Makrolon® FR6020 RE

Partially bio-circular grade / Attributed via mass balance (according to ISCC PLUS Standard). For specific content see sustainability declaration.

polycarbonate; medium viscosity; easy release; UV stabilized; flame retardant; non-reinforced; good hydrolysis resistance; impact modified; injection molding; Information technology; electrical/electronic

ISO Shortname

PC-I FR(40)

	Property	Test Condition	Unit	Standard	typical Value
Rheological properties					-
C	Melt volume-flow rate	300 °C/ 1.2 kg	cm³/10 min	ISO 1133	9
	Melt viscosity	1000 s^{-1}/ 300 °C	Pa·s	b.o. ISO 11443-A	260
	Molding shrinkage, parallel/normal	Value range based on general practical experience	%	b.o. ISO 2577	0.6 - 0.8
Mechanical properties (23 °C/50 % r. h.)					
C	Tensile modulus	1 mm/min	MPa	ISO 527-1,-2	2380
C	Yield stress	50 mm/min	MPa	ISO 527-1,-2	58
C	Yield strain	50 mm/min	%	ISO 527-1,-2	6
	Stress at break	50 mm/min	MPa	ISO 527-1,-2	58
	Strain at break	50 mm/min	%	b.o. ISO 527-1,-2	> 100
	Flexural modulus	2 mm/min	MPa	ISO 178	2430
	Flexural strength	2 mm/min	MPa	ISO 178	90
	Flexural strain at flexural strength	2 mm/min	%	ISO 178	6
	Flexural stress at 3.5 % strain	2 mm/min	MPa	ISO 178	74
C	Charpy impact strength	23 °C	kJ/m²	ISO 179/1eU	N
	Charpy notched impact strength	23 °C	kJ/m²	ISO 21305/based on ISO 179/1eA	69P
	Charpy notched impact strength	-20 °C	kJ/m²	ISO 21305/based on ISO 179/1eA	56C
	Charpy notched impact strength	-30 °C	kJ/m²	ISO 21305/based on ISO 179/1eA	33C
	Izod notched impact strength	23 °C	kJ/m²	ISO 21305/based on ISO 180/A	67P
	Izod notched impact strength	-20 °C	kJ/m²	ISO 21305/based on ISO 180/A	46P
	Izod notched impact strength	-30 °C	kJ/m²	ISO 21305/based on ISO 180/A	26C
	Izod impact strength	23 °C	kJ/m²	ISO 180/U	N
	Izod impact strength	-30 °C	kJ/m²	ISO 180/U	N
Thermal properties					
C	Temperature of deflection under load	1.80 MPa	°C	ISO 75-1,-2	114
C	Temperature of deflection under load	0.45 MPa	°C	ISO 75-1,-2	127
C	Vicat softening temperature	50 N; 50 °C/h	°C	ISO 306	134
	Vicat softening temperature	50 N; 120 °C/h	°C	ISO 306	136
C	Coefficient of linear thermal expansion, parallel	23 to 55 °C	10^{-4}/K	ISO 11359-1,-2	0.49
C	Coefficient of linear thermal expansion, normal	23 to 55 °C	10^{-4}/K	ISO 11359-1,-2	0.58
C	Burning behavior UL 94 (1.5 mm)		Class	UL 94	V-0
C	Burning behavior UL 94	2.0 mm	Class	UL 94	V-0
C	Burning behavior UL 94-5V	2.0 mm	Class	UL 94	5VB
	Burning behavior UL 94-5V	3.0 mm	Class	UL 94	5VA
	Relative temperature index (Tensile strength)	1.5 mm	°C	UL 746B	125
	Relative temperature index (Tensile impact strength)	1.5 mm	°C	UL 746B	115
	Relative temperature index (Electric strength)	1.5 mm	°C	UL 746B	125
Other properties (23 °C)					
C	Density		kg/m³	ISO 1183-1	1200

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	Property	Test Condition	Unit	Standard	typical Value
Processing conditions for test specimens					
C	Injection molding - Melt temperature		°C	ISO 294	280-300
C	Injection molding - Mold temperature		°C	ISO 294	80

C These property characteristics are taken from the CAMPUS plastics data bank and are based on the international catalogue of basic data for plastics according to ISO 10350.

Impact properties: N = non-break, P = partial break, C = complete break

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Disclaimer

Disclaimer for Developmental products

This is a trial product. Further information, including amended or supplementary data on hazards associated with its use, may be compiled in the future. For this reason no assurances are given as to type conformity, processability, long-term performance characteristics or other production or application parameters. Therefore, the purchaser/user uses the product entirely at his own risk without having been given any warranty or guarantee and agrees that the supplier shall not be liable for any damage, of whatever nature, arising out of such use. Commercialisation and continued supply of this material are not assured. Its supply may be discontinued at any time.

Typical value

These values are typical values only. Unless explicitly agreed in written form, the do not constitute a binding material specification or warranted values. Values may be affected by the design of the mold/die, the processing conditions and coloring/pigmentation of the product. Unless specified to the contrary, the property values given have been established on standardized test specimens at room temperature.

General

The manner in which you use and the purpose to which you put and utilize our products, technical assistance and information (whether verbal, written or by way of production evaluations), including any suggested formulations and recommendations are beyond our control. Therefore, it is imperative that you test our products, technical assistance, information and recommendations to determine to your own satisfaction whether our products, technical assistance and information are suitable for your intended uses and applications. This application-specific analysis must at least include testing to determine suitability from a technical as well as health, safety, and environmental standpoint. Such testing has not necessarily been done by Covestro. Unless we otherwise agree in writing, all products are sold strictly pursuant to the terms of our standard conditions of sale which are available upon request. All information and technical assistance is given without warranty or guarantee and is subject to change without notice. It is expressly understood and agreed that you assume and hereby expressly release us from all liability, in tort, contract or otherwise, incurred in connection with the use of our products, technical assistance, and information. Any statement or recommendation not contained herein is unauthorized and shall not bind us. Nothing herein shall be construed as a recommendation to use any product in conflict with any claim of any patent relative to any material or its use. No license is implied or in fact granted under the claims of any patent. With respect to health, safety and environment precautions, the relevant Material Safety Data Sheets (MSDS) and product labels must be observed prior to working with our products.

Recommended Processing and Drying Conditions

Barrel temperatures are valid for a standard 3-zone barrel. Temperature set-up for different barrel types may change according to configuration. Values for hold pressure as percentage of injection pressure may vary depending on, amongst others, part geometry, injection molding machine and injection mold. Drying conditions are for dry air dryers only. Drying times and drying temperatures may differ depending on valid dryer type. Further information is provided by your local Covestro support as well as in the following brochures: Injection Molding of High Quality Molded Parts - Drying; Determining the Dryness of Makrolon by TVI Test; The fundamentals of shrinkage in thermoplastics; Shrinkage and deformation of glass fiber reinforced thermoplastics [...]. https://www.plastics.covestro.com/Library/Overview.aspx

Disclaimer shrinkage data

Shrinkage data is provided as a reference only, and is based on sample plaques molded under specific, controlled processing conditions. Shrinkage rates in production parts can vary and are influenced by several variables such as, but not limited to: part design (e.g. part size, thickness and geometry), mold design (e.g. gate type and location, runner design, mold materials, cooling system), molding conditions (e.g. processing temperature, mold temperature, packing time and pressure, injection speed). We suggest materials be evaluated in existing applicable molds to achieve the most accurate shrinkage estimation for your specific application and processing practices. The final choice of shrinkage is the responsibility of the user of the material, and should be made based on your experience and testing results. We shall not be liable for any damage caused by the use of the shrinkage data as provided by us. If you have any questions, pls consult technical representatives from Covestro.

Covestro AG

Kaiser-Wilhelm-Allee 60

51373 Leverkusen

Germany

www.solutions.covestro.com

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