 2.0 2.0 2.0 2.0	Density	1.2	g/cm³	ISO 1183
Melt Volume Rate, MVR at 260°C/5.0 kg 20 cm²/10 min 50 133 ELECTRICAL (**) ************************************	Water Absorption, (23°C/saturated)	0.3	%	ISO 62-1
National Resistivity	Moisture Absorption (23°C / 50% RH)	0.1	%	ISO 62
Volume Resistivity >1.E195 Q.Cm ASTM D257 Comparative Tracking Index (UL) (PLC) 2 R.C Code UL 746A Hot-Wire Ignition (HWI), PLC 2 33 mm UL 746A High Amp Arc Ignition (HWI), PLC 3 21.6 mm UL 746A High Amp Arc Ignition (HWI), PLC 0 21.6 mm UL 746A High Amp Arc Ignition (HWI), PLC 0 21.6 mm UL 746A HUR CORDITION (HWI), PLC 0 21.6 mm UL 746A UR RECORDIZEO, 94-SVA Flame Class Rating 22.75 mm UL 94 UL Recognized, 94-SVA Flame Class Rating 21.6 mm UL 94 Glow Wire Ignitability Temperature, 3.0 mm 80.0 "C IEC 60695-213 Glow Wire Ignitability Temperature, 2.5 mm 80.0 "C IEC 60695-213 Glow Wire Ignitability Temperature, 1.6 mm 80.0 "C IEC 60695-213 Glow Wire Ignitability Index, 2.5 mm 90.0 "C IEC 60695-212 Glow Wire Flammability Index, 2.5 mm 90.0 "C IEC 60695-212 Glow Wire Flammability Index, 1.6 mm	Melt Volume Rate, MVR at 260°C/5.0 kg	20	cm³/10 min	ISO 1133
Comparative Tracking Index (UL) (PLC) 2 PLC Code UL 746A Hot-Wire Ignition (HWI), PLC 2 ≥3 mm UL 746A Hot-Wire Ignition (HWI), PLC 3 ≥1.6 mm UL 746A Hot-Wire Ignition (HWI), PLC 0 ≥1.6 mm UL 746A High Amp Arc Ignition (HAI), PLC 0 ≥1.6 mm UL 746A FLAME CHARACTERISTICS (PT) VEX. VEX. VEX. UL Recognized, 94-5VA Flame Class Rating ≥1.7 mm UL 94 UL Recognized, 94-5VA Flame Class Rating ≥1.6 mm UL 94 Glow Wire Ignitability Temperature, 2.0 mm 800 °C UE 60695-2·13 Glow Wire Ignitability Temperature, 2.0 mm 800 °C UE 60695-2·13 Glow Wire Ignitability Temperature, 2.0 mm 800 °C UE 60695-2·13 Glow Wire Ignitability Temperature, 2.0 mm 800 °C UE 60695-2·13 Glow Wire Ignitability Temperature, 2.0 mm 800 °C UE 60695-2·13 Glow Wire Ignitability Temperature, 2.0 mm 90 °C UE 60695-2·12 Glow Wire Ignitability	ELECTRICAL (1)			
Hot-Wire Ignition (HWI), PLC 2 ≥3 mm UL 746A Hot-Wire Ignition (HWI), PLC 3 ≥1.6 mm UL 746A High Amp Arc Ignition (HWI), PLC 0 ≥1.6 mm UL 746A LUARD CHARACTERISICS (**) ************************************	Volume Resistivity	>1.E+15	Ω.cm	ASTM D257
Hot-Wire Ignition (HM), PLC 3	Comparative Tracking Index (UL) {PLC}	2	PLC Code	UL 746A
High Amp Arc Ignition (HAI), PLC 0	Hot-Wire Ignition (HWI), PLC 2	≥3	mm	UL 746A
FAME CHARACTERISTICS (2) UL Yellow Card Link £20.7780.5553.23 - - UL Recognized, 94-5VA Flame Class Rating ≥1.7 mm UL 94 UL Recognized, 94-5VB Flame Class Rating ≥1.6 mm UL 94 Glow Wire Ignitability Temperature, 3.0 mm 800 ° LEC 60695-213 Glow Wire Ignitability Temperature, 2.5 mm 800 ° LEC 60695-213 Glow Wire Ignitability Temperature, 2.0 mm 800 ° LEC 60695-213 Glow Wire Ignitability Temperature, 1.6 mm 800 ° LEC 60695-213 Glow Wire Ignitability Index, 2.5 mm 800 ° LEC 60695-213 Glow Wire Ignitability Temperature, 1.6 mm 800 ° LEC 60695-213 Glow Wire Flammability Index, 2.5 mm 960 ° LEC 60695-212 Glow Wire Flammability Index, 2.5 mm 960 ° LEC 60695-212 Glow Wire Flammability Index, 1.5 mm 960 ° LEC 60695-212 Glow Wire Flammability Index, 1.5 mm 90 ° ° Drying Temperature 90 ° ° <td>Hot-Wire Ignition (HWI), PLC 3</td> <td>≥1.6</td> <td>mm</td> <td>UL 746A</td>	Hot-Wire Ignition (HWI), PLC 3	≥1.6	mm	UL 746A
Li Yellow Card Link E207780-555323	High Amp Arc Ignition (HAI), PLC 0	≥1.6	mm	UL 746A
LU Recognized, 94-5VA Flame Class Rating 2.5 mm UL 94 UL Recognized, 94-5VB Flame Class Rating 21.6 mm UL 94 UL Recognized, 94-V0 Flame Class Rating 21.6 mm UL 94 UL Recognized, 94-V0 Flame Class Rating 800 °C IEC 60695-2-13 Glow Wire Ignitability Temperature, 2.5 mm 800 °C IEC 60695-2-13 Glow Wire Ignitability Temperature, 2.0 mm 800 °C IEC 60695-2-13 Glow Wire Ignitability Temperature, 1.6 mm 800 °C IEC 60695-2-13 Glow Wire Ignitability Temperature, 1.6 mm 800 °C IEC 60695-2-13 Glow Wire Ignitability Temperature, 1.6 mm 960 °C IEC 60695-2-13 Glow Wire Flammability Index, 3.0 mm 960 °C IEC 60695-2-12 Glow Wire Flammability Index, 2.5 mm 960 °C IEC 60695-2-12 Glow Wire Flammability Index, 2.0 mm 960 °C IEC 60695-2-12 Glow Wire Flammability Index, 1.7 mm 960 °C IEC 60695-2-12 Glow Wire Flammability Index, 1.6 mm 960 °C IEC 60695-2-12 Glow Wire Flammability Index, 1.6 mm 960 °C IEC 60695-2-12 Glow Wire Flammability Index, 1.6 mm 960 °C IEC 60695-2-12 Glow Wire Flammability Index, 1.6 mm 960 °C IEC 60695-2-12 Glow Wire Flammability Index, 1.7 mm 960 °C IEC 60695-2-12 Glow Wire Flammability Index, 1.6 mm 960 °C IEC 60695-2-12 Glow Wire Flammability Index, 1.6 mm 960 °C IEC 60695-2-12 Glow Wire Flammability Index, 1.6 mm 960 °C IEC 60695-2-12 Glow Wire Flammability Index, 1.7 mm 960 °C IEC 60695-2-12 Glow Wire Flammability Index, 1.6 mm 960 °C IEC 60695-2-12 Glow Wire Flammability Index, 1.7 mm 960 °C IEC 60695-2-12 Glow Wire Flammability Index, 1.7 mm 960 °C IEC 60695-2-12 Glow Wire Flammability Index, 1.7 mm 960 °C IEC 60695-2-12 Glow Wire Flammability Index, 1.7 mm 960 °C IEC 60695-2-12 Glow Wire Flammability Index, 1.7 mm 960 °C IEC 60695-2-12 Glow Wire Flammability Index, 1.6 mm 960 °C IEC 60695-2-12 Glow Wire Flammability	FLAME CHARACTERISTICS (2)			
UL Recognized, 94-5VB Flame Class Rating ≥1.7 mm UL 94 UL Recognized, 94V-0 Flame Class Rating ≥1.6 mm UL 94 Glow Wire Ignitability Temperature, 2.0 mm 800 °C IEC 60695-2-13 Glow Wire Ignitability Temperature, 2.0 mm 800 °C IEC 60695-2-13 Glow Wire Ignitability Temperature, 1.7 mm 800 °C IEC 60695-2-13 Glow Wire Ignitability Temperature, 1.6 mm 800 °C IEC 60695-2-13 Glow Wire Ignitability Index, 3.0 mm 960 °C IEC 60695-2-12 Glow Wire Flammability Index, 2.5 mm 960 °C IEC 60695-2-12 Glow Wire Flammability Index, 2.0 mm 960 °C IEC 60695-2-12 Glow Wire Flammability Index, 1.6 mm 960 °C IEC 60695-2-12 Glow Wire Flammability Index, 1.6 mm 90 − 100 °C IEC 60695-2-12 More Time Flammability Index, 1.6 mm 90 − 100 °C IEC 60695-2-12 Nozign Temperature 2 − 4 Hrs Drying Time 2 − 4 Hrs Melt Temperature 250 − 290	UL Yellow Card Link	E207780-555323	-	-
UL Recognized, 94V-0 Flame Class Rating ≥1.6 mm UL 94 Glow Wire Ignitability Temperature, 3.0 mm 800 °C IEC 60695-2-13 Glow Wire Ignitability Temperature, 2.5 mm 800 °C IEC 60695-2-13 Glow Wire Ignitability Temperature, 2.0 mm 800 °C IEC 60695-2-13 Glow Wire Ignitability Temperature, 1.7 mm 800 °C IEC 60695-2-13 Glow Wire Ignitability Temperature, 1.6 mm 800 °C IEC 60695-2-13 Glow Wire Ignitability Index, 3.0 mm 960 °C IEC 60695-2-12 Glow Wire Flammability Index, 2.5 mm 960 °C IEC 60695-2-12 Glow Wire Flammability Index, 1.7 mm 960 °C IEC 60695-2-12 Glow Wire Flammability Index, 1.6 mm 90-100 °C IEC 60695-2-12 INIECTION MOLDING (*) *C *C 1EC 60695-2-12 Maximum Moisture Content 0.02 *C *C Maximum Moisture Content 2.70-300 °C *C Nozzle Temperature 250-290 °C *C Front - Zone 3 Temperature	UL Recognized, 94-5VA Flame Class Rating	≥2.5	mm	UL 94
Glow Wire Ignitability Temperature, 3.0 mm 8800 °C IEC 60695:2:13 Glow Wire Ignitability Temperature, 2.5 mm 8800 °C IEC 60695:2:13 Glow Wire Ignitability Temperature, 2.0 mm 8800 °C IEC 60695:2:13 Glow Wire Ignitability Temperature, 1.7 mm 8800 °C IEC 60695:2:13 Glow Wire Ignitability Temperature, 1.6 mm 8800 °C IEC 60695:2:13 Glow Wire Ignitability Index, 3.0 mm 960 °C IEC 60695:2:12 Glow Wire Flammability Index, 2.5 mm 960 °C IEC 60695:2:12 Glow Wire Flammability Index, 2.0 mm 960 °C IEC 60695:2:12 Glow Wire Flammability Index, 1.7 mm 960 °C IEC 60695:2:12 Glow Wire Flammability Index, 1.6 mm 960 °C IEC 60695:2:12 INIECTION MOLDING (**) ************************************	UL Recognized, 94-5VB Flame Class Rating	≥1.7	mm	UL 94
Silva Wire Ignitability Temperature, 2.5 mm 800 °C IEC 60695-2-13	UL Recognized, 94V-0 Flame Class Rating	≥1.6	mm	UL 94
Silva Wire Ignitability Temperature, 2.0 mm 800 °C IEC 60695-2·13	Glow Wire Ignitability Temperature, 3.0 mm	800	°C	IEC 60695-2-13
Glow Wire Ignitability Temperature, 1.7 mm 800 °C IEC 60695-2-13 Glow Wire Ignitability Temperature, 1.6 mm 800 °C IEC 60695-2-13 Glow Wire Flammability Index, 3.0 mm 960 °C IEC 60695-2-12 Glow Wire Flammability Index, 2.5 mm 960 °C IEC 60695-2-12 Glow Wire Flammability Index, 2.0 mm 960 °C IEC 60695-2-12 Glow Wire Flammability Index, 1.7 mm 960 °C IEC 60695-2-12 Glow Wire Flammability Index, 1.6 mm 960 °C IEC 60695-2-12 INJECTION MOLDING ⁽⁴⁾ *** *** *** Drying Temperature 90 − 100 °C *** *** Maximum Moisture Content 0.02 % *** *** *** *** *** *** *** *** *** ** ***	Glow Wire Ignitability Temperature, 2.5 mm	800	°C	IEC 60695-2-13
Glow Wire Ignitability Temperature, 1.6 mm 800 °C IEC 60695-2-13 Glow Wire Flammability Index, 3.0 mm 960 °C IEC 60695-2-12 Glow Wire Flammability Index, 2.5 mm 960 °C IEC 60695-2-12 Glow Wire Flammability Index, 2.0 mm 960 °C IEC 60695-2-12 Glow Wire Flammability Index, 1.7 mm 960 °C IEC 60695-2-12 Glow Wire Flammability Index, 1.6 mm 90 − 100 °C IEC 60695-2-12 INJECTION MOLDING ⁽⁴⁾ V V V Drying Temperature 90 − 100 °C V V Maximum Moisture Content 0.02 % V <t< td=""><td>Glow Wire Ignitability Temperature, 2.0 mm</td><td>800</td><td>°C</td><td>IEC 60695-2-13</td></t<>	Glow Wire Ignitability Temperature, 2.0 mm	800	°C	IEC 60695-2-13
Glow Wire Flammability Index, 3.0 mm 960 °C IEC 60695-2-12 Glow Wire Flammability Index, 2.5 mm 960 °C IEC 60695-2-12 Glow Wire Flammability Index, 2.0 mm 960 °C IEC 60695-2-12 Glow Wire Flammability Index, 1.7 mm 960 °C IEC 60695-2-12 Glow Wire Flammability Index, 1.6 mm 960 °C IEC 60695-2-12 INJECTION MOLDING ⁽⁴⁾ V IEC 60695-2-12 Drying Temperature 90 – 100 °C IEC 60695-2-12 Maximum Moisture Content 90 – 100 °C IEC 60695-2-12 Melt Temperature 2 – 4 Hrs IEC 60695-2-12 Mozzle Temperature 270 – 300 °C IEC 60695-2-12 Nozzle Temperature 250 – 290 °C IEC 60695-2-12 Middle Zone 3 Temperature 260 – 300 °C IEC 60695-2-12 Mozzle Temperature 250 – 290 °C IEC 60695-2-12 Mozzle Temperature 250 – 290 °C IEC 60695-2-12 Mozzle Temperature 250 – 290 °C IEC 60695-2-12	Glow Wire Ignitability Temperature, 1.7 mm	800	°C	IEC 60695-2-13
Glow Wire Flammability Index, 2.5 mm 960 °C IEC 60695-2-12 Glow Wire Flammability Index, 2.0 mm 960 °C IEC 60695-2-12 Glow Wire Flammability Index, 1.7 mm 960 °C IEC 60695-2-12 Glow Wire Flammability Index, 1.6 mm 960 °C IEC 60695-2-12 INJECTION MOLDING ⁽⁴⁾ V IEC 60695-2-12 Drying Temperature 90 – 100 °C IEC 60695-2-12 Maximum Moisture Content 90 – 100 °C IEC 60695-2-12 Melt Temperature 270 – 300 °C IEC 60695-2-12 Nozzle Temperature 270 – 300 °C IEC 60695-2-12 Nozzle Temperature 250 – 290 °C IEC 60695-2-12 Middle - Zone 3 Temperature 260 – 300 °C IEC 60695-2-12 Middle - Zone 2 Temperature 250 – 290 °C IEC 60695-2-12 Middle - Zone 2 Temperature 230 – 260 °C IEC 60695-2-12 Hors IEC 60695-2-12 IEC 60695-2-12 IEC 60695-2-12 Maximum Moisture Content 200 °C IEC 606	Glow Wire Ignitability Temperature, 1.6 mm	800	°C	IEC 60695-2-13
Glow Wire Flammability Index, 2.0 mm 960 °C IEC 60695-2-12 Glow Wire Flammability Index, 1.7 mm 960 °C IEC 60695-2-12 Glow Wire Flammability Index, 1.6 mm 960 °C IEC 60695-2-12 INJECTION MOLDING ⁽⁴⁾ *** *** Drying Temperature 90 − 100 °C ** Prying Time 2 − 4 Hrs ** Maximum Moisture Content 0.02 % ** Nozle Temperature 270 − 300 °C ** Nozle Temperature 250 − 290 °C ** Front - Zone 3 Temperature 260 − 300 °C ** Middle - Zone 2 Temperature 250 − 290 °C ** Rear - Zone 1 Temperature 230 − 260 °C ** Hopper Temperature 60 − 80 °C **	Glow Wire Flammability Index, 3.0 mm	960	°C	IEC 60695-2-12
Glow Wire Flammability Index, 1.7 mm 960 °C IEC 60695-2-12 Glow Wire Flammability Index, 1.6 mm 960 °C IEC 60695-2-12 INJECTION MOLDING ⁽⁴⁾ Drying Temperature 90 − 100 °C C Drying Time Hrs C C Maximum Moisture Content 0.02 % C Nozzle Temperature 270 − 300 °C C Front - Zone 3 Temperature 260 − 300 °C C Middle - Zone 2 Temperature 250 − 290 °C C Rear - Zone 1 Temperature 230 − 260 °C C Hopper Temperature 60 − 80 °C C	Glow Wire Flammability Index, 2.5 mm	960	°C	IEC 60695-2-12
Glow Wire Flammability Index, 1.6 mm Porying Temperature Porying Time Aximum Moisture Content Mozzle Temperature Poozzle Temperature 270 – 300 C Rozzle Temperature 250 – 290 C Middle - Zone 2 Temperature 250 – 290 C Rear - Zone 1 Temperature 60 – 80 C Rear - Zone 1 Temperature 60 – 80 C Rear - Zone 1 Temperature 60 – 80 C Rear - Zone 1 Temperature 60 – 80 C Rear - Zone 1 Temperature 60 – 80 C Rear - Zone 1 Temperature 60 – 80 C Rear - Zone 1 Temperature 60 – 80 C Rear - Zone 1 Temperature 60 – 80 C Rear - Zone 1 Temperature 60 – 80 C Rear - Zone 1 Temperature 60 – 80 C Rear - Zone 1 Temperature 60 – 80 C Rear - Zone 1 Temperature 60 – 80 C Rear - Zone 1 Temperature 60 – 80 C Rear - Zone 1 Temperature 60 – 80 C Rear - Zone 1 Temperature 60 – 80 C Rear - Zone 1 Temperature 60 – 80 C Rear - Zone 1 Temperature 60 – 80	Glow Wire Flammability Index, 2.0 mm	960	°C	IEC 60695-2-12
Drying Temperature 90 – 100 °C Drying Time 2 – 4 Hrs Maximum Moisture Content 270 – 300 °C Mozzle Temperature 250 – 290 °C Middle - Zone 2 Temperature 250 – 290 °C Rear - Zone 1 Temperature 230 – 260 °C Hopper Temperature 60 – 80 °C	Glow Wire Flammability Index, 1.7 mm	960	°C	IEC 60695-2-12
Drying Temperature 90 – 100 °C Drying Time 2 – 4 Hrs Maximum Moisture Content 0.02 % Melt Temperature 270 – 300 °C Nozzle Temperature 250 – 290 °C Front - Zone 3 Temperature 260 – 300 °C Middle - Zone 2 Temperature 250 – 290 °C Rear - Zone 1 Temperature 230 – 260 °C Hopper Temperature 60 – 80 °C	Glow Wire Flammability Index, 1.6 mm	960	°C	IEC 60695-2-12
Drying Time 2 – 4 Hrs Maximum Moisture Content 0.02 % Melt Temperature 270 – 300 °C Nozzle Temperature 250 – 290 °C Front - Zone 3 Temperature 250 – 290 °C Middle - Zone 2 Temperature 250 – 290 °C Rear - Zone 1 Temperature 230 – 260 °C Hopper Temperature 60 – 80 °C	INJECTION MOLDING (4)			
Maximum Moisture Content 0.02 % Melt Temperature 270 – 300 °C Nozzle Temperature 250 – 290 °C Front - Zone 3 Temperature 260 – 300 °C Middle - Zone 2 Temperature 250 – 290 °C Rear - Zone 1 Temperature 230 – 260 °C Hopper Temperature 60 – 80 °C	Drying Temperature	90 – 100	°C	
Melt Temperature 270 – 300 °C Nozzle Temperature 250 – 290 °C Front - Zone 3 Temperature 260 – 300 °C Middle - Zone 2 Temperature 250 – 290 °C Rear - Zone 1 Temperature 230 – 260 °C Hopper Temperature 60 – 80 °C	Drying Time	2 – 4	Hrs	
Nozzle Temperature 250 – 290 °C Front - Zone 3 Temperature 260 – 300 °C Middle - Zone 2 Temperature 250 – 290 °C Rear - Zone 1 Temperature 230 – 260 °C Hopper Temperature 60 – 80 °C	Maximum Moisture Content	0.02	%	
Front - Zone 3 Temperature 260 – 300 °C Middle - Zone 2 Temperature 250 – 290 °C Rear - Zone 1 Temperature 230 – 260 °C Hopper Temperature 60 – 80 °C	Melt Temperature	270 – 300	°C	
Middle - Zone 2 Temperature 250 – 290 °C Rear - Zone 1 Temperature 230 – 260 °C Hopper Temperature 60 – 80 °C	Nozzle Temperature	250 – 290	°C	
Rear - Zone 1 Temperature 230 - 260 °C Hopper Temperature 60 - 80 °C	Front - Zone 3 Temperature	260 – 300	°C	
. Hopper Temperature 60 − 80 °C	Middle - Zone 2 Temperature	250 – 290	°C	
	Rear - Zone 1 Temperature	230 – 260		
Mold Temperature 60 – 90 °C	Hopper Temperature	60 – 80	°C	
	Mold Temperature	60 – 90	°C	



- (1) The information stated on Technical Datasheets should be used as indicative only for material selection purposes and not be utilized as specification or used for part or tool design.
- (2) UL Ratings shown on the technical datasheet might not cover the full range of thicknesses and colors. For details, please see the UL Yellow Card.
- (3) Measurements made from laboratory test coupon. Actual shrinkage may vary outside of range due to differences in processing conditions, equipment, part geometry and tool design. It is recommended that mold shrinkage studies be performed with surrogate or legacy tooling prior to cutting tools for new molded article. The information stated on Technical Datasheets should be used as indicative only for material selection purposes and not be utilized as specification or used for part or tool design.
- (4) Injection Molding parameters are only mentioned as general guidelines. These may not apply or may need adjustment in specific situations such as low shot sizes, large part molding, thin wall molding and gas-assist molding.

DISCLAIMER

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