

Lexan* Resin ML6451

Americas: COMMERCIAL

UV-stabilized, co-extrusion capstock material. Minimal processing values available at this time.

Property

TYPICAL PROPERTIES ⁽¹⁾			
MECHANICAL	Value	Unit	Standard
Tensile Stress, yld, Type I, 50 mm/min	71	MPa	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	72	MPa	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	98	%	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	104	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	2590	MPa	ASTM D 790
IMPACT	Value	Unit	Standard
Izod Impact, notched, 23°C	90	J/m	ASTM D 256
THERMAL	Value	Unit	Standard
HDT, 1.82 MPa, 3.2mm, unannealed	114	°C	ASTM D 648
PHYSICAL	Value	Unit	Standard
Specific Gravity	1.19	-	ASTM D 792
Melt Flow Rate, 300°C/1.2 kgf	10.5	g/10 min	ASTM D 1238

Source GMD, last updated:01/04/2000

Processing

Parameter	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	295 - 315	°C
Nozzle Temperature	290 - 310	°C
Front - Zone 3 Temperature	295 - 315	°C
Middle - Zone 2 Temperature	280 - 305	°C
Rear - Zone 1 Temperature	270 - 295	°C
Mold Temperature	70 - 95	°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

Source GMD, last updated:01/04/2000

THESE PROPERTY VALUES ARE NOT INTENDED FOR SPECIFICATION PURPOSES.

PLEASE CHECK WITH YOUR [\(LOCAL SALES OFFICE\)](#) FOR AVAILABILITY IN YOUR REGION

(1) Typical values only. Variations within normal tolerances are possible for various colors. All values are measured after at least 48 hours storage at 23°C/50% relative humidity. All properties, except the melt volume and melt flow rates, are measured on injection molded samples. All samples tested under ISO test standards are prepared according to ISO 294.

- (2) Only typical data for selection purposes. 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) Internal measurements according to UL standards.

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