

Makropol® PC B3 MF FD CLRA010 PC319

Polycarbonate

Petropol Industry and Trade of Polymers LTDA

Message:

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

General Information			
Features	Food Contact Acceptable		
	Hydrolysis Resistant		
	Medium Viscosity		
Agency Ratings	FDA Food Contact, Unspecified Rating		
Processing Method	Injection Molding		
Resin ID (ISO 1043)	>PC<		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.20	g/cm³	ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	10	g/10 min	ASTM D1238
Melt Volume-Flow Rate (MVR) (300°C/1.2 kg)	9.50	cm³/10min	ASTM D1238
Molding Shrinkage - Across Flow	0.60 to 0.80	%	ASTM D955
Water Absorption			ASTM D570
Saturation, 23°C	0.30	%	
Equilibrium, 23°C, 50% RH	0.12	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ¹	2400	MPa	ASTM D638
Tensile Strength ² (Break)	70.0	MPa	ASTM D638
Tensile Elongation (Break)	120	%	ASTM D638
Flexural Modulus ³	2350	MPa	ASTM D790
Flexural Strength ⁴	100	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ASTM D256
-30°C	No Break		
23°C	No Break		
Notched Izod Impact (Area)			ASTM D256
-30°C	12.0	kJ/m²	
23°C	85.0	kJ/m²	
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed	137	°C	
1.8 MPa, Unannealed	125	°C	

Vicat Softening Temperature	144	°C	ASTM D1525
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+16	ohms	ASTM D257
Volume Resistivity	1.0E+16	ohms·cm	ASTM D257
Dielectric Strength	32	kV/mm	ASTM D149
Relative Permittivity	3.00		IEC 60250
Dissipation Factor (1 MHz)	9.0E-3		IEC 60250
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.60 mm)	V-2		UL 94
Glow Wire Ignition Temperature (3.00 mm)	930	°C	IEC 60695-2-13
Injection	Nominal Value	Unit	
Drying Temperature	120	°C	
Drying Time	4.0	hr	
Suggested Max Moisture	0.020	%	
Processing (Melt) Temp	280 to 320	°C	
Mold Temperature	85.0 to 120	°C	
NOTE			
1.	1.0 mm/min		
2.	50 mm/min		
3.	2.0 mm/min		
4.	2.0 mm/min		

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