

**Makrolon® AG2477**

PC

Covestro Deutschland AG

Rheological properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Melt volume-flow rate, MVR	19	cm <sup>3</sup> /10min	ISO 1133
Temperature	300	°C	-
Load	1.2	kg	-
Molding shrinkage, parallel	0.7	%	ISO 294-4, 2577
Molding shrinkage, normal	0.7	%	ISO 294-4, 2577

Mechanical Properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Tensile Modulus	2400	MPa	ISO 527
Yield stress	66	MPa	ISO 527
Yield strain	6	%	ISO 527
Nominal strain at break	>50	%	ISO 527
Stress at Break	65	MPa	ISO 527
Strain at Break	120	%	ISO 527
Impact Strength (Charpy), +23°C	no break	kJ/m <sup>2</sup>	ISO 179/1eU
Impact Strength (Charpy), -30°C	no break	kJ/m <sup>2</sup>	ISO 179/1eU
Flexural Modulus (23°C)	2350	MPa	ISO 178
Flexural strength	98	MPa	ISO 178
Notched Impact Strength (Izod), 23°C	60	kJ/m <sup>2</sup>	ISO 180/1A
Notched Impact Strength (Izod)	12	kJ/m <sup>2</sup>	ISO 180/1A
Temperature	-30	°C	-

Thermal Properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Temp. of deflection under load (1.80 MPa)	124	°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
Coeff. of Linear Therm. Expansion, parallel	65	E-6/K	ISO 11359-1/-2
Coeff. of Linear Therm. Expansion, normal	65	E-6/K	ISO 11359-1/-2

Test specimen production	Value	Unit	Test Standard
<b>ISO Data</b>			
Injection Molding, melt temperature	280	°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**

UV stabilized, Transparent

**Additives**

Release agent

**Applications**

Automotive

**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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