Makrolon® M404 LF

PC

Covestro Deutschland AG

- polycarbonate
- MVR (300 °C/1.2 kg) 19 cm³/10 min
- low viscosity
- improved friction characteristics
- biocompatible according to many ISO 10993-1 test requirements
- medical devices

Rheological properties	Value	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	19	cm³/10min	ISO 1133
Temperature	300	°C	-
Load	1.2	kg	-
Molding shrinkage, parallel	0.7	%	ISO 294-4, 2577
Molding shrinkage, normal	0.7	%	ISO 294-4, 2577

Mechanical Properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	2100	MPa	ISO 527
Notched Impact Strength (Izod), 23°C	60	kJ/m²	ISO 180/1A

Other Properties	Value	Unit	Test Standard
ISO Data			
Density	1200	kg/m³	ISO 1183

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	120	°C	-
Pre-drying - Time	4	h	-
Processing humidity	≤0.02	%	-
Melt temperature	280 - 320	°C	-
Mold temperature	70 - 110	°C	-
Zone 1	250 - 270	°C	-
Zone 2	270 - 290	°C	-
Zone 3	285 - 305	°C	-
Nozzle temperature	270 - 305	°C	-
Back pressure	10 - 20	MPa	-

Characteristics

Processing
Injection Molding

Certifications
Medical, Biocompatibility ISO 10993

Special Characteristics
Opaque

Applications
Medical

Features
Tribologic Grade

Disclaimer

- risk class III applications according to EU directive 93/42/EEC
- any bodily implant application for greater than 30 days
- any critical component in any medical device that supports or sustains human life.

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