



Makroblend DP4-1386

Speciality grades / Transparent

Developmental product
Polycarbonate/polyester blend; transparent grade with improved chemical resistance to PC

ISO Shortname

Property	Test Condition	Unit	Standard	Value
Rheological properties				
Spiral flow length	0.100 in, 510 °F melt temperature	in	Bayer test	16
Mold shrinkage, flow/cross to flow		in/in	ASTM D 955	0.006-0.008
Melt flow rate	265 °C; 5 kg	g/(10 min)	ASTM D 1238	15-20
Mechanical properties (23 °C/50 % r.h.)				
Tensile stress at yield		lb/in ²	ASTM D 638	8900
Tensile elongation at yield		%	ASTM D 638	5.0
Tensile elongation at break		%	ASTM D 638	110
Tensile stress at break		lb/in ²	ASTM D 638	8700
Izod notched impact strength	73 °F; 0.100 in	ft·lb/in	ASTM D 256	15
Flexural modulus		lb/in ²	ASTM D 790	330000
Flexural stress at 5 % strain		lb/in ²	ASTM D 790	12000
Instrumented impact, Total energy	73 °F; 0.125 in; 0.5-in dart; 3-in clamp; 7.6 mph	ft·lb	ASTM D 3763	51
Instrumented impact, Total energy	-20 °F; 0.125 in; 0.5-in dart; 3-in clamp; 15 mph	ft·lb	ASTM D 3763	51
Instrumented impact, Total energy	-40 °F; 0.125 in; 0.5-in dart; 3-in clamp; 7.6 mph	ft·lb	ASTM D 3763	51
Rockwell hardness		R Scale	ASTM D 785	124
Thermal properties				
Deflection temperature under load, Unannealed	264 psi; 0.250 in	°F	ASTM D 648	220
Deflection temperature under load, Unannealed	66 psi; 0.250 in	°F	ASTM D 648	240
Relative temperature index, mechanical with impact	Thickness tested: 1.5 mm	°C	UL 746 B	85
Relative temperature index, electrical	Thickness tested: 1.5 mm	°C	UL 746 B	95
Relative temperature index, mechanical without impact	Thickness tested: 1.5 mm	°C	UL 746 B	90
Other properties (23 °C)				
Water absorption	73 °F; immersion to saturation	%	ASTM D 570	0.17
Specific volume		in ³ /lb	ASTM D 792	23.1
Density		lb/in ³	ASTM D 792	0.043
Material specific properties				
Haze for transparent materials		%	ASTM D 1003	0.5