



Covestro LLC
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Product Quality Specification Sheet

Product	Makrolon®	Grade	15 Polycarbonate Sheet
PRODUCT DESCRIPTION	Makrolon® 15 polycarbonate sheet is manufactured for use in applications where a long-term weatherable polycarbonate sheet is required.		

Gauge	.236" - .500"		
TOLERANCE	Gauge	+/- 5% of nominal	
	Standard Size	48" x 96", 60" x 96", 72" x 96"	
	Length and Width	+ 5/8", -0"	

WARP	Sheet to be flat within 1" when measured with the sheet placed on a flat surface.
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SQUARE:	If Length and Width are < 48" then 1/8" maximum, ≥ 48" then 1/4" maximum.
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EXTERNAL DEFECTS Maximum per ft ²	Die/burn lines - None shall be visible from three-foot viewing distance in reflected or transmitted light.				
	SCRATCHES	LENGTH		WIDTH	MAXIMUM DEFECTS/ft ²
		>1.5"		<.010"	0
		.5" - 1.5"		<.010"	1
	.25" - .5"		<.010"	4	
	SURFACE DEFECTS	SIZE		.236" - .312"	.375" - .500"
		.032" - .065" (Major)		1	3
		.020" - .031" (Major)		5	8
		.010" - .019" (Minor)		Not Counted	Not Counted
	LINT	Length	Width	.236" - .312"	.375" - .500"
>.5"		<.30" (Major)	0	0	
≤.5"		<.20" (Minor)	2	2	

INTERNAL DEFECTS Maximum per ft ²	Black Specks		
	SIZE	.236" .312"	.375"- .500"
	.032" - .065" (Major)	1	1
	.020" - .031" (Major)	4	6
	.010" - .019" (Minor)	Not Counted	Not Counted
No clusters of 3 or more above .019" in a 1" circle.			