

Makroblend® UT235 M

Polycarbonate + PET

Covestro - Polycarbonates

Message:

(PC+PET)-blend, mineral filled, easy flow, low coefficient of linear thermal expansion, easy release, injection molding. Molded parts from UT235M having exceptional dimensional stability.

General Information			
Filler / Reinforcement	Mineral,15% Filler by Weight		
Features	Good Dimensional Stability		
	Good Flow		
	Good Mold Release		
	Low CLTE		
RoHS Compliance	RoHS Compliant		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density (23°C)	1.34	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (270°C/5.0 kg)	39.0	cm ³ /10min	ISO 1133
Molding Shrinkage ¹			ISO 2577
Across Flow : 270°C, 3.00 mm	0.50 to 0.60	%	
Flow : 270°C, 3.00 mm	0.50 to 0.60	%	
Water Absorption			ISO 62
Saturation, 23°C	0.40	%	
Equilibrium, 23°C, 50% RH	0.20	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	4500	MPa	ISO 527-2/1
Tensile Stress			ISO 527-2/5
Yield, 23°C	68.0	MPa	
Break, 23°C	67.0	MPa	
Tensile Strain			ISO 527-2/5
Yield, 23°C	3.5	%	
Break, 23°C	4.0	%	
Flexural Modulus ² (23°C)	4650	MPa	ISO 178
Flexural Stress ³			ISO 178
23°C	115	MPa	
3.5% Strain,23°C	110	MPa	
Flexural Strain at Flexural Strength ⁴ (23°C)	5.0	%	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Unnotched Impact Strength			ISO 179/1eU

-30°C	85	kJ/m ²	
23°C	85	kJ/m ²	
Unnotched Izod Impact Strength			ISO 180
-30°C	85	kJ/m ²	
23°C	85	kJ/m ²	
Multi-Axial Instrumented Impact Energy (23°C)	36.0	J	ISO 6603-2
Multi-Axial Instrumented Impact Peak Force (23°C)	4500	N	ISO 6603-2
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, Unannealed	128	°C	ISO 75-2/B
1.8 MPa, Unannealed	114	°C	ISO 75-2/A
Vicat Softening Temperature	139	°C	ISO 306/B120
CLTE			ISO 11359-2
Flow : 23 to 85°C	4.5E-5	cm/cm/°C	
Transverse : 23 to 85°C	4.8E-5	cm/cm/°C	
NOTE			
1.	150x105x3 mm, 70°C MT, 600 bar		
2.	2.0 mm/min		
3.	2.0 mm/min		
4.	2 mm/min		

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