

LEXANTM COPOLYMER ML6413

REGION ASIA

DESCRIPTION

LEXAN ML6413 resin 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 suitable for various applications.

TYPICAL PROPERTY VALUES

Revision 20200610

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	58	MPa	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	55	MPa	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	5	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	100	%	ASTM D 638
Tensile Modulus, 5 mm/min	2500	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	85	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	2250	MPa	ASTM D 790
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			
Izod Impact, notched, 23°C	790	J/m	ASTM D 256
Izod Impact, notched, -30°C	150	J/m	ASTM D 256
Instrumented Impact Total Energy, 23°C	72	J	ASTM D 3763
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			
Vicat Softening Temp, Rate B/50	134	°C	ASTM D 1525
HDT, 1.82 MPa, 6.4 mm, unannealed	118	°C	ASTM D 648
CTE, -40°C to 40°C, flow	7.7E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	5.9E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, flow	7.E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	7.E-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 ⁽¹⁾	100	°C	UL 746B
Relative Temp Index, Mech w/impact ⁽¹⁾	100	°C	UL 746B
Relative Temp Index, Mech w/o impact ⁽¹⁾	100	°C	UL 746B

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
PHYSICAL			
Specific Gravity	1.2	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	0.4 – 0.8	%	SABIC method
Melt Flow Rate, 260°C/5.0 kgf	24	g/10 min	ASTM D 1238
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	20	cm ³ /10 min	ISO 1133
ELECTRICAL			
Volume Resistivity	>1.E+15	Ohm-cm	ASTM D 257
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
High Amp Arc Ignition (HAI), PLC 0	≥1.6	mm	UL 746A
FLAME CHARACTERISTICS ⁽¹⁾			
UL Yellow Card Link	E207780-555323	-	-
UL Recognized, 94-5VA Flame Class Rating	≥2.5	mm	UL 94
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, 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 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			
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) 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.



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