

Makroblend® UT235 M (PC+PET)-T15

Covestro Deutschland AG

- (PC PET)-blend, 15% mineral filled, easy flow, low coefficient of linear thermal expansion, easy release, injection molding. Molded parts from UT235M having exceptional dimensional stability.

Mechanical Properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	4500	MPa	ISO 527
Stress at Break	67	MPa	ISO 527
Strain at Break	4	%	ISO 527
Impact Strength (Charpy), +23°C	85	kJ/m ²	ISO 179/1eU
Impact Strength (Charpy), -30°C	85	kJ/m ²	ISO 179/1eU
Puncture - maximum force, +23°C	4500	N	ISO 6603-2
Puncture energy, +23°C	36	J	ISO 6603-2

Thermal Properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load (1.80 MPa)	114	°C	ISO 75-1/-2
Temp. of deflection under load (0.45 MPa)	128	°C	ISO 75-1/-2
Coeff. of Linear Therm. Expansion, parallel	45	E-6/K	ISO 11359-1/-2
Coeff. of Linear Therm. Expansion, normal	45	E-6/K	ISO 11359-1/-2

Other Properties	Value	Unit	Test Standard
ISO Data			
Water Absorption	0.4	%	Sim. to ISO 62
Humidity absorption	0.2	%	Sim. to ISO 62
Density	1340	kg/m ³	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

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

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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