

Makrolon® 6487 R30 CQ

PC

Covestro Deutschland AG

Rheological properties	Value	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	11	cm³/10min	ISO 1133
Temperature	300	°C	-
Load	1.2	kg	-

Mechanical Properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	2350	MPa	ISO 527
Yield stress	67	MPa	ISO 527
Yield strain	6	%	ISO 527
Nominal strain at break	>50	%	ISO 527
Stress at Break	67	MPa	ISO 527
Strain at Break	110	%	ISO 527
Impact Strength (Charpy), -30°C	no break	kJ/m²	ISO 179/1eU
Puncture - maximum force, +23°C	5200	N	ISO 6603-2
Puncture - maximum force, -30°C	6100	N	ISO 6603-2
Puncture energy, +23°C	50	J	ISO 6603-2
Puncture energy, -30°C	50	J	ISO 6603-2
Notched Impact Strength (Izod), 23°C	15	kJ/m²	ISO 180/1A

Thermal Properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load (1.80 MPa)	122	°C	ISO 75-1/-2
Temp. of deflection under load (0.45 MPa)	136	°C	ISO 75-1/-2
Vicat softening temperature, 50°C/h 50N	141	°C	ISO 306
Burning Behav. at 1.5 mm Nom. Thickn.	V-0	class	UL 94
Thickness tested	1.5	mm	-
UL recognition	yes	-	-
Burning Behav. at thickness h	V-0	class	UL 94
Thickness tested	3.0	mm	-
UL recognition	yes	-	-
Thickness tested	3.0	mm	-
Glow Wire (GWFI, Flammability Index)	960	°C	IEC 60695-2-12
GWFI - thickness tested (1)	1	mm	-
Glow Wire (GWFI, Flammability Index)	960	°C	IEC 60695-2-12
GWFI - thickness tested (2)	3	mm	-
Burning Behav. 5V at Thickness h	5VA	class	Producer Method

Electrical Properties	Value	Unit	Test Standard
ISO Data			
Relative permittivity, 100Hz	3	-	IEC 62631-2-1
Relative permittivity, 1MHz	3	-	IEC 62631-2-1
Dissipation Factor, 100Hz	7	E-4	IEC 62631-2-1
Dissipation Factor, 1MHz	96	E-4	IEC 62631-2-1
Volume Resistivity	9E16	Ohm*m	IEC 62631-3-1
Surface Resistivity	2E16	Ohm	IEC 62631-3-2
Comparative tracking index	225	-	IEC 60112

Test specimen production	Value	Unit	Test Standard
ISO Data			
Injection Molding, melt temperature	300	°C	ISO 294
Injection Molding, mold temperature	80	°C	ISO 294
Injection Molding, injection velocity	200	mm/s	ISO 294

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	120	°C	-
Pre-drying - Time	2 - 3	h	-
Processing humidity	≤0.02	%	-
Melt temperature	280 - 320	°C	-

Mold temperature	80 - 120	°C	-
Zone 1	250 - 260	°C	-
Zone 2	270 - 280	°C	-
Zone 3	280 - 290	°C	-
Nozzle temperature	290 - 300	°C	-
Back pressure	5 - 15	MPa	-

Characteristics

Processing

Injection Molding

Special Characteristics

Flame retardant, UV stabilized, Opaque

Delivery form

Black

Certifications

Recycled Resin Content

Additives

Release agent

Applications

Electrical and Electronical

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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