

Makrolon® 8025

PC-GF20

Covestro Deutschland AG

- MVR (300 °C/1.2 kg) 6.0 cm³/10 min
- 20 % glass fiber reinforced
- milled fiber
- high viscosity
- easy release
- precision parts

Rheological properties	Value	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	6	cm³/10min	ISO 1133
Temperature	300	°C	-
Load	1.2	kg	-
Molding shrinkage, parallel	0.6	%	ISO 294-4, 2577
Molding shrinkage, normal	0.3	%	ISO 294-4, 2577

Mechanical Properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	4000	MPa	ISO 527
Yield stress	58	MPa	ISO 527
Yield strain	3.5	%	ISO 527
Tensile Creep Modulus, 1h	3700	MPa	ISO 899-1
Tensile Creep Modulus, 1000h	3500	MPa	ISO 899-1
Impact Strength (Charpy), +23°C	55	kJ/m²	ISO 179/1eU
Impact Strength (Charpy), -30°C	65	kJ/m²	ISO 179/1eU
Puncture - maximum force, +23°C	3300	N	ISO 6603-2
Puncture - maximum force, -30°C	2800	N	ISO 6603-2
Puncture energy, +23°C	20	J	ISO 6603-2
Puncture energy, -30°C	10	J	ISO 6603-2

Thermal Properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load (1.80 MPa)	134	°C	ISO 75-1/-2
Temp. of deflection under load (0.45 MPa)	141	°C	ISO 75-1/-2
Vicat softening temperature, 50°C/h 50N	146	°C	ISO 306
Coeff. of Linear Therm. Expansion, parallel	45	E-6/K	ISO 11359-1/-2
Coeff. of Linear Therm. Expansion, normal	55	E-6/K	ISO 11359-1/-2
Burning Behav. at 1.5 mm Nom. Thickn.	V-2	class	UL 94
Thickness tested	1.5	mm	-
Burning Behav. at thickness h	V-1	class	UL 94
Thickness tested	6.0	mm	-
Oxygen index	32	%	ISO 4589-1/-2

Electrical Properties	Value	Unit	Test Standard
ISO Data			
Relative permittivity, 100Hz	3.3	-	IEC 62631-2-1
Relative permittivity, 1MHz	3.3	-	IEC 62631-2-1
Dissipation Factor, 100Hz	10	E-4	IEC 62631-2-1
Dissipation Factor, 1MHz	90	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	36	kV/mm	IEC 60243-1
Comparative tracking index	175	-	IEC 60112

Other Properties	Value	Unit	Test Standard
ISO Data			
Water Absorption	0.24	%	Sim. to ISO 62
Humidity absorption	0.1	%	Sim. to ISO 62
Density	1340	kg/m³	ISO 1183

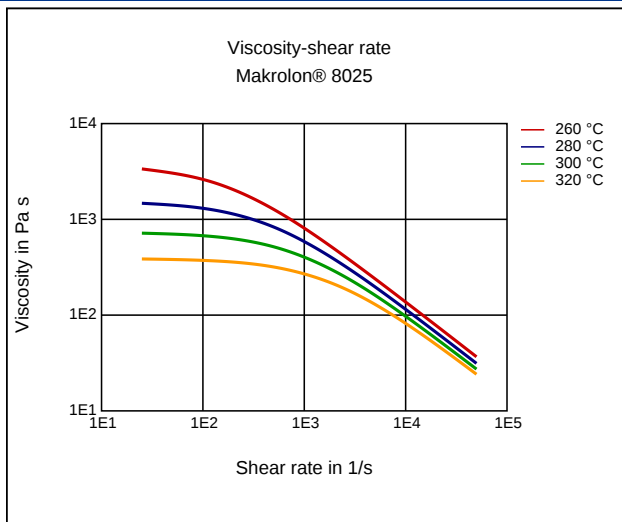
Test specimen production	Value	Unit	Test Standard
ISO Data			

Injection Molding, melt temperature	300	°C	ISO 294
Injection Molding, mold temperature	110	°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	310 - 330	°C	-
Mold temperature	80 - 130	°C	-

Diagrams

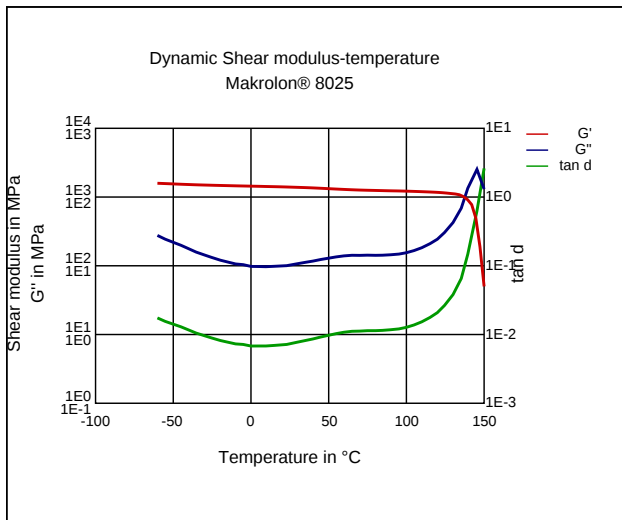
Viscosity-shear rate



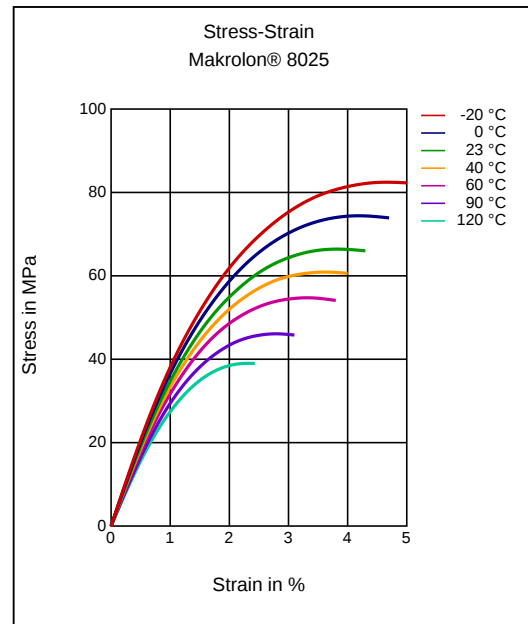
Shearstress-shear rate



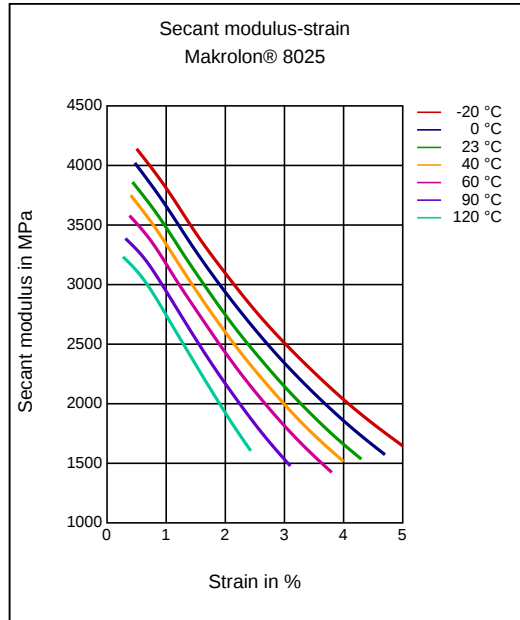
Dynamic Shear modulus-temperature



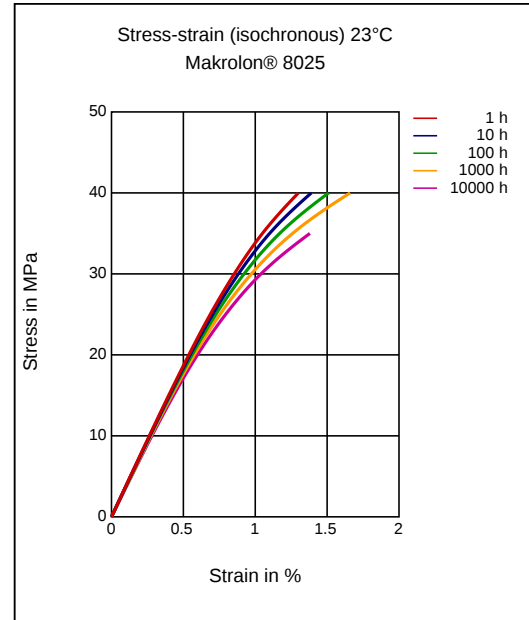
Stress-strain



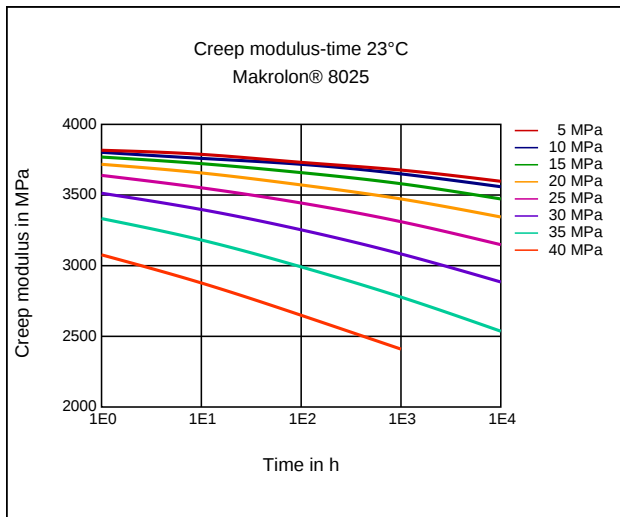
Secant modulus-strain



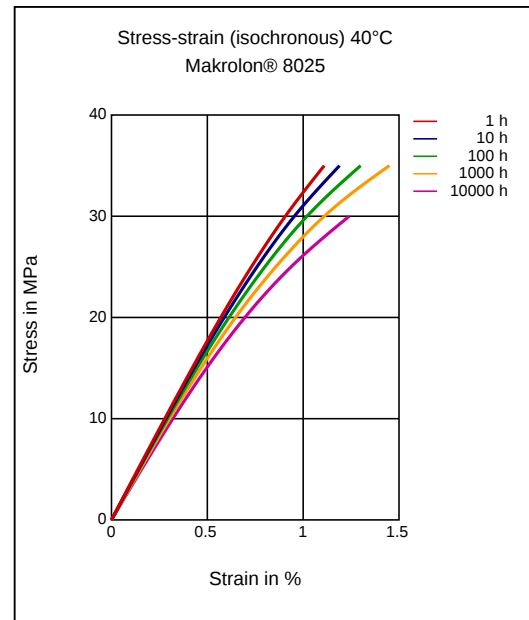
Stress-strain (isochronous) 23 °C



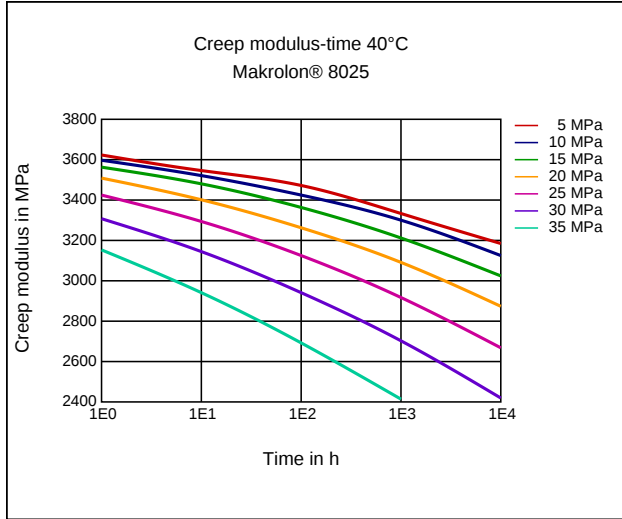
Creep modulus-time 23 °C



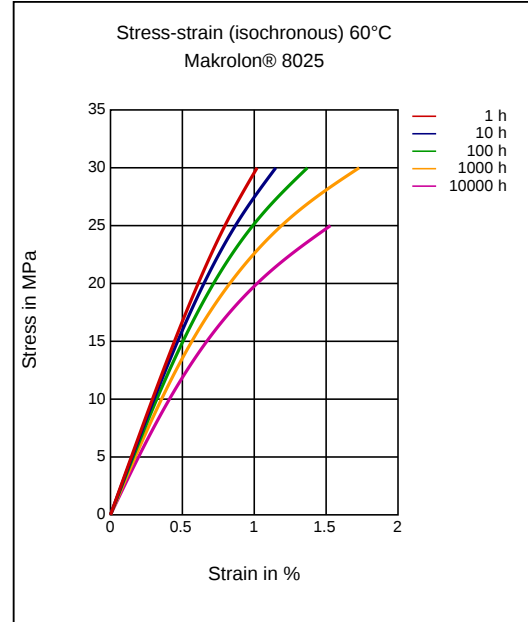
Stress-strain (isochronous) 40 °C



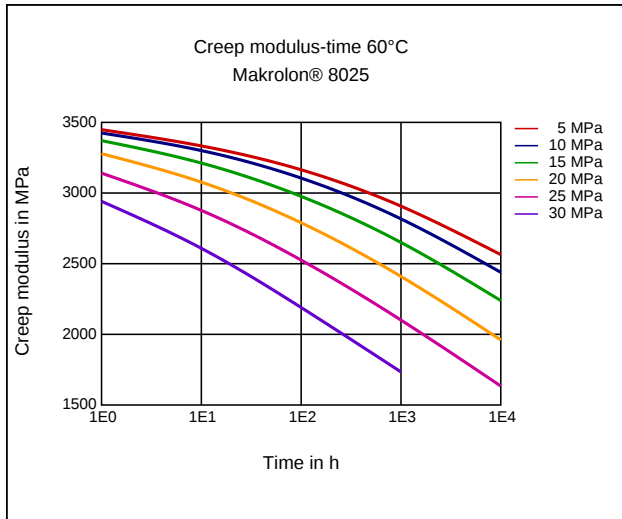
Creep modulus-time 40°C



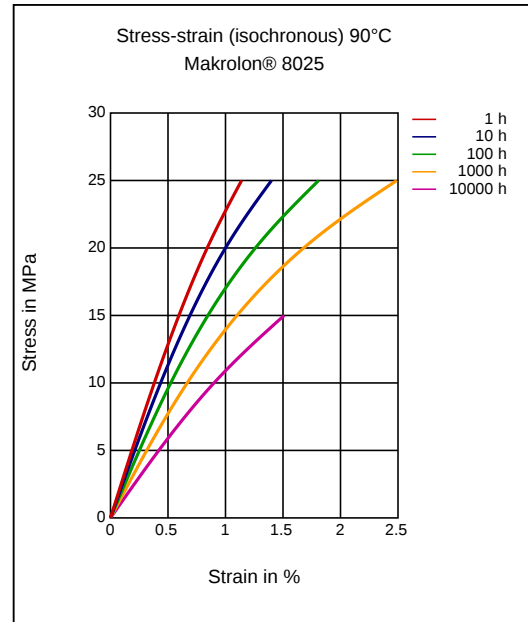
Stress-strain (isochronous) 60°C



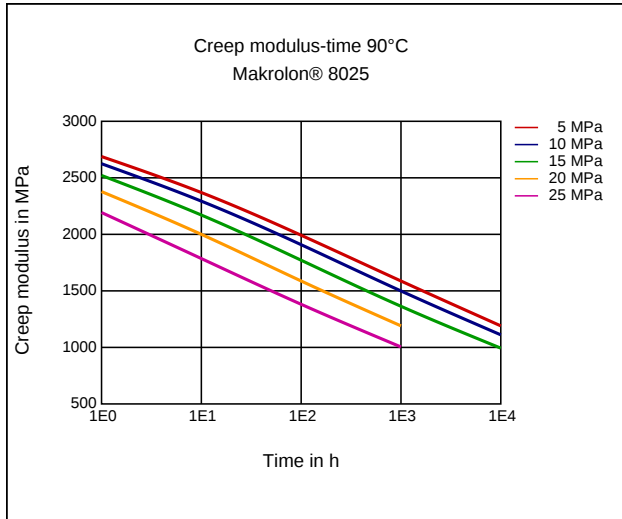
Creep modulus-time 60°C



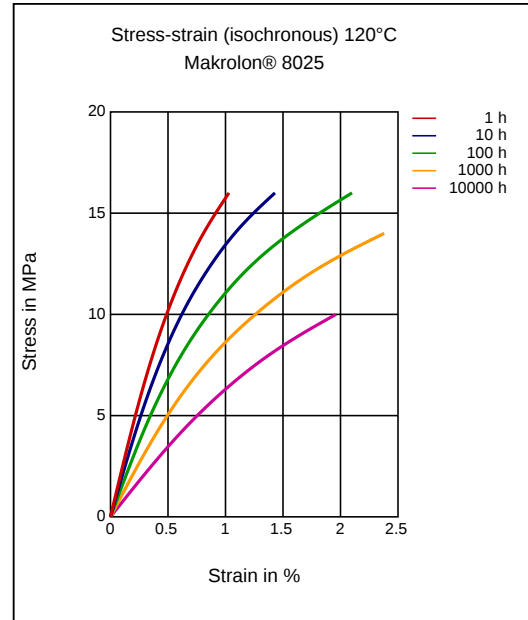
Stress-strain (isochronous) 90°C



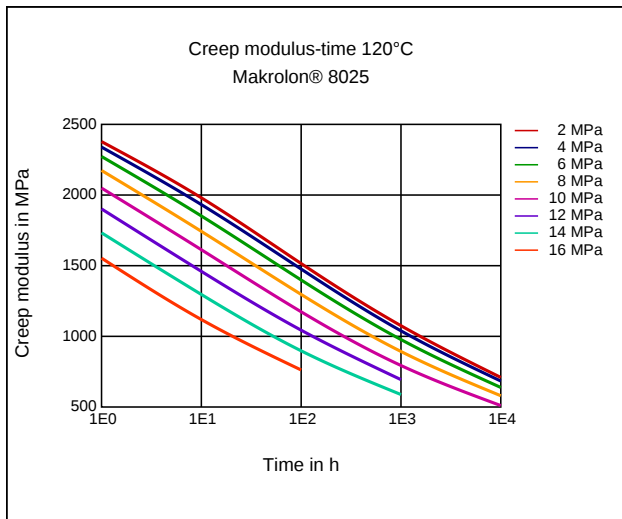
Creep modulus-time 90 °C



Stress-strain (isochronous) 120 °C



Creep modulus-time 120 °C



Characteristics

Processing

Injection Molding, Other Extrusion

Delivery form

Pellets

Additives

Release agent

Special Characteristics

Opaque

Injection Molding

PREPROCESSING

Max. Water content: 0.01 - 0.02 %

Drying temperature: 120 °C

Drying time:

Circulating air drying oven (50 % fresh air) 4-8 h

Fresh air dryer (high speed dryer) 2-4 h

Dry air dryer 2-3 h

PROCESSING

Melt temperature: 310-330 °C

Mold temperature: 80-130 °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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