

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.

UL Yellow Card Link [E207780-521735](https://www.ul.com/yellow-card/E207780-521735)

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	Value	Unit	Test Standard
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	Value	Unit	Test Standard
ISO Data			
Vicat softening temperature, B	134	°C	ISO 306
Vicat softening temperature, 120°C/h 50N	135	°C	ISO 306
Burning behav. at 1.5 mm nom. thickn.	V-0	class	IEC 60695-11-10
Thickness tested	1.5	mm	-
Burning behav. at thickness h	V-2	class	IEC 60695-11-10
Thickness tested	0.8	mm	-
Burning behav. 5V at thickness h	5VB	class	IEC 60695-11-20
Thickness tested	1.7	mm	-
Glow Wire Flammability Index (GWFI)	960	°C	IEC 60695-2-12
Glow Wire Flammability Index (GWFI)	960	°C	IEC 60695-2-12
Glow Wire Flammability Index (GWFI)	960	°C	IEC 60695-2-12
Glow Wire Ignition Temperature (GWIT)	800	°C	IEC 60695-2-13
GWIT - thickness tested (1)	1	mm	-
Glow Wire Ignition Temperature (GWIT)	800	°C	IEC 60695-2-13
GWIT - thickness tested (2)	2	mm	-
Glow Wire Ignition Temperature (GWIT)	800	°C	IEC 60695-2-13
GWIT - thickness tested (3)	3	mm	-

LEXAN™ Copolymer ML6411 - Asia

PC

Saudi Basic Industries Corporation (SABIC)

ASTM Data

DTUL @ 264 psi	114	°C	ASTM D 648
Vicat Temperature	134	°C	ASTM D 1525

Electrical properties

	Value	Unit	Test Standard
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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
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Other properties

	Value	Unit	Test Standard
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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
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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

Asia Pacific