

Makroblend® AR205 (PC+PET)-I

Covestro Deutschland AG

- (PC PET) blend, easy flow, impact modified
- application: automotive body panels

Rheological properties	Value	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	38	cm³/10min	ISO 1133
Temperature	270	°C	-
Load	5	kg	-

Mechanical Properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	2200	MPa	ISO 527
Yield stress	54	MPa	ISO 527
Yield strain	4.8	%	ISO 527
Nominal strain at break	>50	%	ISO 527
Impact Strength (Charpy), +23°C	no break	kJ/m²	ISO 179/1eU
Impact Strength (Charpy), -30°C	no break	kJ/m²	ISO 179/1eU
Notched Impact Strength (Charpy), +23°C	45	kJ/m²	ISO 179/1eA
Notched Impact Strength (Charpy), -30°C	20	kJ/m²	ISO 179/1eA
Puncture - maximum force, +23°C	3900	N	ISO 6603-2
Puncture - maximum force, -30°C	5000	N	ISO 6603-2
Puncture energy, +23°C	42	J	ISO 6603-2
Puncture energy, -30°C	48	J	ISO 6603-2

Thermal Properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load (1.80 MPa)	98	°C	ISO 75-1/-2
Temp. of deflection under load (0.45 MPa)	126	°C	ISO 75-1/-2
Coeff. of Linear Therm. Expansion, parallel	81	E-6/K	ISO 11359-1/-2
Coeff. of Linear Therm. Expansion, normal	82	E-6/K	ISO 11359-1/-2

Other Properties	Value	Unit	Test Standard
ISO Data			
Density	1210	kg/m³	ISO 1183

Test specimen production	Value	Unit	Test Standard
ISO Data			
Injection Molding, melt temperature	270	°C	ISO 294
Injection Molding, mold temperature	70	°C	ISO 294
Injection Molding, injection velocity	200	mm/s	ISO 294

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	110	°C	-
Pre-drying - Time	2 - 4	h	-
Processing humidity	≤0.01	%	-
Melt temperature	260 - 280	°C	-
Mold temperature	60 - 80	°C	-

Characteristics

Processing

Injection Molding

Additives

Release agent

Delivery form

Pellets

Special Characteristics

Impact modified

Injection Molding

PREPROCESSING

Max. Water content: 0.01 %

Drying temperature: 110 °C

Drying time:

Circulating air drying oven (50 % fresh air) 4-12 h
Fresh air dryer (high speed dryer) 2-4 h
Dry air dryer 2-4 h

PROCESSING

Melt temperature: 260-280 °C
Mold temperature: 60-80 °C

Use open nozzle.

Disclaimer

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