

Makroblend® KU2-7609 (PC+PBT)-I-T20

Covestro Deutschland AG

- (PC PBT)-blend, impact modified, Injection molding grade, 20% mineral filled, applications: automotive exterior body panels

Rheological properties	Value	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	11	cm³/10min	ISO 1133
Temperature	260	°C	-
Load	5	kg	-

Mechanical Properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	3600	MPa	ISO 527
Impact Strength (Charpy), +23°C	155	kJ/m²	ISO 179/1eU
Impact Strength (Charpy), -30°C	115	kJ/m²	ISO 179/1eU
Notched Impact Strength (Charpy), +23°C	10	kJ/m²	ISO 179/1eA

Thermal Properties	Value	Unit	Test Standard
ISO Data			
Melting Temperature (10°C/min)	221	°C	ISO 11357-1/-3
Temp. of deflection under load (1.80 MPa)	93	°C	ISO 75-1/-2
Temp. of deflection under load (0.45 MPa)	106	°C	ISO 75-1/-2
Coeff. of Linear Therm. Expansion, parallel	70	E-6/K	ISO 11359-1/-2
Coeff. of Linear Therm. Expansion, normal	70	E-6/K	ISO 11359-1/-2
Burning Behav. at 1.5 mm Nom. Thickn.	HB	class	UL 94
Thickness tested	1.6	mm	-
Burning Behav. at thickness h	HB	class	UL 94
Thickness tested	0.8	mm	-
Oxygen index	21	%	ISO 4589-1/-2

Electrical Properties	Value	Unit	Test Standard
ISO Data			
Relative permittivity, 100Hz	3.2	-	IEC 62631-2-1
Relative permittivity, 1MHz	3.1	-	IEC 62631-2-1
Dissipation Factor, 100Hz	26	E-4	IEC 62631-2-1
Dissipation Factor, 1MHz	95	E-4	IEC 62631-2-1
Volume Resistivity	>1E13	Ohm*m	IEC 62631-3-1
Surface Resistivity	>1E15	Ohm	IEC 62631-3-2
Electric Strength	34	kV/mm	IEC 60243-1
Comparative tracking index	250	-	IEC 60112

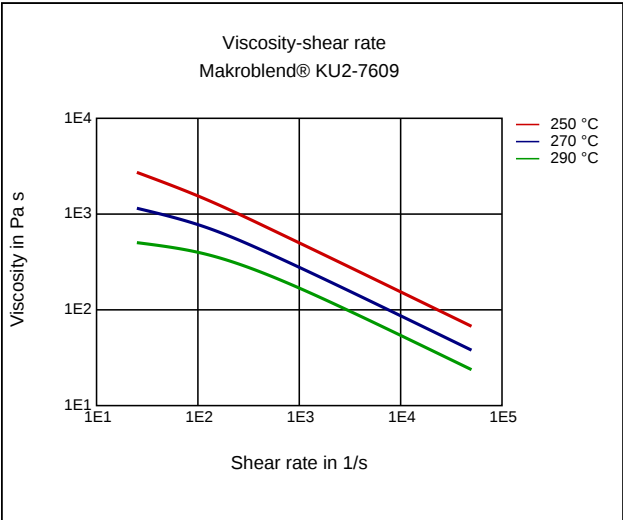
Other Properties	Value	Unit	Test Standard
ISO Data			
Water Absorption	0.8	%	Sim. to ISO 62
Humidity absorption	0.2	%	Sim. to ISO 62
Density	1300	kg/m³	ISO 1183

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

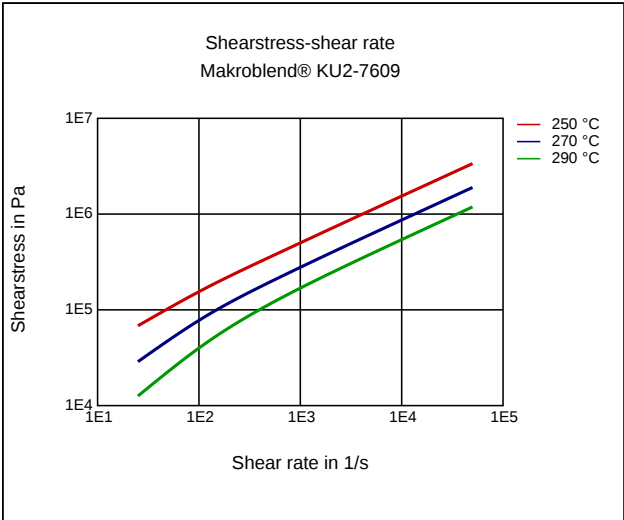
Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	100 - 105	°C	-
Pre-drying - Time	2 - 4	h	-
Processing humidity	≤0.01	%	-
Melt temperature	250 - 270	°C	-
Mold temperature	60 - 80	°C	-

Diagrams

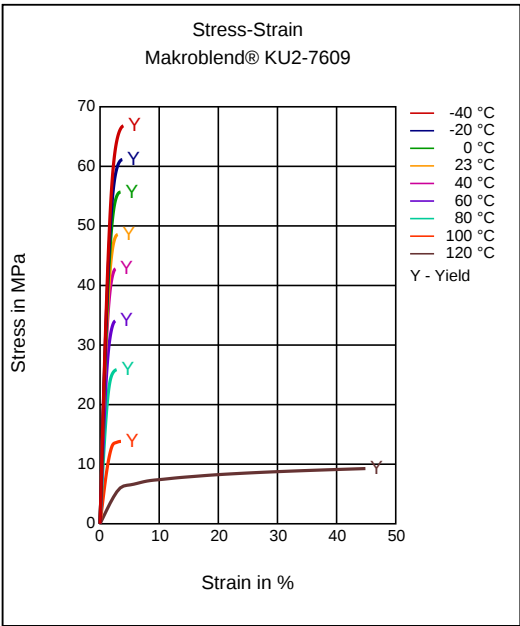
Viscosity-shear rate



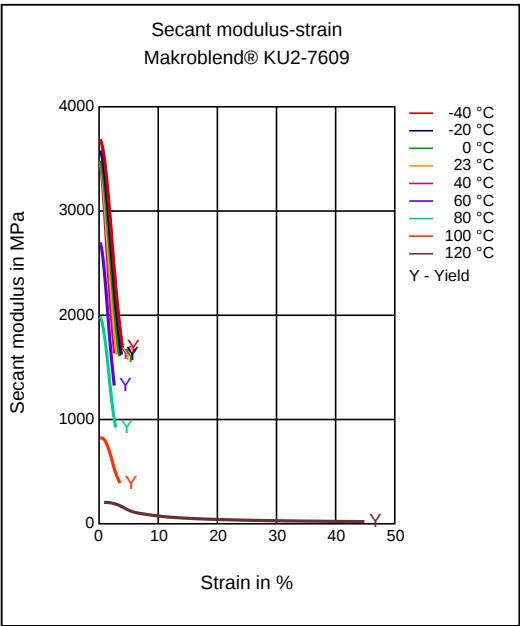
Shearstress-shear rate



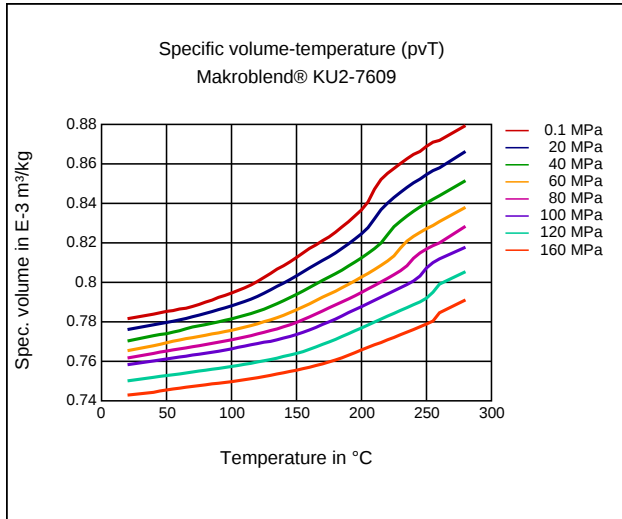
Stress-strain



Secant modulus-strain



Specific volume-temperature (pvT)



Characteristics

Processing

Injection Molding

Additives

Release agent

Delivery form

Pellets

Special Characteristics

Impact modified

Injection Molding

PREPROCESSING

Max. Water content: 0.01 %

Drying temperature: 100 - 105 °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: 250-270 °C

Mold temperature: 60-80 °C

Use open nozzle.

Disclaimer

Liability Exclusion

These guide values are measured and provided by the product manufacturer and have been determined on standardised test specimens and can be affected by pigmentation, mould design and processing conditions. M-Base has taken the guide values from the producer's original Technical Data Sheet. **ALBIS AND M-BASE ARE THEREFORE NOT RESPONSIBLE FOR THE ACCURACY OF THE GUIDE VALUES AND CANNOT GIVE ANY WARRANTY WITH REGARD TO THEIR CORRECTNESS.**

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