Makroblend® AX6505 SG

(PC+PBT) Covestro Deutschland AG

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	**13**	cm³/10min	ISO 1133
Temperature	**260**	°C	-
Load	**5**	kg	-
Molding shrinkage, parallel	**1.0**	%	ISO 294-4, 2577
Molding shrinkage, normal	**1.0**	%	ISO 294-4, 2577

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	**1900**	MPa	ISO 527
Yield stress	**47**	MPa	ISO 527
Yield strain	**4.2**	%	ISO 527
Nominal strain at break	**>50**	%	ISO 527
Stress at break	**39**	MPa	ISO 527
Charpy impact strength, +23°C	**N**	kJ/m²	ISO 179/1eU
Charpy impact strength, -30°C	**N**	kJ/m²	ISO 179/1eU
Charpy notched impact strength, +23°C	**62**	kJ/m²	ISO 179/1eA
Charpy notched impact strength, -30°C	**38**	kJ/m²	ISO 179/1eA
Izod impact strength, +23°C	**N**	kJ/m²	ISO 180/1U
Izod notched impact strength, +23°C	**58**	kJ/m²	ISO 180/1A
Izod notched impact strength	**43**	kJ/m²	ISO 180/1A
Temperature	**-30**	°C	-
Puncture - maximum force, +23°C	**3270**	N	ISO 6603-2
Puncture - maximum force, -30°C	**4370**	N	ISO 6603-2
Puncture energy, +23°C	**38**	J	ISO 6603-2
Puncture energy, -30°C	**43**	J	ISO 6603-2

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	**78**	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	**102**	°C	ISO 75-1/-2
Vicat softening temperature, B	**118**	°C	ISO 306
Coeff. of linear therm. expansion, parallel	**90**	E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal	**95**	E-6/K	ISO 11359-1/-2

Other properties	Value	Unit	Test Standard
Density	**1200**	kg/m³	ISO 1183

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	**105**	°C	-
Pre-drying - Time	**4 - 6**	h	-
Melt temperature	**260**	°C	-
Mold temperature	**70**	°C	-
Injection speed	**200**	mm/s	-

Characteristics

Processing
Injection Molding

Additives
Release agent

Special Characteristics
High impact or impact modified

Features
Good Adhesion

Applications
Automotive

Regional Availability
North America, Europe, Asia Pacific, South and Central America, Near East/Africa