



Makrolon® 3108

Grades / Medical devices

MVR (300 °C/1.2 kg) 6.0 cm³/10 min; medical devices; suitable for ETO and steam sterilization at 121 °C; biocompatible according to many ISO 10993-1 test requirements; high viscosity; injection molding - melt temperature 290 - 330 °C; available in transparent and opaque colors

ISO Shortname

ISO 7391-PC,M,(,,-)09-9

Property	Test Condition	Unit	Standard	typical Value
Rheological properties				
C Melt volume-flow rate	300 °C/ 1.2 kg	cm³/10 min	ISO 1133	6.0
Melt mass-flow rate	300 °C/ 1.2 kg	g/10 min	ISO 1133	6.5
C Molding shrinkage, parallel	60x60x2 mm/ 500 bar	%	ISO 294-4	0.7
C Molding shrinkage, normal	60x60x2 mm/ 500 bar	%	ISO 294-4	0.75
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	2350
C Yield stress	50 mm/min	MPa	ISO 527-1,-2	65
C Yield strain	50 mm/min	%	ISO 527-1,-2	6.3
C Nominal strain at break	50 mm/min	%	ISO 527-1,-2	> 50
Stress at break	50 mm/min	MPa	ISO 527-1,-2	75
Strain at break	50 mm/min	%	b.o. ISO 527-1,-2	120
C Tensile creep modulus	1 h	MPa	ISO 899-1	2200
C Tensile creep modulus	1000 h	MPa	ISO 899-1	1900
Flexural modulus	2 mm/min	MPa	ISO 178	2350
Flexural strength	2 mm/min	MPa	ISO 178	96
Flexural strain at flexural strength	2 mm/min	%	ISO 178	7.2
Flexural stress at 3.5 % strain	2 mm/min	MPa	ISO 178	72
C Charpy impact strength	23 °C	kJ/m²	ISO 179/1eU	N
Charpy impact strength	-60 °C	kJ/m²	ISO 179/1eU	N
Charpy notched impact strength	23 °C/ 3 mm	kJ/m²	ISO 21305/based on ISO 179/1eA	80P
Charpy notched impact strength	-30 °C/ 3 mm	kJ/m²	ISO 21305/based on ISO 179/1eA	18C(P)
Izod notched impact strength	23 °C/ 3 mm	kJ/m²	ISO 21305/based on ISO 180/A	70P
Izod notched impact strength	-30 °C/ 3 mm	kJ/m²	ISO 21305/based on ISO 180/A	20C(P)
C Puncture impact properties - maximum force	23 °C	N	ISO 6603-2	5600
C Puncture impact properties - maximum force	-30 °C	N	ISO 6603-2	6500
C Puncture energy	23 °C	J	ISO 6603-2	60
C Puncture energy	-30 °C	J	ISO 6603-2	70
Ball indentation hardness		N/mm²	ISO 2039-1	111
Thermal properties				
C Glass transition temperature	10 °C/min	°C	ISO 11357-1,-2	149
C Temperature of deflection under load	1.80 MPa	°C	ISO 75-1,-2	129
C Temperature of deflection under load	0.45 MPa	°C	ISO 75-1,-2	141
C Vicat softening temperature	50 N; 50 °C/h	°C	ISO 306	149
Vicat softening temperature	50 N; 120 °C/h	°C	ISO 306	150
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
Thermal conductivity, through-plane	23 °C; 50 % r. h.	W/(m·K)	ISO 8302	0.20
Resistance to heat (ball pressure test)		°C	IEC 60695-10-2	140
Flash ignition temperature		°C	ASTM D1929	480
Self ignition temperature		°C	ASTM D1929	550



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Other properties (23 °C)				
C Water absorption (saturation value)	Water at 23 °C	%	ISO 62	0.30
C Water absorption (equilibrium value)	23 °C; 50 % r. h.	%	ISO 62	0.12
C Density		kg/m³	ISO 1183-1	1200
Bulk density	Pellets	kg/m³	ISO 60	660
Material specific properties				
Refractive index	Procedure A	-	ISO 489	1.587
Haze for transparent materials	3 mm	%	ISO 14782	< 0.8
Luminous transmittance (clear transparent materials)	1 mm	%	ISO 13468-2	89
C Luminous transmittance (clear transparent materials)	2 mm	%	ISO 13468-2	89
Luminous transmittance (clear transparent materials)	3 mm	%	ISO 13468-2	88
Luminous transmittance (clear transparent materials)	4 mm	%	ISO 13468-2	87
Processing conditions for test specimens				
C Injection molding - Melt temperature		°C	ISO 294	300
C Injection molding - Mold temperature		°C	ISO 294	80
C Injection molding - Injection velocity		mm/s	ISO 294	200
Recommended processing and drying conditions				
Melt temperatures		°C	-	290 - 330
Standard Melt temperature		°C	-	310
Barrel Temperatures - Rear		°C	-	260 - 270
Barrel Temperatures - Middle		°C	-	280 - 290
Barrel Temperatures - Front		°C	-	290 - 300
Barrel Temperatures - Nozzle		°C	-	300 - 310
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

