

Makrolon® 1260

Polycarbonate

Covestro - Polycarbonates

Message:

MVR (300 °C/1.2 kg) 34 cm³/10 min; impact modified; low viscosity; easy release; injection molding - melt temperature 280 - 320 °C; available in light colors only

General Information	
UL YellowCard	E41613-233126
Additive	Impact Modifier
Features	Good Mold Release
	Impact Modified
	Low Viscosity
RoHS Compliance	RoHS Compliant
Appearance	Colors Available
Processing Method	Injection Molding
Multi-Point Data	Specific Volume vs Temperature (ISO 11403-2)
	Viscosity vs. Shear Rate (ISO 11403-2)

Physical	Nominal Value	Unit	Test Method
Density (23°C)	1.20	g/cm ³	ISO 1183
Apparent Density ¹	0.64	g/cm ³	ISO 60
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	36	g/10 min	ISO 1133
Melt Volume-Flow Rate (MVR) (300°C/1.2 kg)	33.0	cm ³ /10min	ISO 1133
Molding Shrinkage			
Across Flow	0.50 to 0.70	%	ISO 2577
Flow	0.50 to 0.70	%	ISO 2577
Across Flow : 2.00 mm ²	0.70	%	ISO 294-4
Flow : 2.00 mm ³	0.65	%	ISO 294-4
Water Absorption			
Saturation, 23°C	0.30	%	ISO 62
Equilibrium, 23°C, 50% RH	0.12	%	
Hardness	Nominal Value	Unit	Test Method
Ball Indentation Hardness	114	MPa	ISO 2039-1
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	2350	MPa	ISO 527-2/1
Tensile Stress			ISO 527-2/50
Yield, 23°C	63.0	MPa	
Break, 23°C	55.0	MPa	

Tensile Strain			ISO 527-2/50
Yield, 23°C	5.8	%	
Break, 23°C	100	%	
Nominal Tensile Strain at Break (23°C)	> 50	%	ISO 527-2/50
Flexural Modulus ⁴ (23°C)	2350	MPa	ISO 178
Flexural Stress ⁵			ISO 178
3.5% Strain, 23°C	72.0	MPa	
23°C	93.0	MPa	
Flexural Strain at Flexural Strength (23°C) ⁶	6.8	%	ISO 178
Burning Rate - US-FMVSS (> 1.00 mm)	passed		ISO 3795
Flash Ignition Temperature	460	°C	ASTM D1929
Needle Flame Test			IEC 60695-11-5
Method F : 1.50 mm	1.0	min	
Method F : 2.00 mm	2.0	min	
Method F : 3.00 mm	2.0	min	
Method K : 1.50 mm	0.1	min	
Method K : 2.00 mm	0.1	min	
Method K : 3.00 mm	0.2	min	
Self Ignition Temperature	540	°C	ASTM D1929
Electrolytical Corrosion (23°C)	A1		IEC 60426
ISO Shortname	ISO 7391-PC,MPR,(,,)-24-9		
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ⁷			ISO 7391
-30°C, Complete Break	14	kJ/m ²	
23°C, Partial Break	55	kJ/m ²	
Charpy Unnotched Impact Strength			ISO 179/1eU
-60°C	No Break		
-30°C	No Break		
23°C	No Break		
Notched Izod Impact Strength ⁸			ISO 7391
-30°C, Complete Break	15	kJ/m ²	
23°C, Partial Break	50	kJ/m ²	
Multi-Axial Instrumented Impact Energy			ISO 6603-2
-30°C	55.0	J	
23°C	50.0	J	
Multi-Axial Instrumented Impact Peak Force			ISO 6603-2
-30°C	5700	N	
23°C	4800	N	
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, Unannealed	135	°C	ISO 75-2/B

1.8 MPa, Unannealed	122	°C	ISO 75-2/A
Glass Transition Temperature ⁹	142	°C	ISO 11357-2
Vicat Softening Temperature			
--	142	°C	ISO 306/B50
--	143	°C	ISO 306/B120
Ball Pressure Test (134°C)	Pass		IEC 60695-10-2
CLTE			ISO 11359-2
Flow : 23 to 55°C	7.0E-5	cm/cm/°C	
Transverse : 23 to 55°C	7.0E-5	cm/cm/°C	
Thermal Conductivity ¹⁰ (23°C)	0.20	W/m/K	ISO 8302
RTI Elec (1.50 mm)	125	°C	UL 746
RTI Imp (1.50 mm)	105	°C	UL 746
RTI Str (1.50 mm)	115	°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
Electric Strength (23°C, 1.00 mm)	34	kV/mm	IEC 60243-1
Relative Permittivity			IEC 60250
23°C, 100 Hz	3.10		
23°C, 1 MHz	3.00		
Dissipation Factor			IEC 60250
23°C, 100 Hz	1.0E-3		
23°C, 1 MHz	0.010		
Comparative Tracking Index			IEC 60112
Solution A	250	V	
Solution B	125	V	
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.750 mm)	V-2		UL 94
Glow Wire Flammability Index			IEC 60695-2-12
0.750 mm	875	°C	
1.50 mm	900	°C	
3.00 mm	960	°C	
Glow Wire Ignition Temperature			IEC 60695-2-13
0.750 mm	875	°C	
1.50 mm	875	°C	
3.00 mm	900	°C	
Oxygen Index ¹¹	30	%	ISO 4589-2
NOTE			
1.	Pellets		
2.	60x60x2 mm, 500 bar		
3.	60x60x2 mm, 500 bar		
4.	2.0 mm/min		

5.	2.0 mm/min
6.	2 mm/min
7.	Based on ISO 179-1eA, 3 mm
8.	Based on ISO 180-A, 3 mm
9.	10°C/min
10.	Cross-flow
11.	Procedure A

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