Makrolon® 1804

PC FR — Covestro Deutschland AG

Product Texts

- 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

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

[C]: CAMPUS

Mechanical properties	Value	Unit	Test Standard
ISO Data			
[C] Tensile Modulus	**2400**	MPa	ISO 527
[C] Yield stress	**65**	MPa	ISO 527
[C] Yield strain	**6.2**	%	ISO 527
[C] Nominal strain at break	**>50**	%	ISO 527
[C] Tensile creep modulus, 1h	**2200**	MPa	ISO 899-1
[C] Tensile creep modulus, 1000h	**1900**	MPa	ISO 899-1
[C] Charpy impact strength, +23°C	**N**	kJ/m²	ISO 179/1eU
[C] Charpy impact strength, -30°C	**N**	kJ/m²	ISO 179/1eU
[C] Puncture - maximum force, +23°C	**5600**	N	ISO 6603-2
[C] Puncture - maximum force, -30°C	**6500**	N	ISO 6603-2
[C] Puncture energy, +23°C	**60**	J	ISO 6603-2
[C] Puncture energy, -30°C	**70**	J	ISO 6603-2

[C]: CAMPUS

Thermal properties	Value	Unit	Test Standard
ISO Data			
[C] Glass transition temperature, 10°C/min	**148**	°C	ISO 11357-1/-2
[C] Temp. of deflection under load, 1.80 MPa	**127**	°C	ISO 75-1/-2
[C] Temp. of deflection under load, 0.45 MPa	**140**	°C	ISO 75-1/-2
[C] Vicat softening temperature, B	**147**	°C	ISO 306
[C] Coeff. of linear therm. expansion, parallel	**65**	E-6/K	ISO 11359-1/-2
[C] Coeff. of linear therm. expansion, normal	**65**	E-6/K	ISO 11359-1/-2
[C] Burning Behav. at 1.5 mm nom. thickn.	**V-2**	class	IEC 60695-11-10
Thickness tested	**1.5**	mm	-
[C] Burning Behav. at thickness h	**V-0**	class	IEC 60695-11-10
Thickness tested	**6.0**	mm	-
[C] Oxygen index	**31**	%	ISO 4589-1/-2

[C]: CAMPUS

Electrical properties	Value	Unit	Test Standard
ISO Data			
[C] Relative permittivity, 100Hz	**3.1**	-	IEC 62631-2-1
[C] Relative permittivity, 1MHz	**3**	-	IEC 62631-2-1
[C] Dissipation factor, 100Hz	**8**	E-4	IEC 62631-2-1
[C] Dissipation factor, 1MHz	**95**	E-4	IEC 62631-2-1
[C] Volume resistivity	**>1E13**	Ohm*m	IEC 62631-3-1
[C] Surface resistivity	**>1E15**	Ohm	IEC 62631-3-2
[C] Electric strength	**34**	kV/mm	IEC 60243-1

[C] Comparative tracking index	**225**	-	IEC 60112

[C]: CAMPUS

Optical properties	Value	Unit	Test Standard
ISO Data			
[C] Luminous transmittance	**89**	%	ISO 13468-1, -2

[C]: CAMPUS

Other properties	Value	Unit	Test Standard
[C] Water absorption	**0.3**	%	Sim. to ISO 62
[C] Humidity absorption	**0.12**	%	Sim. to ISO 62
[C] Density	**1200**	kg/m³	ISO 1183

[C]: CAMPUS

Test specimen production	Value	Unit	Test Standard
ISO Data			
[C] 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

[C]: CAMPUS

Characteristics

Processing
Profile Extrusion, Sheet Extrusion, Other Extrusion

Delivery form
Pellets

Special Characteristics
Flame retardant, Light stabilized or stable to light, U.V. stabilized or stable to weather, Transparent

Regional Availability
North America, Europe, Asia Pacific, South and Central America, Near East/Africa