

Makrolon® AX2675

聚碳酸酯

Covestro - Polycarbonates

Technical Data			
Product Description			
MVR (300°C/1.2 kg) 12 cm³/10 min; medium viscosity; easy release; injection molding - melt temperature 280 - 320°C; available in black colors only; automotive exterior roof trim + pillar appliques; optimized and especially suitable for high-gloss surfaces with highest requirements "Piano-black"; tailored for the use in combination with Polysiloxan coatings			
General			
Features	• 高光	• 脱模性能良好	• 中等粘性
Uses	• 汽车领域的应用	• 汽车外部零件	• 汽车外部装饰
RoHS Compliance	• RoHS 合规		
Appearance	• 黑色	• 可用颜色	
Processing Method	• 注射成型		
Physical		额定值 单位制	测试方法
Density (23°C)		1.20 g/cm³	ISO 1183
Apparent (Bulk) Density ³		0.66 g/cm³	ISO 60
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)		13 g/10 min	ISO 1133
Melt Volume-Flow Rate (MVR) (300°C/1.2 kg)		12 cm³/10min	ISO 1133
Molding Shrinkage			
垂直		0.60 到 0.80 %	ISO 2577
流动		0.60 到 0.80 %	ISO 2577
垂直 : 280°C, 2.00 mm ⁴		0.75 %	ISO 294-4
流动 : 2.00 mm ⁴		0.70 %	ISO 294-4
Water Absorption			ISO 62
饱和, 23°C		0.30 %	
平衡, 23°C, 50% RH		0.12 %	
Mechanical		额定值 单位制	测试方法
Tensile Modulus (23°C)		2400 MPa	ISO 527-2/1
Tensile Stress			ISO 527-2/50
屈服, 23°C		65.0 MPa	
断裂, 23°C		69.0 MPa	
Tensile Strain			ISO 527-2/50
屈服, 23°C		6.0 %	
断裂, 23°C		120 %	
Nominal Tensile Strain at Break (23°C)		> 50 %	ISO 527-2/50
Flexural Modulus ⁵ (23°C)		2400 MPa	ISO 178
Flexural Stress ⁵			ISO 178
23°C		98.0 MPa	
3.5% Strain, 23°C		74.0 MPa	
Flexural Strain at Flexural Strength ⁶ (23°C)		7.1 %	ISO 178
Films		额定值 单位制	测试方法
Water Vapor Transmission Rate			ISO 15106-1
23°C, 85% RH, 100 µm		15 g/m²/24 hr	



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Impact	额定值 单位制	测试方法
Charpy Notched Impact Strength ⁷		ISO 179/1eA
-30°C, 完全断裂	16 kJ/m²	
23°C, 局部断裂	70 kJ/m²	
Charpy Unnotched Impact Strength		ISO 179/1eU
-60°C	无断裂	
-30°C	无断裂	
23°C	无断裂	
Notched Izod Impact Strength ⁷		ISO 180/A
-30°C, 完全断裂	14 kJ/m²	
23°C, 局部断裂	70 kJ/m²	
Multi-Axial Instrumented Impact Energy		ISO 6603-2
-30°C	60.0 J	
23°C	55.0 J	
Multi-Axial Instrumented Impact Peak Force		ISO 6603-2
-30°C	6100 N	
23°C	5200 N	
Hardness	额定值 单位制	测试方法
Ball Indentation Hardness	115 MPa	ISO 2039-1
Thermal	额定值 单位制	测试方法
Heat Deflection Temperature		
0.45 MPa, 未退火	136 °C	ISO 75-2/B
1.8 MPa, 未退火	124 °C	ISO 75-2/A
Glass Transition Temperature ⁸	143 °C	ISO 11357-2
Vicat Softening Temperature		
--	144 °C	ISO 306/B120
--	143 °C	ISO 306/B50
Ball Pressure Test (135°C)	通过	IEC 60695-10-2
CLTE		ISO 11359-2
流动 : 23 到 55°C	6.5E-5 cm/cm/°C	
垂直 : 23 到 55°C	6.5E-5 cm/cm/°C	
Thermal Conductivity ⁹ (23°C)	0.20 W/m/K	ISO 8302
RTI Elec (1.5 mm)	125 °C	UL 746
RTI Imp (1.5 mm)	115 °C	UL 746
RTI Str (1.5 mm)	125 °C	UL 746
Electrical	额定值 单位制	测试方法
Surface Resistivity	1.0E+16 ohms	IEC 60093
Volume Resistivity (23°C)	1.0E+16 ohms·cm	IEC 60093
Electric Strength (23°C, 1.00 mm)	34 kV/mm	IEC 60243-1
Relative Permittivity		IEC 60250
23°C, 100 Hz	3.10	
23°C, 1 MHz	3.00	
Dissipation Factor		IEC 60250
23°C, 100 Hz	5.0E-4	
23°C, 1 MHz	9.0E-3	
Comparative Tracking Index		IEC 60112
解决方案 A	250 V	
解决方案 B	125 V	
Flammability	额定值 单位制	测试方法
Application of Flame from Small Burner ¹⁰	K1, F1	DIN 53438-1, -3
Flash Ignition Temperature	480 °C	ASTM D1929
Self Ignition Temperature	550 °C	ASTM D1929
燃烧速率 ¹¹ (> 1.00 mm)	passed	ISO 3795



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Additional Information		额定值 单位制	测试方法
Electrolytical Corrosion (23°C)		A1	IEC 60426
ISO Shortname		ISO 7391-PC,MR,(,)-18-9	
Injection		额定值 单位制	
Drying Temperature - Dry Air Dryer		120 °C	
Drying Time - Dry Air Dryer		4.0 hr	
Suggested Max Moisture		< 0.020 %	
Suggested Shot Size		30 到 70 %	
Rear Temperature		250 到 270 °C	
Middle Temperature		270 到 290 °C	
Front Temperature		285 到 305 °C	
Nozzle Temperature		270 到 305 °C	
Processing (Melt) Temp		280 到 320 °C	
Mold Temperature		70 到 110 °C	
Back Pressure		10.0 到 20.0 MPa	
Vent Depth		0.025 到 0.075 mm	
Injection Notes			
Peripheral Screw Speed: 0.05 - 0.2 m/s			
Hold Pressure (% of Injection Pressure): 50 - 75%			
Standard Melt Temperature: 300°C			

