



# MAKROFOL<sup>®</sup> DE 1-1 000000

## Characterization

Makrofol DE 1-1 000000 is an extrusion film based on Makrolon<sup>®</sup> polycarbonate.

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## Properties / Applications

Makrofol DE 1-1 000000 comprises excellent transparency with high optical quality. Typical applications are automotive, labels, membrane switches, nameplates, and thermoform packaging.

Makrofol DE 1-1 000000 is available in various standard thicknesses from 0.005 " to 0.040 " (125 microns to 1,000 microns). Other thicknesses are available on request. The surface combination of Makrofol DE 1-1 000000 is both sides gloss; one or both sides either with cling (C) or stick (S) masking. As with any product, use of Makrofol DE 1-1 000000 in a given application must be tested (including but not limited to field testing) in advance by the user to determine suitability.

# MAKROFOL<sup>®</sup> DE 1-1 000000

## Typical Properties\*

Property	Test Method	Unit	Value
<b>General</b>			
Specific Gravity	ASTM D 792		1.20
Conversion Factor		ft <sup>2</sup> /lb•mil   m <sup>2</sup> /kg•mm	161   0.833
Gloss 60° top side black inked second surface	ASTM D 2457	gloss unit	> 90
Gloss 60° reverse side	ASTM D 2457	gloss unit	> 90
Roughness, R3z, top side	ISO 4287/88	µm	≤ 0.5
Roughness, R3z, reverse side	ISO 4287/88	µm	≤ 0.5
Surface			gloss/gloss
<b>Mechanical</b>			
Tensile Strength, Yield	ASTM D 882	psi	9,100
Tensile Strength, Break	ASTM D 882	psi	10,500
Elongation at Break	ASTM D 882	%	125
Flexural Modulus	ASTM D 790	psi	330,000
Tear Strength, Initiation	ASTM D 1004	lb/in	1,100
<b>Thermal</b>			
Coefficient of linear thermal expansion parallel 20°C to 120°C	DIN 53752	10 <sup>-6</sup> /K	70
Coefficient of linear thermal expansion across 20°C to 120°C	DIN 53752	10 <sup>-6</sup> /K	70
Shrinkage, parallel 130°C, 1h	IEC 60674-2	%	< 0.4
Shrinkage, across 130°C, 1h	IEC 60674-2	%	< 0.4
Heat Deflection Temperature 1.82 MPa	ASTM D 648	°F	270
0.45 MPa			288
Vicat Softening Temperature, Rate A	ASTM D 1525	°F	297
<b>Flammability</b>			
Burning Rate (FMVSS 302)	ISO 3795	mm/min	≤ 100
UL Listing	UL 94 V-2	min. thickness	0.015" (375 µm)
UL Listing	UL 94 VTM-2	min. thickness	0.005" (125 µm)
<b>Optical</b>			
Haze	ASTM D 1003	%	< 1
Light Transmittance	ASTM D 1003	%	89
Yellowness Index	ASTM E 313		1
<b>Other</b>			
Water Absorption (saturation)	ISO 62	%	0.20
Water Absorption (immersion at 73°F/24h)	ASTM D 570	%	0.35

\*These items are provided as general information only. They are approximate values and are not part of the product specifications.



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## Health and Safety Information

Appropriate literature has been assembled which provides information concerning the health and safety precautions that must be observed when handling this product. Before working with this product, you must read and become familiar with the available information on its risks, proper use, and handling. This cannot be overemphasized. Information is available in several forms, e.g., safety data sheets and product labels. For further information contact your Covestro LLC representative or the Product Safety and Regulatory Affairs Department in Pittsburgh, PA.

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Document contains important information and must be read in its entirety.

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**Product Datasheet**