

Makrolon® 6265 X

Polycarbonate

Covestro - Polycarbonates

Message:

MVR (300 °C/1.2 kg) 19 cm³/10 min; flame retardant; UL 94V-0/1.5 mm; low viscosity; easy release; injection molding - melt temperature 280 - 320 °C; available in opaque colors only

General Information			
UL YellowCard	E41613-100813670		
Additive	Flame Retardant		
Features	Flame Retardant		
	Good Mold Release		
	Low Viscosity		
RoHS Compliance	RoHS Compliant		
Appearance	Colors Available		
	Opaque		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density (23°C)	1.20	g/cm ³	ISO 1183
Apparent Density ¹	0.64	g/cm ³	ISO 60
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	20	g/10 min	ISO 1133
Melt Volume-Flow Rate (MVR) (300°C/1.2 kg)	19.0	cm ³ /10min	ISO 1133
Molding Shrinkage			
Across Flow	0.50 to 0.70	%	ISO 2577
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Across Flow : 2.00 mm ²	0.65	%	ISO 294-4
Flow : 2.00 mm ³	0.65	%	ISO 294-4
Water Absorption			ISO 62
Saturation, 23°C	0.30	%	
Equilibrium, 23°C, 50% RH	0.12	%	
Hardness	Nominal Value	Unit	Test Method
Ball Indentation Hardness	115	MPa	ISO 2039-1
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	2400	MPa	ISO 527-2/1
Tensile Stress			ISO 527-2/50
Yield, 23°C	65.0	MPa	
Break, 23°C	65.0	MPa	
Tensile Strain			ISO 527-2/50

Yield, 23°C	6.0	%	
Break, 23°C	120	%	
Nominal Tensile Strain at Break (23°C)	> 50	%	ISO 527-2/50
Tensile Creep Modulus			ISO 899-1
1 hr	2200	MPa	
1000 hr	1900	MPa	
Flexural Modulus ⁴ (23°C)	2400	MPa	ISO 178
Flexural Stress ⁵			ISO 178
3.5% Strain, 23°C	73.0	MPa	
23°C	96.0	MPa	
Flexural Strain at Flexural Strength (23°C) ⁶	7.0	%	ISO 178
Application of Flame from Small Burner - Method K and F (2.00 mm)	K1, F1		DIN 53438-1, -3
Burning Rate - US-FMVSS (> 1.00 mm)	passed		ISO 3795
Flash Ignition Temperature	460	°C	ASTM D1929
Needle Flame Test			IEC 60695-11-5
Method F : 1.50 mm	2.0	min	
Method F : 2.00 mm	2.0	min	
Method F : 3.00 mm	2.0	min	
Method K : 1.50 mm	2.0	min	
Method K : 2.00 mm	2.0	min	
Method K : 3.00 mm	2.0	min	
Self Ignition Temperature	530	°C	ASTM D1929
Electrolytical Corrosion (23°C)	A1		IEC 60426
ISO Shortname	ISO 7391-PC,MFR,(..)-18-9		
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ⁷			ISO 7391
-30°C, Complete Break	12	kJ/m ²	
23°C, Partial Break	65	kJ/m ²	
Charpy Unnotched Impact Strength			ISO 179/1eU
-60°C	No Break		
-30°C	No Break		
23°C	No Break		
Notched Izod Impact Strength ⁸			ISO 7391
-30°C, Complete Break	11	kJ/m ²	
23°C, Partial Break	15	kJ/m ²	
Multi-Axial Instrumented Impact Energy			ISO 6603-2
-30°C	55.0	J	
23°C	50.0	J	
Multi-Axial Instrumented Impact Peak Force			ISO 6603-2
-30°C	5900	N	
23°C	5000	N	

Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, Unannealed	137	°C	ISO 75-2/B
1.8 MPa, Unannealed	124	°C	ISO 75-2/A
Glass Transition Temperature ⁹	144	°C	ISO 11357-2
Vicat Softening Temperature			
--	145	°C	ISO 306/B50
--	146	°C	ISO 306/B120
Ball Pressure Test (136°C)	Pass		IEC 60695-10-2
CLTE			ISO 11359-2
Flow : 23 to 55°C	6.5E-5	cm/cm/°C	
Transverse : 23 to 55°C	6.5E-5	cm/cm/°C	
Thermal Conductivity ¹⁰ (23°C)	0.20	W/m/K	ISO 8302
RTI Elec (1.50 mm)	125	°C	UL 746
RTI Imp (1.50 mm)	115	°C	UL 746
RTI Str (1.50 mm)	125	°C	UL 746
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+16	ohms	IEC 60093
Volume Resistivity (23°C)	1.0E+16	ohms·cm	IEC 60093
Electric Strength (23°C, 1.00 mm)	34	kV/mm	IEC 60243-1
Relative Permittivity			IEC 60250
23°C, 100 Hz	3.10		
23°C, 1 MHz	3.00		
Dissipation Factor			IEC 60250
23°C, 100 Hz	8.0E-4		
23°C, 1 MHz	9.0E-3		
Comparative Tracking Index			IEC 60112
Solution A	225	V	
Solution B	125	V	
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.50 mm)	V-0		UL 94
Glow Wire Flammability Index			IEC 60695-2-12
0.750 mm	960	°C	
1.50 mm	960	°C	
3.00 mm	960	°C	
Glow Wire Ignition Temperature			IEC 60695-2-13
0.750 mm	875	°C	
1.50 mm	900	°C	
3.00 mm	900	°C	
Oxygen Index ¹¹	36	%	ISO 4589-2
NOTE			
1.	Pellets		

2.	60x60x2 mm, 500 bar
3.	60x60x2 mm, 500 bar
4.	2.0 mm/min
5.	2.0 mm/min
6.	2 mm/min
7.	Based on ISO 179-1eA, 3 mm
8.	Based on ISO 180-A, 3 mm
9.	10°C/min
10.	Cross-flow
11.	Procedure A

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