

Makroblend DP 7645

PC+PET Blends, elastomer modified / Non reinforced

(PC/PET)-blends, impact modified, Injection molding grade, unreinforced

ISO Shortname

ISO 7792-PC/PET,MHPR,-020

Property	Test Condition	Unit	Standard	Value
Rheological properties				
Göfftert melt viscosity	165 s ⁻¹ ; 260 °C	Pa·s	Bayer test	600
C Melt volume-flow rate	260 °C; 5 kg	cm ³ /10 min	ISO 1133	12
Molding shrinkage, parallel/normal	Value range based on general practical experience (600bar)	%	b.o. ISO 2577	0,6 - 0,8
Post- shrinkage, parallel/normal	Value range based on general practical experience (1h; 90°C)	%	b.o. ISO 2577	0,1 - 0,2
Mechanical properties (23 °C/50 % r. h.)				
C Tensile modulus	1 mm/min	MPa	ISO 527-1,-2	2100
C Yield stress	50 mm/min	MPa	ISO 527-1,-2	50
C Yield strain	50 mm/min	%	ISO 527-1,-2	4.5
C Nominal strain at break	50 mm/min	%	ISO 527-1,-2	> 50
Stress at break	50 mm/min	MPa	ISO 527-1,-2	40
C Charpy impact strength	23 °C	kJ/m ²	ISO 179/1eU	N
C Charpy impact strength	-30 °C	kJ/m ²	ISO 179/1eU	N
C Charpy notched impact strength	23 °C	kJ/m ²	ISO 179/1eA	55
Izod impact strength	23 °C	kJ/m ²	ISO 180/U	N
Izod impact strength	-30 °C	kJ/m ²	ISO 180/U	N
Izod notched impact strength	23 °C	kJ/m ²	ISO 180/A	50
Izod notched impact strength	-10 °C	kJ/m ²	ISO 180/A	45
Izod notched impact strength	-20 °C	kJ/m ²	ISO 180/A	23
Flexural modulus	2 mm/min	MPa	ISO 178	2100
Flexural strength	2 mm/min	MPa	ISO 178	75
Flexural strain at flexural strength	2 mm/min	%	ISO 178	5.7
Flexural stress at 3.5 % strain	2 mm/min	MPa	ISO 178	65
Ball indentation hardness		N/mm ²	ISO 2039-1	100
Thermal properties				
C Temperature of deflection under load	1.80 MPa	°C	ISO 75-1,-2	94
Vicat softening temperature	50 N; 120 °C/h	°C	ISO 306	133
C Coefficient of linear thermal expansion, parallel	23 to 55 °C	10 ⁻⁴ /K	ISO 11359-1,-2	0.7
C Coefficient of linear thermal expansion, transverse	23 to 55 °C	10 ⁻⁴ /K	ISO 11359-1,-2	0.7
C Burning behavior UL 94 (1.5 mm)	1.6 mm	Class	UL 94	HB
C Burning behavior UL 94	0.8 mm	Class	UL 94	HB
C Oxygen index	Method A	%	ISO 4589-2	20
Thermal conductivity	23 °C	W/(m·K)	ISO 8302	0.2
Burning rate (US-FMVSS)	>=1.0 mm	mm/min	ISO 3795	passed
Other properties (23 °C)				
C Density		kg/m ³	ISO 1183	1200
Bulk density		g/cm ³	ISO 60	0,7
Processing conditions for test specimens				
C Injection molding-Melt temperature		°C	ISO 294	270
C Injection molding-Mold temperature		°C	ISO 294	70
C Injection molding-Injection velocity		mm/s	ISO 294	200

C These property characteristics are taken from the CAMPUS plastics data bank and are based on the international catalogue of basic data for plastics according to ISO 10350.