Makrolon® M404 LF

Preliminary Datasheet /

polycarbonate; MVR (300 °C/1.2 kg) 19 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	19
C	Molding shrinkage, parallel	60x60x2 mm³	%	ISO 294-4	0.7
C	Molding shrinkage, normal	60x60x2 mm³	%	ISO 294-4	0.7
Mechanical properties (23 °C/50 % r. h.)					
C	Tensile modulus	1 mm/min	MPa	ISO 527-1,-2	2100
C	Yield stress	50 mm/min	MPa	ISO 527-1,-2	60
C	Nominal strain at break	50 mm/min	%	ISO 527-1,-2	>50
	Izod notched impact strength	23 °C	kJ/m²	ISO 21305/based on ISO 180/A	60
Thermal properties					
	Vicat softening temperature	50 N; 120 °C/h	°C	ISO 306	144
Other properties (23 °C)					
C	Density		kg/m³	ISO 1183-1	1200
Recommended processing and drying conditions					
	Melt temperatures		°C	-	280 - 320
	Standard Melt temperature		°C	-	300
	Barrel Temperatures - Rear		°C	-	250 - 270
	Barrel Temperatures - Middle		°C	-	270 - 290
	Barrel Temperatures - Front		°C	-	285 - 305
	Barrel Temperatures - Nozzle		°C	-	270 - 305
	Mold Temperatures		°C	-	70 - 110
	Hold Pressure (% of injection pressure)		%	-	50 - 75
	Plastic Back Pressure (specific)		bar	-	100 - 200
	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	-	4
	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

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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.

Information Impact properties

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

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.

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.

Medical Grade with limited bio-compatibility

The biocompatibility testing referenced above cannot assure the biocompatibility of final or intermediate products made from Covestro products or the suitability of such products for their use in a medical application, i.e., the test data cannot be used to conclude that any medical devices manufactured from the Covestro products meet the necessary requirements of ISO Standard 10993-1. It is the sole responsibility of the manufacturer of the final end-use product to conduct all necessary tests (including biocompatibility tests) and inspections and to evaluate the final product under actual end-use requirements. 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.

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