

Makrolon® 1954

Polycarbonate

Covestro - Polycarbonates

Message:

MVR (300 °C/1.2 kg) 18 cm³/10 min; low viscosity; UV stabilized; improved friction characteristics; injection molding - melt temperature 280 - 320 °C; available in opaque colors only; housings- and operating parts; sliding elements

General Information			
Additive	PTFE Lubricant (5%)		
	UV Stabilizer		
Features	Low Viscosity		
Uses	Housings		
RoHS Compliance	RoHS Compliant		
Appearance	Colors Available		
	Opaque		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density (23°C)	1.22	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	19	g/10 min	ISO 1133
Melt Volume-Flow Rate (MVR) (300°C/1.2 kg)	18.0	cm ³ /10min	ISO 1133
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	2300	MPa	ISO 527-2/1
Tensile Stress			ISO 527-2/50
Yield, 23°C	63.0	MPa	
Break, 23°C	60.0	MPa	
Tensile Strain			ISO 527-2/50
Yield, 23°C	5.6	%	
Break, 23°C	100	%	
Flexural Modulus ¹ (23°C)	2300	MPa	ISO 178
Flexural Stress ²			ISO 178
3.5% Strain, 23°C	73.0	MPa	
23°C	94.0	MPa	
Flexural Strain at Flexural Strength ³ (23°C)	6.6	%	ISO 178
ISO Shortname	ISO 7391-PC,MLS,(,,)-18-9		
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ⁴ (23°C, Complete Break)	12	kJ/m ²	ISO 7391
Charpy Unnotched Impact Strength			ISO 179/1eU

-30°C	No Break		
23°C	No Break		
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, Unannealed	136	°C	ISO 75-2/B
1.8 MPa, Unannealed	124	°C	ISO 75-2/A
Vicat Softening Temperature	143	°C	ISO 306/B50
Flammability	Nominal Value		Test Method
Flame Rating (1.50 mm)	HB		UL 94
NOTE			
1.	2.0 mm/min		
2.	2.0 mm/min		
3.	2 mm/min		
4.	Based on ISO 179-1eA, 3 mm		

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