

Makrolon® SF810

Grades / Structural foam

MVR (300 °C/1.2 kg) 6.0 cm³/10 min; structural foam; glass fiber reinforced; flame retardant; easy release; injection molding; in combination with an appropriate blowing agent for the production of structural foam moldings

ISO Shortname

Property	Test Condition	Unit	Standard	typical Value
Rheological properties				
Melt volume-flow rate	300 °C/1.2 kg	cm³/10 min	ISO 1133	6
C Molding shrinkage, parallel	60x60x2 mm	%	ISO 294-4	0.60
C Molding shrinkage, normal	60x60x2 mm	%	ISO 294-4	0.45
Mechanical properties (23 °C/50 % r. h.)				
C Tensile modulus	1 mm/min	MPa	ISO 527-1,-2	3800
C Yield stress	50 mm/min	MPa	ISO 527-1,-2	64
C Yield strain	50 mm/min	%	ISO 527-1,-2	4
C Stress at break	5 mm/min	MPa	ISO 527-1,-2	45
C Strain at break	5 mm/min	%	ISO 527-1,-2	15
Flexural modulus	2 mm/min	MPa	ISO 178	3600
Flexural strength	2 mm/min	MPa	ISO 178	105
Flexural strain at flexural strength	2 mm/min	%	ISO 178	5.8
Thermal properties				
C Temperature of deflection under load	1.80 MPa	°C	ISO 75-1,-2	135
C Temperature of deflection under load	0.45 MPa	°C	ISO 75-1,-2	140
C Vicat softening temperature	50 N; 50 °C/h	°C	ISO 306	145
C Coefficient of linear thermal expansion, parallel	23 to 55 °C	10 ⁻⁴ /K	ISO 11359-1,-2	0.4
C Coefficient of linear thermal expansion, transverse	23 to 55 °C	10 ⁻⁴ /K	ISO 11359-1,-2	0.65
C Oxygen index	Method A	%	ISO 4589-2	35
Electrical properties (23 °C/50 % r. h.)				
C Relative permittivity	100 Hz	-	IEC 60250	3.2
C Relative permittivity	1 MHz	-	IEC 60250	3.2
C Electrical strength	1 mm	kV/mm	IEC 60243-1	36
C Comparative tracking index CTI	Solution A	Rating	IEC 60112	175
Volume resistivity		Ohm·m	b.o. IEC 60093	1.0E+14
Surface resistivity		Ohm	b.o. IEC 60093	1.0E+16
Other properties (23 °C)				
C Water absorption (saturation value)	Water at 23 °C	%	ISO 62	0.26
C Water absorption (equilibrium value)	23 °C; 50 % r. h.	%	ISO 62	0.10
C Density		kg/m³	ISO 1183-1	1270
Glass fiber content	Method A	%	b.o. ISO 3451-1	10
Processing conditions for test specimens				
C Injection molding-Melt temperature		°C	ISO 294	300
C Injection molding-Mold temperature		°C	ISO 294	110
C Injection molding-Injection velocity		mm/s	ISO 294	200



Makrolon® SF810

Property	Test Condition	Unit	Standard	typical Value
Recommended Processing and Drying Conditions				
Melt Temperatures		°C	-	280 - 320
Standard Melt Temperature		°C	-	300
Barrel Temperatures - Rear		°C	-	250 - 260
Barrel Temperatures - Middle		°C	-	270 - 280
Barrel Temperatures - Front		°C	-	280 - 290
Barrel Temperatures - Nozzle		°C	-	290 - 300
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