

Makrolon® ET3227 RE

PC

Covestro Deutschland AG

- MVR (300 °C/1.2 kg) 3.0 cm³/10 min
- Extrusion
- high viscosity
- branched
- UV stabilized
- easy release
- multi wall sheets / profiles

Rheological properties	Value	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	3	cm³/10min	ISO 1133
Temperature	300	°C	-
Load	1.2	kg	-
Molding shrinkage, parallel	0.7	%	ISO 294-4, 2577
Molding shrinkage, normal	0.8	%	ISO 294-4, 2577
Melt Flow Index, MFI	3	g/10min	ISO 1133
MFI temperature	300	°C	-
MFI load	1.2	kg	-

Mechanical Properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	2400	MPa	ISO 527
Yield stress	66	MPa	ISO 527
Yield strain	6.2	%	ISO 527
Nominal strain at break	>50	%	ISO 527
Tensile Creep Modulus, 1h	2200	MPa	ISO 899-1
Tensile Creep Modulus, 1000h	1900	MPa	ISO 899-1
Impact Strength (Charpy), +23°C	no break	kJ/m²	ISO 179/1eU
Puncture - maximum force, +23°C	5600	N	ISO 6603-2
Puncture - maximum force, -30°C	6500	N	ISO 6603-2
Puncture energy, +23°C	60	J	ISO 6603-2
Puncture energy, -30°C	65	J	ISO 6603-2
Flexural Modulus (23°C)	2400	MPa	ISO 178
Flexural strength	100	MPa	ISO 178
Notched Impact Strength (Izod), 23°C	65	kJ/m²	ISO 180/1A
Notched Impact Strength (Izod)	20	kJ/m²	ISO 180/1A
Temperature	-30	°C	-
Ball Indentation Hardness	113	MPa	ISO 2039-1

Thermal Properties	Value	Unit	Test Standard
ISO Data			
Glass Transition Temperature (10°C/min)	146	°C	ISO 11357-1/-2
Temp. of deflection under load (1.80 MPa)	128	°C	ISO 75-1/-2
Temp. of deflection under load (0.45 MPa)	140	°C	ISO 75-1/-2
Vicat softening temperature, 50°C/h 50N	146	°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
Burning Behav. at 1.5 mm Nom. Thickn.	HB	class	UL 94
Thickness tested	1.5	mm	-
Burning Behav. at thickness h	HB	class	UL 94
Thickness tested	3.0	mm	-
Oxygen index	28	%	ISO 4589-1/-2
Glow Wire (GWFI, Flammability Index)	875	°C	IEC 60695-2-12
GWFI - thickness tested (1)	0.75	mm	-
Glow Wire (GWFI, Flammability Index)	875	°C	IEC 60695-2-12
GWFI - thickness tested (2)	1.5	mm	-
Glow Wire (GWFI, Flammability Index)	960	°C	IEC 60695-2-12
GWFI - thickness tested (3)	3	mm	-

Electrical Properties	Value	Unit	Test Standard
ISO Data			
Relative permittivity, 100Hz	3.1	-	IEC 62631-2-1

Relative permittivity, 1MHz	3	-	IEC 62631-2-1
Dissipation Factor, 100Hz	8	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	36	kV/mm	IEC 60243-1
Comparative tracking index	250	-	IEC 60112

Other Properties	Value	Unit	Test Standard
ISO Data			
Water Absorption	0.3	%	Sim. to ISO 62
Humidity absorption	0.12	%	Sim. to ISO 62
Density	1200	kg/m³	ISO 1183
Bulk density	660	kg/m³	-

Material Specific Properties	Value	Unit	Test Standard
ISO Data			
Luminous transmittance	88	%	ISO 13468-1, -2

Test specimen production	Value	Unit	Test Standard
ISO Data			
Injection Molding, melt temperature	310	°C	ISO 294
Injection Molding, mold temperature	90	°C	ISO 294
Injection Molding, injection velocity	200	mm/s	ISO 294

Characteristics

Processing

Injection Molding, Profile Extrusion, Sheet Extrusion, Other Extrusion

Delivery form

Pellets

Additives

Release agent

Special Characteristics

UV stabilized

Certifications

Contains renewable resources, ISCC Plus

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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