# Makrolon® M204 LF

| | |
|---|---|
| / | MVR (300 °C/1.2 kg) 35 cm³/10 min; low viscosity; improved friction characteristics; biocompatible according to many ISO 10993-1 test requirements; available in opaque colors only; medical devices |
| **ISO Shortname** | PC |

| | Property | Test Condition | Unit | Standard | typical Value |
|---|---|---|---|---|---|
| **Rheological properties** | | | | | |
| | Melt volume-flow rate | 300 °C/ 1.2 kg | cm³/10 min | ISO 1133 | 35 |
| | Molding shrinkage, parallel/normal | Value range based on general practical experience | % | b.o. ISO 2577 | 0.5 - 0.7 |
| **Mechanical properties (23 °C/50 % r. h.)** | | | | | |
| C | Tensile modulus | 1 mm/min | MPa | ISO 527-1,-2 | 2350 |
| C | Yield stress | 50 mm/min | MPa | ISO 527-1,-2 | 62 |
| C | Yield strain | 50 mm/min | % | ISO 527-1,-2 | 5.8 |
| C | Nominal strain at break | 50 mm/min | % | ISO 527-1,-2 | > 50 |
| | Flexural modulus | 2 mm/min | MPa | ISO 178 | 2350 |
| | Flexural strength | 2 mm/min | MPa | ISO 178 | 94 |
| | Izod notched impact strength | 23 °C/ 3 mm | kJ/m² | ISO 21305/based on ISO 180/A | 50 P |
| | Izod notched impact strength | -30 °C/ 3 mm | kJ/m² | ISO 21305/based on ISO 180/A | 12 C |
| | 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 | 121 |
| C | Temperature of deflection under load | 0.45 MPa | °C | ISO 75-1,-2 | 135 |
| | Vicat softening temperature | 50 N; 120 °C/h | °C | ISO 306 | 142 |
| C | Coefficient of linear thermal expansion, parallel | 23 to 55 °C | $10^{-4}$/K | ISO 11359-1,-2 | 0.65 |
| C | Coefficient of linear thermal expansion, normal | 23 to 55 °C | $10^{-4}$/K | ISO 11359-1,-2 | 0.65 |
| C | Burning behavior UL 94 (1.5 mm) | | Class | UL 94 | V-2 (Covestro Test) |
| **Other properties (23 °C)** | | | | | |
| C | Water absorption (saturation value) | Water at 23 °C | % | ISO 62 | 0.33 |
| C | Water absorption (equilibrium value) | 23 °C; 50 % r. h. | % | ISO 62 | 0.11 |
| C | Density | | kg/m³ | ISO 1183-1 | 1190 |
| **Processing conditions for test specimens** | | | | | |
| C | Injection molding - Melt temperature | | °C | ISO 294 | 280 |
| C | Injection molding - Mold temperature | | °C | ISO 294 | 80 |
| C | Injection molding - Injection velocity | | mm/s | ISO 294 | 200 |



2026-02-18 11:00:00 Distributed by Mito polimeri

# Makrolon® M204 LF

| | Property | Test Condition | Unit | Standard | typical Value |
|---|---|---|---|---|---|
| **Recommended processing and drying conditions** | | | | | |
| | Melt temperatures | | °C | - | 280 - 320 |
| | Standard Melt temperature | | °C | - | 300 |
| | Barrel Temperatures - Rear | | °C | - | 250 - 260 |
| | Barrel Temperatures - Middle | | °C | - | 270 - 280 |
| | Barrel Temperatures - Front | | °C | - | 280 - 290 |
| | Barrel Temperatures - Nozzle | | °C | - | 290 - 300 |
| | Mold Temperatures | | °C | - | 80 - 120 |
| | Hold Pressure (% of injection pressure) | | % | - | 50 - 75 |
| | Plastic Back Pressure (specific) | | bar | - | 50 - 150 |
| | Peripheral Screw Speed | | m/s | - | 0.05 - 0.2 |
| | Shot-to-Cylinder Size | | % | - | 30 - 70 |
| | Dry Air Drying Temperature | | °C | - | 120 |
| | Dry Air Drying Time | | h | - | 2 - 3 |
| | Moisture Content max. (%) | | % | - | <=0.02 |
| | Vent Depth | | mm | - | 0.025 - 0.075 |

**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



2026-02-18 11:00:00 Distributed by Mito polimeri

# Makrolon® M204 LF

## Disclaimer

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.

Covestro Medical Grades

For more information on Covestro products in Medical Applications, please request from your sales support contact our Guidance document: GUIDANCE ON USE OF COVESTRO PRODUCTS IN A MEDICAL APPLICATION.

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



2026-02-18 11:00:00 Distributed by Mito polimeri