

Makropol® PC B3 LF FD CRLA010 PC321

Polycarbonate

Petropol Industry and Trade of Polymers LTDA

Message:

Polycarbonate transparent, high viscosity, FDA - food contact quality, good hydrolysis resistance. Indicated for injection molding and extrusion.

General Information			
Features	Food Contact Acceptable		
	High Viscosity		
	Hydrolysis Resistant		
Agency Ratings	FDA Food Contact, Unspecified Rating		
Appearance	Clear/Transparent		
Processing Method	Extrusion		
	Injection Molding		
Resin ID (ISO 1043)	>PC<		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.20	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	6.5	g/10 min	ASTM D1238
Molding Shrinkage - Across Flow	0.75	%	ASTM D955
Water Absorption			ASTM D570
Saturation, 23°C	0.30	%	
Equilibrium	0.12	%	
Hardness	Nominal Value	Unit	Test Method
Ball Indentation Hardness	111	MPa	ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ¹	2350	MPa	ASTM D638
Tensile Strength (Break)	75.0	MPa	ASTM D638
Tensile Elongation (Break)	130	%	ASTM D638
Flexural Modulus ²	2350	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179
-30°C	18	kJ/m ²	
23°C	80	kJ/m ²	
Notched Izod Impact (Area)			ASTM D256
-30°C	16.0	kJ/m ²	
23°C	90.0	kJ/m ²	
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648

0.45 MPa, Unannealed	141	°C	
1.8 MPa, Unannealed	129	°C	
Vicat Softening Temperature	150	°C	ASTM D1525 ³
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+16	ohms	ASTM D257
Volume Resistivity	1.0E+14	ohms·cm	ASTM D257
Electric Strength	34	kV/mm	IEC 60243-1
Dissipation Factor (1 MHz)	9.5E-3		ASTM D150
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.60 mm)	V-2		UL 94
Glow Wire Flammability Index (3.00 mm)	930	°C	IEC 60695-2-12
Injection	Nominal Value	Unit	
Drying Temperature	120	°C	
Drying Time	4.0	hr	
Suggested Max Moisture	0.020	%	
Processing (Melt) Temp	265 to 290	°C	
Mold Temperature	70.0 to 110	°C	
NOTE			
1.	1.0 mm/min		
2.	2.0 mm/min		
3.	Loading 2 (50 N)		

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