

Makrolon® 1804

PC FR

Covestro Deutschland AG

- MVR (300 °C/1.2 kg) 6.0 cm³/10 min
- Extrusion
- flame retardant
- UL 94V-2/1.5 mm and 3.0 mm
- high viscosity
- UV stabilized
- optimized for low plate-out
- solid sheet

Rheological properties	Value	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	6	cm³/10min	ISO 1133
Temperature	300	°C	-
Load	1.2	kg	-
Molding shrinkage, parallel	0.7	%	ISO 294-4, 2577
Molding shrinkage, normal	0.8	%	ISO 294-4, 2577

Mechanical Properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	2400	MPa	ISO 527
Yield stress	65	MPa	ISO 527
Yield strain	6.2	%	ISO 527
Nominal strain at break	>50	%	ISO 527
Tensile Creep Modulus, 1h	2200	MPa	ISO 899-1
Tensile Creep Modulus, 1000h	1900	MPa	ISO 899-1
Impact Strength (Charpy), +23°C	no break	kJ/m²	ISO 179/1eU
Impact Strength (Charpy), -30°C	no break	kJ/m²	ISO 179/1eU
Puncture - maximum force, +23°C	5600	N	ISO 6603-2
Puncture - maximum force, -30°C	6500	N	ISO 6603-2
Puncture energy, +23°C	60	J	ISO 6603-2
Puncture energy, -30°C	70	J	ISO 6603-2

Thermal Properties	Value	Unit	Test Standard
ISO Data			
Glass Transition Temperature (10°C/min)	148	°C	ISO 11357-1/-2
Temp. of deflection under load (1.80 MPa)	127	°C	ISO 75-1/-2
Temp. of deflection under load (0.45 MPa)	140	°C	ISO 75-1/-2
Vicat softening temperature, 50°C/h 50N	147	°C	ISO 306
Coeff. of Linear Therm. Expansion, parallel	65	E-6/K	ISO 11359-1/-2
Coeff. of Linear Therm. Expansion, normal	65	E-6/K	ISO 11359-1/-2
Burning Behav. at 1.5 mm Nom. Thickn.	V-2	class	UL 94
Thickness tested	1.5	mm	-
Burning Behav. at thickness h	V-0	class	UL 94
Thickness tested	6.0	mm	-
Oxygen index	31	%	ISO 4589-1/-2

Electrical Properties	Value	Unit	Test Standard
ISO Data			
Relative permittivity, 100Hz	3.1	-	IEC 62631-2-1
Relative permittivity, 1MHz	3	-	IEC 62631-2-1
Dissipation Factor, 100Hz	8	E-4	IEC 62631-2-1
Dissipation Factor, 1MHz	95	E-4	IEC 62631-2-1
Volume Resistivity	>1E13	Ohm*m	IEC 62631-3-1
Surface Resistivity	>1E15	Ohm	IEC 62631-3-2
Electric Strength	34	kV/mm	IEC 60243-1
Comparative tracking index	225	-	IEC 60112

Other Properties	Value	Unit	Test Standard
ISO Data			
Water Absorption	0.3	%	Sim. to ISO 62
Humidity absorption	0.12	%	Sim. to ISO 62
Density	1200	kg/m³	ISO 1183

Material Specific Properties	Value	Unit	Test Standard
ISO Data			
Luminous transmittance	89	%	ISO 13468-1, -2

Test specimen production	Value	Unit	Test Standard
ISO Data			
Injection Molding, melt temperature	300	°C	ISO 294
Injection Molding, mold temperature	80	°C	ISO 294
Injection Molding, injection velocity	200	mm/s	ISO 294

Characteristics

Processing

Profile Extrusion, Sheet Extrusion, Other Extrusion

Delivery form

Pellets

Special Characteristics

Flame retardant, Light stabilized or stable to light, UV stabilized, Transparent

Disclaimer

Liability Exclusion

These guide values are measured and provided by the product manufacturer and have been determined on standardised test specimens and can be affected by pigmentation, mould design and processing conditions. M-Base has taken the guide values from the producer's original Technical Data Sheet. **ALBIS AND M-BASE ARE THEREFORE NOT RESPONSIBLE FOR THE ACCURACY OF THE GUIDE VALUES AND CANNOT GIVE ANY WARRANTY WITH REGARD TO THEIR CORRECTNESS.**

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