

# Makrolon® 8345

**Glass fiber (Normal fiber) reinforced grades / 35 % Glass fiber reinforced** MVR (300 °C/1.2 kg) 3.0 cm<sup>3</sup>/10 min; 35 % glass fiber reinforced; high viscosity; easy release; injection molding - melt temperature 310 - 330 °C; extrusion; available in opaque colors only

**ISO Shortname** ISO 7391-PC,GR,(,)-05-3,GF35

Property	Test Condition	Unit	Standard	typical Value
<b>Rheological properties</b>				
C Melt volume-flow rate	300 °C/ 1.2 kg	cm <sup>3</sup> /10 min	ISO 1133	3.0
Molding shrinkage, parallel/normal	Value range based on general practical experience	%	b.o. ISO 2577	0.3 - 0.5
Melt mass-flow rate	300 °C/ 1.2 kg	g/10 min	ISO 1133	3.5
<b>Mechanical properties (23 °C/50 % r. h.)</b>				
C Tensile modulus	1 mm/min	MPa	ISO 527-1,-2	9400
C Yield stress	50 mm/min	MPa	ISO 527-1,-2	113
C Yield strain	50 mm/min	%	ISO 527-1,-2	1.9
C Stress at break	5 mm/min	MPa	ISO 527-1,-2	110
C Strain at break	5 mm/min	%	ISO 527-1,-2	1.8
C Tensile creep modulus	1 h	MPa	ISO 899-1	9000
C Tensile creep modulus	1000 h	MPa	ISO 899-1	8500
Flexural modulus	2 mm/min	MPa	ISO 178	8600
Flexural strength	2 mm/min	MPa	ISO 178	170
Flexural strain at flexural strength	2 mm/min	%	ISO 178	2.5
C Charpy impact strength	23 °C	kJ/m <sup>2</sup>	ISO 179-1eU	40C
C Charpy impact strength	-30 °C	kJ/m <sup>2</sup>	ISO 179-1eU	45C
Charpy notched impact strength	23 °C/ 3 mm	kJ/m <sup>2</sup>	ISO 7391/b.o. ISO 179-1eA	8C
Izod notched impact strength	23 °C/ 3 mm	kJ/m <sup>2</sup>	ISO 7391/b.o. ISO 180-A	8C
C Puncture maximum force	23 °C	N	ISO 6603-2	900
C Puncture maximum force	-30 °C	N	ISO 6603-2	900
C Puncture energy	23 °C	J	ISO 6603-2	5
C Puncture energy	-30 °C	J	ISO 6603-2	5
Ball indentation hardness		N/mm <sup>2</sup>	ISO 2039-1	175

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Property	Test Condition	Unit	Standard	typical Value
<b>Thermal properties</b>				
C Temperature of deflection under load	1.80 MPa	°C	ISO 75-1,-2	140
C Temperature of deflection under load	0.45 MPa	°C	ISO 75-1,-2	144
C Vicat softening temperature	50 N; 50 °C/h	°C	ISO 306	148
C Vicat softening temperature	50 N; 120 °C/h	°C	ISO 306	149
C Coefficient of linear thermal expansion, parallel	23 to 55 °C	10 <sup>-4</sup> /K	ISO 11359-1,-2	0.2
C Coefficient of linear thermal expansion, transverse	23 to 55 °C	10 <sup>-4</sup> /K	ISO 11359-1,-2	0.6
C Burning behavior UL 94 (1.5 mm) [UL recognition]	1.5 mm	Class	UL 94	V-1
C Burning behavior UL 94 [UL recognition]	3.0 mm	Class	UL 94	V-0
C Oxygen index	Method A	%	ISO 4589-2	35
Thermal conductivity, cross-flow	23 °C; 50 % r. h.	W/(m·K)	ISO 8302	0.24
Resistance to heat (ball pressure test)		°C	IEC 60695-10-2	136
Relative temperature index (Tensile strength) [UL recognition]	1.5 mm	°C	UL 746B	125
Relative temperature index (Tensile impact strength) [UL recognition]	1.5 mm	°C	UL 746B	115
Relative temperature index (Electric strength) [UL recognition]	1.5 mm	°C	UL 746B	125
Glow wire test (GWFI)	1.5 mm	°C	IEC 60695-2-12	960
Glow wire test (GWFI)	3.0 mm	°C	IEC 60695-2-12	960
Application of flame from small burner	Method K and F/ 2.0 mm	Class	DIN 53438-1,-3	K1, F1
Needle flame test	Method K/ 1.5 mm	s	IEC 60695-11-5	60
Needle flame test	Method K/ 2.0 mm	s	IEC 60695-11-5	60
Needle flame test	Method K/ 3.0 mm	s	IEC 60695-11-5	120
Needle flame test	Method F/ 1.5 mm	s	IEC 60695-11-5	120
Needle flame test	Method F/ 2.0 mm	s	IEC 60695-11-5	120
Needle flame test	Method F/ 3.0 mm	s	IEC 60695-11-5	120
Burning rate (US-FMVSS)	>=1.0 mm	mm/min	ISO 3795	passed
Flash ignition temperature		°C	ASTM D1929	470
Self ignition temperature		°C	ASTM D1929	550
<b>Electrical properties (23 °C/50 % r. h.)</b>				
C Relative permittivity	100 Hz	-	IEC 60250	3.6
C Relative permittivity	1 MHz	-	IEC 60250	3.6
C Dissipation factor	100 Hz	10 <sup>-4</sup>	IEC 60250	10
C Dissipation factor	1 MHz	10 <sup>-4</sup>	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	36
C Comparative tracking index CTI	Solution A	Rating	IEC 60112	175
Comparative tracking index CTI M	Solution B	Rating	IEC 60112	125M
Electrolytic corrosion		Rating	IEC 60426	A1
<b>Other properties (23 °C)</b>				
C Water absorption (saturation value)	Water at 23 °C	%	ISO 62	0.20
C Water absorption (equilibrium value)	23 °C; 50 % r. h.	%	ISO 62	0.10
C Density		kg/m <sup>3</sup>	ISO 1183-1	1480
Glass fiber content	Method A	%	b.o. ISO 3451-1	35
Bulk density	Pellets	kg/m <sup>3</sup>	ISO 60	670

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Property	Test Condition	Unit	Standard	typical Value
<b>Processing conditions for test specimens</b>				
C Injection molding-Melt temperature		°C	ISO 294	300
C Injection molding-Mold temperature		°C	ISO 294	110
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



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## Disclaimer

### Typical value

These values are typical values only. Unless explicitly agreed in written form, they do not constitute a binding material specification or warranted values. Values may be affected by the design of the mold/die, the processing conditions and coloring/pigmentation of the product. Unless specified to the contrary, the property values given have been established on standardized test specimens at room temperature.

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