

**Makrolon® FP3087**

 Covestro - Polycarbonates - *Polycarbonate*

## General Information

**Product Description**

 MVR (300°C/1.2 kg) 7.0 cm<sup>3</sup>/10 min; high viscosity

**General**

Material Status	• Commercial: Active		
Availability	• Africa & Middle East	• Europe	• North America
	• Asia Pacific	• Latin America	
Features	• High Viscosity		
RoHS Compliance	• RoHS Compliant		
Resin ID (ISO 1043)	• PC		

 Properties <sup>1</sup>

Physical	Nominal Value	Unit	Test Method
Melt Volume-Flow Rate (MVR) (300°C/1.2 kg)	7.0	cm <sup>3</sup> /10min	ISO 1133
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (73°F)	341000	psi	ISO 527-1/1
Tensile Stress (Yield, 73°F)	9570	psi	ISO 527-2/50
Tensile Stress (Break, 73°F)	10900	psi	ISO 527-2/50
Tensile Strain (Yield, 73°F)	6.0	%	ISO 527-2/50
Tensile Strain (Break, 73°F)	130	%	ISO 527-2/50
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength <sup>2</sup>			ISO 7391
-4°F	6.7	ft·lb/in <sup>2</sup>	
73°F	36	ft·lb/in <sup>2</sup>	
Multi-Axial Instrumented Impact Energy			ISO 6603-2
-22°F	49.4	ft·lb	
73°F	45.7	ft·lb	
Multi-Axial Instrumented Impact Peak Force			ISO 6603-2
-22°F	1460	lbf	
73°F	1280	lbf	
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (264 psi, Unannealed)	252	°F	ISO 75-2/A
Vicat Softening Temperature	288	°F	ISO 306/B50

## Processing Information

Injection	Nominal Value	Unit
Drying Temperature - Dry Air Dryer	248	°F
Drying Time - Dry Air Dryer	2.0 to 3.0	hr
Suggested Max Moisture	< 0.020	%
Suggested Shot Size	30 to 70	%
Rear Temperature	482 to 500	°F
Middle Temperature	518 to 536	°F
Front Temperature	536 to 554	°F
Nozzle Temperature	554 to 572	°F
Processing (Melt) Temp	536 to 608	°F
Mold Temperature	176 to 248	°F
Back Pressure	725 to 2180	psi
Vent Depth	9.8E-4 to 3.0E-3	in

**Injection Notes**


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Hold Pressure (% of Injection Pressure): 50 - 75%  
Standard Melt Temperature: 300°C  
Peripheral Screw Speed: 0.05 - 0.2 m/s

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#### Notes

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<sup>1</sup> Typical properties: these are not to be construed as specifications.

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<sup>2</sup> Notch A

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