Makroblend® DP7645

Polycarbonate + PET

Covestro - Polycarbonates

Message:

(PC+PET) blend, impact modified, Injection molding grade, unreinforced

General Information			
Additive	Impact Modifier		
Features	Impact Modified		
RoHS Compliance	RoHS Compliant		
Processing Method	Injection Molding		
Physical	**Nominal Value**	**Unit**	**Test Method**
Density (23°C)	1.20	g/cm³	ISO 1183
Apparent Density	0.70	g/cm³	ISO 60
Melt Volume-Flow Rate (MVR) (260°C/5.0 kg)	12.0	cm³/10min	ISO 1133
Molding Shrinkage			ISO 2577
Across Flow [1]	0.60 to 0.80	%	
Across Flow : 90°C, 1 hr	0.10 to 0.20	%	
Flow [2]	0.60 to 0.80	%	
Flow : 90°C, 1 hr	0.10 to 0.20	%	
Hardness	**Nominal Value**	**Unit**	**Test Method**
Ball Indentation Hardness	100	MPa	ISO 2039-1
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus (23°C)	2100	MPa	ISO 527-2/1
Tensile Stress			ISO 527-2/50
Yield, 23°C	50.0	MPa	
Break, 23°C	40.0	MPa	
Tensile Strain (Yield, 23°C)	4.5	%	ISO 527-2/50
Nominal Tensile Strain at Break (23°C)	> 50	%	ISO 527-2/50
Flexural Modulus [3] (23°C)	2100	MPa	ISO 178
Flexural Stress [4]			ISO 178
23°C	75.0	MPa	
3.5% Strain,23°C	65.0	MPa	
Flexural Strain at Flexural Strength [5] (23°C)	5.7	%	ISO 178
Burning Rate - US-FMVSS (> 1.00 mm)	passed		ISO 3795
Gottfert Melt Viscosity [6] (260°C)	600	Pa·s	Internal Method
ISO Shortname	ISO 7792-PC/PET,MHPR,-020		
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Notched Impact Strength (23°C)	55	kJ/m²	ISO 179/1eA

Charpy Unnotched Impact Strength			ISO 179/1eU
-30°C	No Break		
23°C	No Break		
Notched Izod Impact Strength			ISO 180/A
-20°C	23	kJ/m²	
-10°C	45	kJ/m²	
23°C	50	kJ/m²	
Unnotched Izod Impact Strength			ISO 180
-30°C	No Break		
23°C	No Break		
Thermal	**Nominal Value**	**Unit**	**Test Method**
Heat Deflection Temperature (1.8 MPa, Unannealed)	94.0	°C	ISO 75-2/A
Vicat Softening Temperature	133	°C	ISO 306/B120
CLTE			ISO 11359-2
Flow : 23 to 55°C	7.0E-5	cm/cm/°C	
Transverse : 23 to 55°C	7.0E-5	cm/cm/°C	
Thermal Conductivity [7] (23°C)	0.20	W/m/K	ISO 8302
Flammability	**Nominal Value**	**Unit**	**Test Method**
Flame Rating			UL 94
0.800 mm	HB		
1.60 mm	HB		
Oxygen Index [8]	20	%	ISO 4589-2
NOTE			
1.	600 bar		
2.	600 bar		
3.	2.0 mm/min		
4.	2.0 mm/min		
5.	2 mm/min		
6.	165/s		
7.	Cross-flow		
8.	Procedure A		

Recommended distributors for this material

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