Makrolon® FP2987

Covestro - Polycarbonates - *Polycarbonate*

General Information

Product Description			
high viscosity; MVR (300 °C/1.2 kg) 9.0 cm³/10 min			
General			
Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Features	• High Viscosity		
ISO Designation	• PC		

Properties [1]

Physical	**Nominal Value**	**Unit**	**Test Method**
Melt Volume-Flow Rate (MVR) (300°C/1.2 kg)	9.0	cm³/10min	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			ISO 180/A
-4°F	6.7	ft·lb/in²	
73°F	36	ft·lb/in²	
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

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

Notes

[1] Typical properties: these are not to be construed as specifications.