



made of
makrolon[®]
High-tech plastic from Bayer

Optical Grade Product Data

MAKROLON[®] OP

MAKROLON[®] OP polycarbonate sheet is a clear, polished surface, UV stabilized sheet for use in premium visual applications. Offering high performance coupled with excellent optical clarity, MAKROLON OP polycarbonate sheet meets or exceeds the physical properties of any product in its class. This superior performance is backed by a comprehensive product warranty.

APPLICATIONS

MAKROLON OP polycarbonate sheet is manufactured to stringent visual specifications. Typical applications include aftermarket automotive parts, military vehicle glazing, laminated security glazing, and other demanding applications requiring low distortion with optimal visual quality.

Typical Physical Properties			
Property	Test Method	Units	MAKROLON
PHYSICAL			
Specific Gravity	ASTM D792	-	1.2
Refractive Index @ 72°F	ASTM D542	-	1.586
Light Transmission, Clear 1/8"	ASTM D1003	%	86
Light Transmission, Gray/Bronze	ASTM D1003	%	50
Light Transmission, Dark Gray	ASTM D1003	%	18
Rockwell Hardness	ASTM D785	-	M70/R118
Water Absorption, Equilibrium, 24 hrs	ASTM D570	%	0.15
MECHANICAL			
Tensile Strength, Yield	ASTM D638	psi	9000
Tensile Strength, Ultimate	ASTM D638	psi	9500
Tensile Modulus	ASTM D638	psi	345000
Flexural Strength	ASTM D790	psi	13500
Flexural Modulus	ASTM D790	psi	345000
Compressive Strength	ASTM D695	psi	12500
Compressive Modulus	ASTM D695	psi	345000
Elongation	ASTM D638	%	110
Poisson's Ratio	-	-	0.38
Izod Impact Strength, Notched @ 1/8"	ASTM D256	Ft-lbs/in	12-16
Izod Impact Strength, Unnotched @ 1/8"	ASTM D256	Ft-lbs/in	60 (No failure)
Instrumented Impact, 1/8"	ASTM D3763	Ft-lbs	>45
Shear Strength, @ Yield	ASTM D732	psi	6000
Shear Strength, Ultimate	ASTM D732	psi	10000
Shear Modulus	ASTM D732	psi	114000
THERMAL			
Coefficient of Thermal Expansion	ASTM D696	In/in/F	3.75 x 10 ⁻⁵
Coefficient of Thermal Conductivity	ASTM C177	Btu-in/hr-ft ² -F	1.35
Heat Deflection Temperature, @ 264 psi	ASTM D648	F	270
Heat Deflection Temperature, @ 66 psi	ASTM D648	F	280
Brittle Temperature	ASTM D746	F	-200
Shading Coefficient, Clear 1/8"	ASHRAE	-	1.02
Shading Coefficient Gray, Bronze 1/8"	ASHRAE	-	0.7
U Value 1/4" (summer gain, winter loss)	-	-	0.90, 0.96

Sheffield Plastics Inc. will not be responsible for the use of this information relative to actual application. Users must make their own determination of its suitability for their specific application. No warranty is made for the fitness of any product, and nothing herein waives any of the seller's conditions of sale.

Product Data

MAKROLON® OP

HIGH IMPACT STRENGTH

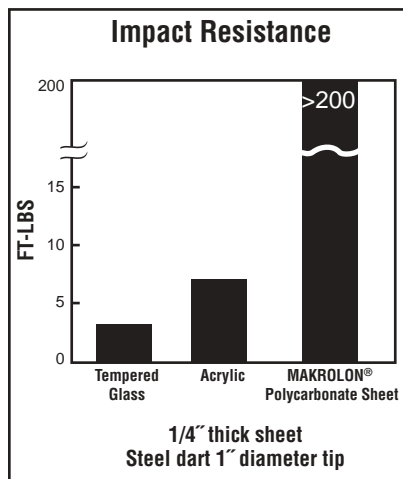
MAKROLON polycarbonate sheet is virtually unbreakable with 250 times the impact strength of float glass and 30 times that of acrylic.

CODE COMPLIANCE

MAKROLON polycarbonate sheet products satisfy major building code requirements for a CC-1 rating in construction applications (BOCA, ICBO, SBCCI, and Dade County). MAKROLON polycarbonate sheet products are listed with Underwriters Laboratories for the UL flammability standard and the UL972 standard for burglary resistant glazing materials. Additionally, MAKROLON polycarbonate sheet is approved for Consumer Product Safety Commission (CPSC 16CFR 1201) categories I & II and ANSI Z97.1-1984 Safety Glazing Standards.

Typical Physical Properties (continued)

Property	Test Method	Units	MAKROLON
ELECTRICAL			
Dielectric Constant, @ 10 Hz	ASTM D150	-	2.96
Dielectric Constant, @ 60 Hz	ASTM D150	-	3.17
Volume Resistivity	ASTM D257	Ohm-cm	8.2 x 10 ¹⁶
Dissipation Factor, @ 60 Hz	ASTM D150	-	0.0009
Dissipation Factor, @ 1 MHz	ASTM D150	-	0.01
Arc Resistance	ASTM D495	Seconds	
Stainless Steel Strip Electrode			10-11
Tungsten Electrodes			120
Dielectric Strength, in air, 125 mils	ASTM D149	V/mil	380
FLAMMABILITY			
Horizontal Burn, AEB	ASTM D635	Inches	<1
Ignition Temperature, Self	ASTM D1929	F	1070
Ignition Temperature, Flash	ASTM D1929	F	870
UL 94, Clear @ .060"	UL 94	-	V2
UL 94, Clear @ .220"	UL 94	-	V0



For additional information please call the Sheffield Plastics Customer Service at: 800-254-1707.



MAKOP3/03



Sheffield
Plastics Inc.

A Bayer Polymers Company

119 Salisbury Road
Sheffield, MA 01257
800-254-1707

FAX: 800-457-3553

Web site: sheffieldplastics.com