

Bayer MaterialScience Makrolon® 6267 Polycarbonate, Flame Retardant Grade

Categories: [Polymer](#); [Thermoplastic](#); [Polycarbonate](#); [Polycarbonate, Molded](#)

- Material Notes:**
- ISO 7391-PC,MFLR,(,,-)18-9
 - Formerly Makrolon DP1-1872
 - MVR (300 °C/1.2 kg) 19 cm³/10 min
 - Flame retardant
 - UL 94V-0/1.5 mm
 - Low viscosity
 - UV stabilized
 - Easy release
 - Injection molding - Melt temperature 280 - 320 °C
 - Available in opaque colors only

Preprocessing

Max. Water content 0.02 %

Drying temperature 120 °C

Drying time

Circulating air drying oven (50 % fresh air) 4-12 h

Fresh air dryer (high speed dryer) 2-4 h

Dry air dryer 2-3 h

Processing

Melt temperature 280-320 °C

Mold temperature 80-120 °C

Vendors: No vendors are listed for this material. Please [click here](#) if you are a supplier and would like information on how to add your listing to this material.

Physical Properties	Metric	English	Comments
Density	1.20 g/cc	0.0434 lb/in³	ISO 1183
	1.02 g/cc	0.0368 lb/in³	Melt
	@Temperature 280 °C	@Temperature 536 °F	
Water Absorption	0.300 %	0.300 %	Similar to ISO 62
Moisture Absorption at Equilibrium	0.120 %	0.120 %	Similar to ISO 62
Linear Mold Shrinkage, Flow	0.00700 cm/cm	0.00700 in/in	parallel; ISO 294-4,2577
Linear Mold Shrinkage, Transverse	0.00700 cm/cm	0.00700 in/in	ISO 294-4,2577
Melt Flow	19.0 g/10 min	19.0 g/10 min	ISO 1133
	@Load 1.20 kg, Temperature 300 °C	@Load 2.65 lb, Temperature 572 °F	
Mechanical Properties	Metric	English	Comments
Tensile Strength, Yield	67.0 MPa	9720 psi	ISO 527-1/-2
Elongation at Break	>= 50.0 %	>= 50.0 %	Nominal; ISO 527-1/-2
Elongation at Yield	6.00 %	6.00 %	ISO 527-1/-2
Tensile Modulus	2.45 GPa	355 ksi	ISO 527-1/-2
Charpy Impact Unnotched	NB	NB	ISO 179/1eU
	NB	NB	ISO 179/1eU
	@Temperature -30.0 °C	@Temperature -22.0 °F	
Impact	5000	5000	Puncture - maximum force (N); ISO 6603-2
	5900	5900	Puncture - maximum force (N); ISO 6603-2
	@Temperature -30.0 °C	@Temperature -22.0 °F	
Puncture Energy	50.0 J	36.9 ft-lb	ISO 6603-2
	55.0 J	40.6 ft-lb	ISO 6603-2
	@Temperature -30.0 °C	@Temperature -22.0 °F	
Electrical Properties	Metric	English	Comments
Volume Resistivity	>= 1.00e+13 ohm-cm	>= 1.00e+13 ohm-cm	IEC 60093
Surface Resistance	>= 1.00e+15 ohm	>= 1.00e+15 ohm	IEC 60093
Dielectric Constant 	3.00	3.00	IEC 60250
	@Frequency 1.00e+6 Hz	@Frequency 1.00e+6 Hz	
	3.10	3.10	IEC 60250
	@Frequency 100 Hz	@Frequency 100 Hz	
Dielectric Strength	34.0 kV/mm	864 kV/in	IEC 60243-1
Dissipation Factor 	0.000800	0.000800	IEC 60250
	@Frequency 100 Hz	@Frequency 100 Hz	
	0.00900	0.00900	IEC 60250



	@Frequency 1.00e+6 Hz	@Frequency 1.00e+6 Hz	
Comparative Tracking Index	225 V	225 V	IEC 60112
Thermal Properties	Metric	English	Comments
CTE, linear	65.0 µm/m-°C	36.1 µin/in-°F	parallel; ISO 11359-1/-2
CTE, linear, Transverse to Flow	65.0 µm/m-°C	36.1 µin/in-°F	ISO 11359-1/-2
Specific Heat Capacity	1.70 J/g-°C	0.406 BTU/lb-°F	Melt
Thermal Conductivity	0.173 W/m-K	1.20 BTU-in/hr-ft²-°F	Melt
Deflection Temperature at 0.46 MPa (66 psi)	134 °C	273 °F	ISO 75-1/-2
Deflection Temperature at 1.8 MPa (264 psi)	122 °C	252 °F	ISO 75-1/-2
Vicat Softening Point	144 °C	291 °F	50°C/h 50N; ISO 306
Flammability, UL94 	V-0	V-0	IEC 60695-11-10
	@Thickness 1.50 mm	@Thickness 0.0591 in	
	V-0	V-0	IEC 60695-11-10
	@Thickness 3.00 mm	@Thickness 0.118 in	
Oxygen Index	35.0 %	35.0 %	ISO 4589-1/-2
Processing Properties	Metric	English	Comments
Melt Temperature	280 °C	536 °F	Injection Molding; ISO 294
	280 - 320 °C	536 - 608 °F	
Mold Temperature	80.0 °C	176 °F	Injection Molding; ISO 10724
	80.0 - 120 °C	176 - 248 °F	
Ejection Temperature	130 °C	266 °F	
Injection Velocity	200 mm/sec	7.87 in/sec	ISO 294
Descriptive Properties			
Availability		Asia Pacific	
		Europe	
		India	
		Near East/Africa	
		North America	
		South and Central America	
Eff. thermal diffusivity (m²/s)		1E-07	
Feature		Light stabilised or stable to light	
		Release agent	
		U.V. stabilised or stable to weather	
Form		Pellets	
Process		Injection Molding	
UL recognition		ULV1.5\h	
		ULV\h\h	

