



Makrolon® 1952

Flame retardant grades / Medium viscosity

MVR (300 °C/1.2 kg) 10 cm³/10 min; flame retardant; UL 94V-0/2.3 mm; medium viscosity; UV stabilized; easy release; injection molding - melt temperature 280 - 320 °C; available in translucent and opaque colors; LCD notebook cover

ISO Shortname

ISO 7391-PC,MFLR,(,)-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	10
C Molding shrinkage, parallel	60x60x2 mm; 500 bar	%	ISO 294-4	0.65
C Molding shrinkage, normal	60x60x2 mm; 500 bar	%	ISO 294-4	0.7
Molding shrinkage, parallel/normal	Value range based on general practical experience	%	b.o. ISO 2577	0.6 - 0.8
Melt mass-flow rate	300 °C; 1.2 kg	g/10 min	ISO 1133	10
Mechanical properties (23 °C/50 % r. h.)				
C Tensile modulus	1 mm/min	MPa	ISO 527-1,-2	2400
C Yield stress	50 mm/min	MPa	ISO 527-1,-2	66
C Yield strain	50 mm/min	%	ISO 527-1,-2	6.1
C Nominal strain at break	50 mm/min	%	ISO 527-1,-2	> 50
Stress at break	50 mm/min	MPa	ISO 527-1,-2	70
Strain at break	50 mm/min	%	b.o. ISO 527-1,-2	130
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	2400
Flexural strength	2 mm/min	MPa	ISO 178	99
Flexural strain at flexural strength	2 mm/min	%	ISO 178	7.0
Flexural stress at 3.5 % strain	2 mm/min	MPa	ISO 178	75
C Charpy impact strength	23 °C	kJ/m²	ISO 179-1eU	N
C Charpy impact strength	-30 °C	kJ/m²	ISO 179-1eU	N
Charpy notched impact strength	23 °C; 3 mm	kJ/m²	ISO 7391/b.o. ISO 179-1eA	70P(C)
Charpy notched impact strength	-30 °C; 3 mm	kJ/m²	ISO 7391/b.o. ISO 179-1eA	14C
Izod notched impact strength	23 °C; 3 mm	kJ/m²	ISO 7391/b.o. ISO 180-A	65P
Izod notched impact strength	-30 °C; 3 mm	kJ/m²	ISO 7391/b.o. ISO 180-A	12C
C Puncture maximum force	23 °C	N	ISO 6603-2	5400
C Puncture maximum force	-30 °C	N	ISO 6603-2	6300
C Puncture energy	23 °C	J	ISO 6603-2	60
C Puncture energy	-30 °C	J	ISO 6603-2	65
Ball indentation hardness		N/mm²	ISO 2039-1	115
Thermal properties				
C Glass transition temperature	10 °C/min	°C	ISO 11357-1,-2	144
C Temperature of deflection under load	1.80 MPa	°C	ISO 75-1,-2	124
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	144
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, transverse	23 to 55 °C	10⁻⁴/K	ISO 11359-1,-2	0.65
C Burning behavior UL 94 [UL recognition]	2.3 mm	Class	UL 94	V-0
Thermal conductivity, cross-flow	23 °C; 50 % r. h.	W/(m·K)	ISO 8302	0.20
Resistance to heat (ball pressure test)		°C	IEC 60695-10-2	135
Burning rate (US-FMVSS)	>=1.0 mm	mm/min	ISO 3795	passed
Flash ignition temperature		°C	ASTM D1929	460
Self ignition temperature		°C	ASTM D1929	530



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Property	Test Condition	Unit	Standard	typical Value
Electrical properties (23 °C/50 % r. h.)				
C Relative permittivity	100 Hz	-	IEC 60250	3.1
C Relative permittivity	1 MHz	-	IEC 60250	3.0
C Dissipation factor	100 Hz	10 ⁻⁴	IEC 60250	8
C Dissipation factor	1 MHz	10 ⁻⁴	IEC 60250	90
C Volume resistivity		Ohm·m	IEC 60093	1E14
C Surface resistivity		Ohm	IEC 60093	1E16
C Electrical strength	1 mm	kV/mm	IEC 60243-1	34
C Comparative tracking index CTI	Solution A	Rating	IEC 60112	225
Comparative tracking index CTI M	Solution B	Rating	IEC 60112	125M
Electrolytic corrosion		Rating	IEC 60426	A1
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/m ³	ISO 1183-1	1200
Water vapor permeability	23 °C; 85 % RH; 100 µm film	g/(m ² ·24 h)	ISO 15106-1	15
Gas permeation	Oxygen; 100 µm film	cm ³ /(m ² ·24 h·bar)	b.o. ISO 2556	650
Gas permeation	Oxygen; 25.4 µm (1 mil) film	cm ³ /(m ² ·24 h·bar)	b.o. ISO 2556	2760
Gas permeation	Nitrogen; 100 µm film	cm ³ /(m ² ·24 h·bar)	b.o. ISO 2556	120
Gas permeation	Nitrogen; 25.4 µm (1 mil) film	cm ³ /(m ² ·24 h·bar)	b.o. ISO 2556	510
Gas permeation	Carbon dioxide; 100 µm film	cm ³ /(m ² ·24 h·bar)	b.o. ISO 2556	3800
Gas permeation	Carbon dioxide; 25.4 µm (1 mil) film	cm ³ /(m ² ·24 h·bar)	b.o. ISO 2556	16900
Bulk density	Pellets	kg/m ³	ISO 60	640
Material specific properties				
Haze	2 mm	%	ISO 14782	3
Haze	4 mm	%	ISO 14782	8
Luminous transmittance	2 mm	%	ISO 13468-2	88
Luminous transmittance	4 mm	%	ISO 13468-2	84
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

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

