

Makrolon 6485

Flame retardant grades / Medium viscosity

Global grade; MFR 11 g/10 min; Flame retardant; UL 94 V-0/1.5 mm and 5VA/3.0 mm; Medium viscosity; Easy release; Injection molding; Available in opaque colors only

ISO Shortname

ISO 7391-PC,MFR,(,)-09-9

Property	Test Condition	Unit	Standard	Value
Rheological properties				
Melt flow rate	300 °C / 1.2 kg	g/(10 min)	ASTM D 1238	11
Mold shrinkage, flow/cross to flow		in/in	ASTM D 955	0.006-0.008
Mechanical properties (23 °C/50 % r.h.)				
Tensile modulus	1 mm/min	lb/in ²	ASTM D 638	350000
Tensile stress at yield	-	lb/in ²	ASTM D 638	9400
Tensile elongation at yield	-	%	ASTM D 638	6.0
Tensile elongation at break	-	%	ASTM D 638	95
Tensile stress at break	-	lb/in ²	ASTM D 638	8700
Izod notched impact strength	73 °F, 0.125 in	ft·lb/in	ASTM D 256	2.0
Flexural modulus	-	lb/in ²	ASTM D 790	340000
Flexural stress at 5 % strain		lb/in ²	ASTM D 790	13200
Rockwell hardness		M Scale	ASTM D 785	70
Thermal properties				
Deflection temperature under load, Unannealed	264 psi; 0.250 in	°F	ASTM D 648	262
Deflection temperature under load, Unannealed	66 psi; 0.250 in	°F	ASTM D 648	277
Vicat softening temperature	50 N, 50 °C/h	°F	ASTM D 1525	291
Coefficient of linear thermal expansion, flow/cross-flow		in/in/°F	ASTM D 696	3.34E-05
UL94 Flame Class	Thickness tested: 1.5 mm	Class	UL 94	V-0
UL94 Flame Class	Thickness tested: 3.0 mm	Class	UL 94	V-0/5VA
UL94 Flame Class	Thickness tested: 6.0 mm	Class	UL 94	V-0/5VA
Oxygen index		%	ASTM D 2863	37
Thermal conductivity		Btu·in/(h·ft ² ·°F)	ASTM C 177	1.39
Specific heat		Btu/(lb·°F)	ASTM D 2766	0.28
Relative temperature index, mechanical with impact	Thickness tested: 1.5 mm	°C	UL 746 B	115
Relative temperature index, mechanical without impact	Thickness tested: 1.5 mm	°C	UL 746 B	125
Relative temperature index, electrical	Thickness tested: 1.5 mm	°C	UL 746 B	125
Electrical properties (23 °C/50 % r.h.)				
Dissipation factor, Tinfoil electrodes	60 Hz	-	ASTM D 150	0.0009
Dissipation factor, Tinfoil electrodes	1 MHz	-	ASTM D 150	0.01
Dielectric constant, Tinfoil electrodes	60 Hz	-	ASTM D 150	3.0
Dielectric constant, Tinfoil electrodes	1 MHz	-	ASTM D 150	3.0
Volume resistivity, Tinfoil electrodes		Ohm·m	ASTM D 257	1.0 E+14
Surface resistivity		Ohm	ASTM D 257	1.0 E+16
Dielectric strength	Short time under oil at 73 °F; 0.162 in	V/mil	ASTM D 149	810
Other properties (23 °C)				
Water absorption	73 °F; immersion to saturation	%	ASTM D 570	0.3
Water absorption	73 °F; immersion 24 h	%	ASTM D 570	0.12
Density		lb/in ³	ASTM D 792	0.043
Specific volume		in ³ /lb	ASTM D 792	23.1
Specific gravity		-	ASTM D 792	1.2