

Makrolon® EM9417

Polycarbonate

Covestro - Polycarbonates

Message:

MVR (300 °C/1.2 kg) 6.0 cm³/10 min; 10 % glass fiber reinforced; flame retardant; high viscosity; UV stabilized; easy release; injection molding - melt temperature 310 - 330 °C; available in opaque colors only

General Information			
Filler / Reinforcement	Glass Fiber,10% Filler by Weight		
Additive	Flame Retardant		
	UV Stabilizer		
Features	Flame Retardant		
	Good Mold Release		
	High Viscosity		
RoHS Compliance	RoHS Compliant		
Appearance	Colors Available		
	Opaque		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density (23°C)	1.27	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (300°C/1.2 kg)	6.00	cm ³ /10min	ISO 1133
Molding Shrinkage			
Across Flow	0.40 to 0.60	%	ISO 2577
Flow	0.40 to 0.60	%	ISO 2577
Across Flow : 2.00 mm ¹	0.50	%	ISO 294-4
Flow : 2.00 mm ²	0.60	%	ISO 294-4
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	3700	MPa	ISO 527-2/1
Tensile Stress			ISO 527-2/5
Yield, 23°C	60.0	MPa	
Break, 23°C	45.0	MPa	
Tensile Strain			ISO 527-2/5
Yield, 23°C	5.0	%	
Break, 23°C	15	%	
Impact	Nominal Value	Unit	Test Method
Charpy Unnotched Impact Strength (23°C, Complete Break)	75	kJ/m ²	ISO 179/1eU

Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, Unannealed	141	°C	ISO 75-2/B
1.8 MPa, Unannealed	135	°C	ISO 75-2/A
Vicat Softening Temperature			
--	143	°C	ISO 306/B50
--	144	°C	ISO 306/B120
CLTE			
Flow : 23 to 55°C	4.0E-5	cm/cm/°C	
Transverse : 23 to 55°C	6.0E-5	cm/cm/°C	
RTI Elec (1.50 mm)	125	°C	UL 746
RTI Imp (1.50 mm)	115	°C	UL 746
RTI Str (1.50 mm)	125	°C	UL 746
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+16	ohms	IEC 60093
Volume Resistivity (23°C)	1.0E+16	ohms·cm	IEC 60093
Comparative Tracking Index (Solution A)	175	V	IEC 60112
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.50 mm)	V-0		UL 94
Glow Wire Flammability Index (1.50 mm)	960	°C	IEC 60695-2-12
Oxygen Index ³	35	%	ISO 4589-2
NOTE			
1.	60x60x2 mm, 500 bar		
2.	60x60x2 mm, 500 bar		
3.	Procedure A		

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