



Makrolon® FP2607

PC

Covestro Deutschland AG

| Rheological properties | Value | Unit | Test Standard |
|----------------------------|-------|------------------------|---------------|
| ISO Data | | | |
| Melt volume-flow rate, MVR | 12 | cm ³ /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/m ² | ISO 179/1eU |
| Impact Strength (Charpy), -30°C | no break | kJ/m ² | 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/m ² | ISO 180/1A |
| Notched Impact Strength (Izod) | 15 | kJ/m ² | 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