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; suitable for 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
Recommended processing and drying conditions					
	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