

**Makrolon® FP2607**
PC

Covestro Deutschland AG

Rheological properties	Value	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	12	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	66	MPa	ISO 527
Yield strain	6	%	ISO 527
Stress at Break	70	MPa	ISO 527
Strain at Break	120	%	ISO 527
Impact Strength (Charpy), +23°C	no break	kJ/m²	ISO 179/1eU
Impact Strength (Charpy), -30°C	no break	kJ/m²	ISO 179/1eU
Puncture - maximum force, +23°C	5400	N	ISO 6603-2
Puncture - maximum force, -30°C	6300	N	ISO 6603-2
Puncture energy, +23°C	60	J	ISO 6603-2
Puncture energy, -30°C	65	J	ISO 6603-2
Notched Impact Strength (Izod), 23°C	70	kJ/m²	ISO 180/1A
Notched Impact Strength (Izod)	15	kJ/m²	ISO 180/1A
Temperature	-30	°C	-

Thermal Properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load (1.80 MPa)	122	°C	ISO 75-1/-2
Vicat softening temperature, 50°C/h 50N	142	°C	ISO 306

Test specimen production	Value	Unit	Test Standard
ISO Data			
Injection Molding, melt temperature	290	°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, Other Extrusion

Special Characteristics

UV stabilized, Transparent

Additives

Release agent

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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