

LEXAN™ COPOLYMER ML6411

REGION AMERICAS

DESCRIPTION

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.

TYPICAL PROPERTY VALUES

Revision 20241024

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL ⁽¹⁾			
Tensile Stress, yld, Type I, 50 mm/min	62	MPa	ASTM D638
Tensile Stress, brk, Type I, 50 mm/min	54	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, 50 mm/min	2500	MPa	ASTM D638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	95	MPa	ASTM D790
Flexural Modulus, 1.3 mm/min, 50 mm span	2600	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	900	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/m ²	ISO 180/1A
Izod Impact, notched 80*10*3 -30°C	15	kJ/m ²	ISO 180/1A
THERMAL ⁽¹⁾			
Vicat Softening Temp, Rate B/50	134	°C	ASTM D1525
HDT, 1.82 MPa, 3.2mm, unannealed	114	°C	ASTM D648
HDT, 0.45 MPa, 6.4 mm, unannealed	128	°C	ASTM D648
HDT, 1.82 MPa, 6.4 mm, unannealed	119	°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
Ball Pressure Test, 125°C +/- 2°C	PASSES	-	IEC 60695-10-2
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

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm	115	°C	ISO 75/Ae
PHYSICAL ⁽¹⁾			
Specific Gravity	1.19	-	ASTM D792
Mold Shrinkage, flow, 3.2 mm ⁽²⁾	0.4 – 0.8	%	SABIC method
Melt Flow Rate, 260°C/2.16 kgf	7	g/10 min	ASTM D1238
Density	1.2	g/cm ³	ISO 1183
Water Absorption, (23°C/saturated)	0.3	%	ISO 62-1
Moisture Absorption (23°C / 50% RH)	0.1	%	ISO 62
Melt Volume Rate, MVR at 260°C/5.0 kg	18	cm ³ /10 min	ISO 1133
ELECTRICAL ⁽¹⁾			
Dielectric Strength, in oil, 3.2 mm	26.5	kV/mm	ASTM D149
Volume Resistivity	>1.E+15	Ω.cm	IEC 60093
Comparative Tracking Index	250	V	IEC 60112
INJECTION MOLDING ⁽³⁾			
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	
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) 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.

(3) 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.

MORE INFORMATION

For curve data and CAE cards, please visit and register at <https://materialfinder.sabic-specialties.com>

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