



## Product description

Polycarbonate; flame retardant; no intentionally added PFAS; V-0 at 3.0 mm (UL 94); medium viscosity; easy release; available in transparent, translucent and opaque colors

## Applications

Injection molding; Electrical/electronic

## Typical Values

### Rheological properties

| Property                    | Test Condition                | Value | Unit                    | Standard          |
|-----------------------------|-------------------------------|-------|-------------------------|-------------------|
| Melt Volume-flow Rate (MVR) | 300 °C/1.2 kg                 | 7     | cm <sup>3</sup> /10 min | ISO 1133-1        |
| Melt Viscosity              | 300 °C; 1,000 s <sup>-1</sup> | 230   | Pa·s                    | b. o. ISO 11443-A |

### Mechanical properties (23 °C; 50 % r. h.)

| Property                     | Test Condition | Value | Unit              | Standard                  |
|------------------------------|----------------|-------|-------------------|---------------------------|
| Tensile Modulus              | 1 mm/min       | 2,350 | MPa               | ISO 527-1,-2              |
| Yield Stress                 | 50 mm/min      | 65    | MPa               | ISO 527-1,-2              |
| Yield Strain                 | 50 mm/min      | 6.1   | %                 | ISO 527-1,-2              |
| Stress at Break              | 50 mm/min      | 57    | MPa               | ISO 527-1,-2              |
| Strain at Break              | 50 mm/min      | 85    | %                 | ISO 527-1,-2              |
| Nominal Strain at Break      | 50 mm/min      | > 50  | %                 | ISO 527-1,-2              |
| Izod Notched Impact Strength | 23 °C; 3 mm    | 50P   | kJ/m <sup>2</sup> | ISO 21305/b. o. ISO 180/A |

Impact properties: N = non-break, P = partial break, C = complete break

### Thermal properties

| Property                                   | Test Condition | Value | Unit | Standard       |
|--------------------------------------------|----------------|-------|------|----------------|
| Temperature of Deflection under Load (HDT) | 1.80 MPa       | 122   | °C   | ISO 75-1,-2    |
| Temperature of Deflection under Load (HDT) | 0.45 MPa       | 137   | °C   | ISO 75-1,-2    |
| Vicat Softening Temperature                | 50 N; 50 °C/h  | 143   | °C   | ISO 306        |
| Vicat Softening Temperature                | 50 N; 120 °C/h | 144   | °C   | ISO 306        |
| Burning Behavior                           | 3 mm           | V-0   |      | UL 94          |
| Glow Wire Test (GWFI)                      | 0.8 mm         | 900   | °C   | IEC 60695-2-12 |
| Glow Wire Test (GWFI)                      | 1.5 mm         | 900   | °C   | IEC 60695-2-12 |
| Glow Wire Test (GWFI)                      | 3 mm           | 960   | °C   | IEC 60695-2-12 |
| Glow Wire Test (GWIT)                      | 0.8 mm         | 850   | °C   | IEC 60695-2-13 |



| Property              | Test Condition | Value | Unit | Standard       |
|-----------------------|----------------|-------|------|----------------|
| Glow Wire Test (GWIT) | 1.5 mm         | 850   | °C   | IEC 60695-2-13 |
| Glow Wire Test (GWIT) | 3 mm           | 850   | °C   | IEC 60695-2-13 |

## Electrical properties (23 °C; 50 % r. h.)

| Property                         | Test Condition | Value | Unit  | Standard      |
|----------------------------------|----------------|-------|-------|---------------|
| Volume Resistivity               |                | 1E14  | Ω·m   | IEC 62631-3-1 |
| Surface Resistivity              |                | 1E15  | Ω     | IEC 62631-3-2 |
| Electric Strength                | 1 mm           | 32    | kV/mm | IEC 60243-1   |
| Comparative Tracking Index (CTI) | Solution A     | 175   | V     | IEC 60112     |

## Other properties (23 °C)

| Property | Test Condition | Value | Unit  | Standard   |
|----------|----------------|-------|-------|------------|
| Density  |                | 1,200 | kg/m³ | ISO 1183-1 |

## Recommended processing and drying conditions

| Property                   | Test Condition | Value     | Unit | Standard |
|----------------------------|----------------|-----------|------|----------|
| Dry Air Drying Temperature |                | 120       | °C   |          |
| Dry Air Drying Time        |                | 2 - 3     | h    |          |
| Melt Temperatures          |                | 280 - 320 | °C   |          |
| Mold Temperatures          |                | 80 - 120  | °C   |          |

## Health and Safety Information

Before working with this product, you must read and become familiar with the available information regarding its risks, proper use, and safe handling. This information is provided in various formats, including the current Safety Data Sheet (SDS) and product label. SDS can be accessed via the following link:

[Safety Data Sheets \(SDS\) for Covestro products | Covestro](#)

For further questions, please use the contact information provided on this technical data sheet.

Please note that for products manufactured in different colors, safety data may vary depending on the color variant.



## Disclaimer

### Responsibility and Liability

The use of Covestro products, technical assistance, and information (regardless of how provided) is outside Covestro's control and is solely the responsibility of the customer. The customer must conduct adequate testing to determine the suitability of products for its intended use, including but not limited to technical, health, safety, and environmental aspects. Unless otherwise agreed in writing, all products are sold exclusively under Covestro's standard conditions of sale, which prevail in case of conflict and are available upon request.

The terms and conditions of sale and delivery are available via the following link:

<https://order.covestro.com/covestrostorefront/saleConditions>

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### Restrictions on Regulated Applications

This product is not intended for use in regulated applications such as agriculture, cosmetics, drinking water contact, food contact, medical products (e.g., medical devices), toys, or similar uses subject to specific regulatory requirements. Prior written approval from Covestro is required before this product may be used in any regulated application. The customer is solely responsible for ensuring compliance with all applicable laws and determining product suitability. Covestro disclaims all liability and warranties for unauthorized regulated uses.

### Preliminary Datasheet

This product's typical properties have been determined using limited statistical data and are provided for reference only. Actual values may differ as additional data becomes available. No definitive statements can be made regarding type conformity, processing capability, or long-term performance under various conditions. Customers are solely responsible for evaluating suitability for their intended production and application parameters. Covestro disclaims all warranties, express or implied, and accepts no liability for damages or losses resulting from reliance on preliminary data.

### Typical Value

These values are provided as typical data only and do not constitute binding specifications or warranted performance, unless explicitly agreed by Covestro in writing. Performance may vary depending on factors including, but not limited to, mold/die, processing conditions and coloring/pigmentation. Unless otherwise stated, values are based on standardized test specimens at room temperature.

### Sample

Samples provided by Covestro are intended solely for evaluation and testing purposes by the customer and may not be used in commercial applications, resold, transferred to third parties (except qualified testing service providers acting on behalf of the customer), reverse engineered, modified, or used in any manner not explicitly authorized in writing by Covestro. Samples are provided 'as-is' without any warranties, express or implied, including fitness for a particular purpose. Customers are solely responsible for ensuring safe handling, regulatory compliance, and suitability of the material for their intended evaluations. Covestro disclaims all liability for damages or losses arising from the use of samples.

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# Makrolon® IFR6555

Designation according to ISO 1043: PC FR



## Recommended Processing and Drying Conditions

The recommended processing and drying conditions are provided for reference only and do not constitute binding specifications or warranted values. Barrel temperatures are based on a standard 3-zone barrel; other configurations may require different settings. Values for hold pressure as a percentage of injection pressure may vary depending on part geometry, injection molding machine, and injection mold. Drying conditions are specified for dry air dryers only; drying times and temperatures may differ depending on the dryer type.

Processors are solely responsible for validating and optimizing processing parameters for their specific equipment and applications. To the maximum extent permitted by law, Covestro disclaims all liability for performance outcomes or damages resulting from reliance on these recommended conditions.

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## Contact Information

Please use our [contact form](#) or contact us directly by sending an e-mail to [technical-datasheets@cx.covestro.com](mailto:technical-datasheets@cx.covestro.com).

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