

Makrolon® LED5102

Grades / Light guides

MVR (300 °C/1.2 kg) 34 cm³/10 min; low viscosity; UV stabilized; easy release; high optical transmittance; LED Lighting, optics and lenses; injection molding - melt temperature 280 - 320 °C

ISO Shortname

PC

Property	Test Condition	Unit	Standard	typical Value
Rheological properties				
C Melt volume-flow rate	300 °C/ 1.2 kg	cm³/10 min	ISO 1133	34
C Molding shrinkage, parallel	60x60x2 mm	%	ISO 294-4	0.65
C Molding shrinkage, normal	60x60x2 mm	%	ISO 294-4	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	63
C Yield strain	50 mm/min	%	ISO 527-1,-2	6.0
C Nominal strain at break	50 mm/min	%	ISO 527-1,-2	> 50
Stress at break	50 mm/min	MPa	ISO 527-1,-2	60
Strain at break	50 mm/min	%	b.o. ISO 527-1,-2	120
Flexural modulus	2 mm/min	MPa	ISO 178	2350
Flexural strength	2 mm/min	MPa	ISO 178	97
Flexural strain at flexural strength	2 mm/min	%	ISO 178	7.1
Flexural stress at 3.5 % strain	2 mm/min	MPa	ISO 178	73
Izod notched impact strength	23 °C/ 3 mm	kJ/m²	ISO 21305/based on ISO 180/A	55P(C)
Izod notched impact strength	-30 °C/ 3 mm	kJ/m²	ISO 21305/based on ISO 180/A	12C
Thermal properties				
C Temperature of deflection under load	1.80 MPa	°C	ISO 75-1,-2	123
C Temperature of deflection under load	0.45 MPa	°C	ISO 75-1,-2	136
C Vicat softening temperature	50 N; 50 °C/h	°C	ISO 306	143
Vicat softening temperature	50 N; 120 °C/h	°C	ISO 306	145
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
Other properties (23 °C)				
C Density		kg/m³	ISO 1183-1	1190
Material specific properties				
C Refractive index	Procedure A	-	ISO 489	1.584
Haze for transparent materials	3 mm	%	ISO 14782	< 0.5
C Luminous transmittance (clear transparent materials)	2 mm	%	ISO 13468-2	90
Luminous transmittance (clear transparent materials)	4 mm	%	ISO 13468-2	89
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





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Property	Test Condition	Unit	Standard	typical Value
Recommended processing and drying conditions				
Melt temperatures		°C	-	250-300
Standard Melt temperature		°C	-	270
Barrel Temperatures - Rear		°C	-	230-240
Barrel Temperatures - Middle		°C	-	250-260
Barrel Temperatures - Front		°C	-	260-270
Barrel Temperatures - Nozzle		°C	-	260-270
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

