

Product Texts

LEXAN ML6411 polycarbonate (PC) siloxane resin, is a high flow opaque injection molding (IM) grade with very low temperature ductility characteristics. This grade offers UL94 V0 @ 1.5mm and 5VA @ 3.0mm flame retardancy based on non-chlorine, non-bromine FR systems. LEXAN ML6411 resin offers excellent processing characteristics with opportunity for shorter IM cycle times compared to standard PC. This product is available in a wide range of opaque colors and is an excellent candidate for a wide range of electrical applications.

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	18	cm ³ /10min	ISO 1133
Temperature	260	°C	-
Load	5	kg	-
ASTM Data			
Melt Flow Index, MFI	7	g/10min	ASTM D 1238
Temperature	260	°C	-
Load	2.16	kg	-
Mechanical properties			
ISO Data			
Tensile Modulus	2350	MPa	ISO 527
Yield stress	62	MPa	ISO 527
Yield strain	5	%	ISO 527
Stress at break	58	MPa	ISO 527
Strain at break	50	%	ISO 527
Flexural modulus	2350	MPa	ISO 178
Izod notched impact strength, +23°C, 3mm	60	kJ/m ²	ISO 180/1A
Izod notched impact strength, -30°C, 3mm	15	kJ/m ²	ISO 180/1A
ASTM Data			
Tensile Modulus	2500	MPa	ASTM D 638
Tensile Strength at Yield	62	MPa	ASTM D 638
Tensile Strength at Break	54	MPa	ASTM D 638
Elongation at Yield	5	%	ASTM D 638
Elongation at Break	100	%	ASTM D 638
Flexural Modulus	2600	MPa	ASTM D 790
Izod Impact notched, 1/8 in	900	J/m	ASTM D 256
Izod Impact notched, Low-Temperature	150	J/m	ASTM D 256
Temperature	-30	°C	-
Thermal properties			
ISO Data			
Vicat softening temperature, B	134	°C	ISO 306
Vicat softening temperature, 120°C/h 50N	135	°C	ISO 306
ASTM Data			
DTUL @ 264 psi	114	°C	ASTM D 648
Vicat Temperature	134	°C	ASTM D 1525
Electrical properties			
ISO Data			
Volume resistivity	>1E13	Ohm*m	IEC 62631-3-1
Comparative tracking index	250	-	IEC 60112
ASTM Data			
Dielectric Strength, Short Time	26.5	kV/mm	ASTM D 149
Other properties			
Water absorption	0.3	%	Sim. to ISO 62
Humidity absorption	0.1	%	Sim. to ISO 62
Density	1200	kg/m ³	ISO 1183
Density	1190	kg/m ³	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	90 - 100	°C	-
Pre-drying - Time	2 - 4	h	-
Processing humidity	≤0.02	%	-
Melt temperature	270 - 300	°C	-
Mold temperature	60 - 90	°C	-
Feed temperature	60 - 80	°C	-
Zone 1	230 - 260	°C	-
Zone 2	250 - 290	°C	-
Zone 3	260 - 300	°C	-

Characteristics**Processing**

Injection Molding

Special Characteristics

Flame retardant

Additives

Flame retarding agent

Regional Availability

North America