

Makrolon® LED2247

/ MVR (300 °C/1.2 kg) 35 cm³/10 min; low viscosity; high optical transmittance; UV stabilized; easy release; LED Lighting, optics and lenses; injection molding - melt temperature 280 - 320 °C

ISO Shortname

PC

Property	Test Condition	Unit	Standard	typical Value
Rheological properties				
C Melt volume-flow rate	300 °C/ 1.2 kg	cm³/10 min	ISO 1133	34
C Molding shrinkage, parallel	60x60x2 mm/ 500 bar	%	ISO 294-4	0.65
C Molding shrinkage, normal	60x60x2 mm/ 500 bar	%	ISO 294-4	0.7
Molding shrinkage, parallel/normal	Value range based on general practical experience	%	b.o. ISO 2577	0.5 - 0.7
Mechanical properties (23 °C/50 % r. h.)				
C Tensile modulus	1 mm/min	MPa	ISO 527-1,-2	2350
C Yield stress	50 mm/min	MPa	ISO 527-1,-2	63
C Yield strain	50 mm/min	%	ISO 527-1,-2	6.0
C Nominal strain at break	50 mm/min	%	ISO 527-1,-2	> 50
Stress at break	50 mm/min	MPa	ISO 527-1,-2	60
Strain at break	50 mm/min	%	b.o. ISO 527-1,-2	120
Flexural modulus	2 mm/min	MPa	ISO 178	2350
Flexural strength	2 mm/min	MPa	ISO 178	97
Flexural strain at flexural strength	2 mm/min	%	ISO 178	7.1
Flexural stress at 3.5 % strain	2 mm/min	MPa	ISO 178	73
C Charpy impact strength	23 °C	kJ/m²	ISO 179-1eU	N
C Charpy impact strength	-30 °C	kJ/m²	ISO 179-1eU	N
Charpy impact strength	-60 °C	kJ/m²	ISO 179-1eU	N
Charpy notched impact strength	23 °C/ 3 mm	kJ/m²	ISO 7391/b.o. ISO 179-1eA	55P(C)
Charpy notched impact strength	-30 °C/ 3 mm	kJ/m²	ISO 7391/b.o. ISO 179-1eA	12C
Izod notched impact strength	23 °C/ 3.2 mm	kJ/m²	b.o. ISO 180-A	65P(C)
Izod notched impact strength	-30 °C/ 3.2 mm	kJ/m²	b.o. ISO 180-A	12C
C Puncture maximum force	23 °C	N	ISO 6603-2	4900
C Puncture maximum force	-30 °C	N	ISO 6603-2	5900
C Puncture energy	23 °C	J	ISO 6603-2	55
C Puncture energy	-30 °C	J	ISO 6603-2	60
Ball indentation hardness		N/mm²	ISO 2039-1	115
Thermal properties				
C Glass transition temperature	10 °C/min	°C	ISO 11357-1,-2	144
C Temperature of deflection under load	1.80 MPa	°C	ISO 75-1,-2	123
C Temperature of deflection under load	0.45 MPa	°C	ISO 75-1,-2	136
C Vicat softening temperature	50 N; 50 °C/h	°C	ISO 306	143
Vicat softening temperature	50 N; 120 °C/h	°C	ISO 306	145
C Coefficient of linear thermal expansion, parallel	23 to 55 °C	10⁻⁴/K	ISO 11359-1,-2	0.65
C Coefficient of linear thermal expansion, transverse	23 to 55 °C	10⁻⁴/K	ISO 11359-1,-2	0.65
Thermal conductivity, cross-flow	23 °C; 50 % r. h.	W/(m·K)	ISO 8302	0.20

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Electrical properties (23 °C/50 % r. h.)				
C Relative permittivity	100 Hz	-	IEC 60250	3.1
C Relative permittivity	1 MHz	-	IEC 60250	3.0
C Dissipation factor	100 Hz	10 ⁻⁴	IEC 60250	5
C Dissipation factor	1 MHz	10 ⁻⁴	IEC 60250	90
C Volume resistivity		Ohm·m	IEC 60093	1E14
C Surface resistivity		Ohm	IEC 60093	1E16
C Electrical strength	1 mm	kV/mm	IEC 60243-1	34
C Comparative tracking index CTI	Solution A	Rating	IEC 60112	250
C Comparative tracking index CTI M	Solution B	Rating	IEC 60112	125M
Other properties (23 °C)				
C Water absorption (saturation value)	Water at 23 °C	%	ISO 62	0.30
C Water absorption (equilibrium value)	23 °C; 50 % r. h.	%	ISO 62	0.12
C Density		kg/m³	ISO 1183-1	1190
Bulk density		kg/m³	ISO 60	660
Material specific properties				
Refractive index	Procedure A	-	ISO 489	1.584
Haze for transparent materials	3 mm	%	ISO 14782	< 0.5
Luminous transmittance (clear transparent materials)	1 mm	%	ISO 13468-2	90
C Luminous transmittance (clear transparent materials)	2 mm	%	ISO 13468-2	90
Luminous transmittance (clear transparent materials)	3 mm	%	ISO 13468-2	89
Luminous transmittance (clear transparent materials)	4 mm	%	ISO 13468-2	89
Processing conditions for test specimens				
C Injection molding-Melt temperature		°C	ISO 294	280
C Injection molding-Mold temperature		°C	ISO 294	80
C Injection molding-Injection velocity		mm/s	ISO 294	200
Recommended Processing and Drying Conditions				
Melt Temperatures		°C	-	250-300
Standard Melt Temperature		°C	-	270
Barrel Temperatures - Rear		°C	-	230-240
Barrel Temperatures - Middle		°C	-	250-260
Barrel Temperatures - Front		°C	-	260-270
Barrel Temperatures - Nozzle		°C	-	260-270
Mold Temperatures		°C	-	80 - 120
Hold Pressure (% of injection pressure)		%	-	50 - 75
Plastic Back Pressure (specific)		bar	-	50 - 150
Peripheral Screw Speed		m/s	-	0.05 - 0.2
Shot-to-Cylinder Size		%	-	30 - 70
Dry Air Drying Temperature		°C	-	120
Dry Air Drying Time		h	-	2-3
Moisture Content max. (%)		%	-	<= 0,02
Vent Depth		mm	-	0.025 - 0.075

C These property characteristics are taken from the CAMPUS plastics data bank and are based on the international catalogue of basic data for plastics according to ISO 10350.

Impact properties: N = non-break, P = partial break, C = complete break

