

Product Texts

- (PC PBT) Blend, impact modified, easy release, injection molding grade. Makroblend M525 offers an exceptional low-temperature impact strength, good flowability and excellent chemical resistance. Manufactured according to GMP, tested only according to ISO 10993-5 and ISO 10993-10 for contact with uncompromised skin only
- for questions regarding biocompatibility we ask for an email inquiry under plastics@covestro.com.

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
^[C] Melt volume-flow rate, MVR	21	cm ³ /10min	ISO 1133
Temperature	260	°C	-
Load	5	kg	-
Molding shrinkage, parallel	0.8	%	ISO 294-4, 2577
Molding shrinkage, normal	0.8	%	ISO 294-4, 2577

[C]: CAMPUS

Mechanical properties	Value	Unit	Test Standard
ISO Data			
^[C] Tensile Modulus	2000	MPa	ISO 527
^[C] Yield stress	55	MPa	ISO 527
^[C] Yield strain	4.5	%	ISO 527
^[C] Nominal strain at break	>50	%	ISO 527
Flexural modulus, 23°C	2000	MPa	ISO 178
Izod notched impact strength, +23°C	60	kJ/m ²	ISO 180/1A
Izod notched impact strength	45	kJ/m ²	ISO 180/1A
Temperature	-20	°C	-

[C]: CAMPUS

Thermal properties	Value	Unit	Test Standard
ISO Data			
^[C] Temp. of deflection under load, 1.80 MPa	75	°C	ISO 75-1/-2
^[C] Temp. of deflection under load, 0.45 MPa	100	°C	ISO 75-1/-2
Vicat softening temperature, B	122	°C	ISO 306
^[C] Burning Behav. at 1.5 mm nom. thickn.	HB	class	IEC 60695-11-10
Thickness tested	1.5	mm	-
Yellow Card available	yes	-	-

[C]: CAMPUS

Electrical properties	Value	Unit	Test Standard
ISO Data			
^[C] Volume resistivity	>1E13	Ohm*m	IEC 62631-3-1
^[C] Surface resistivity	>1E15	Ohm	IEC 62631-3-2
^[C] Comparative tracking index	225	-	IEC 60112

[C]: CAMPUS

Other properties	Value	Unit	Test Standard
^[C] Density	1220	kg/m ³	ISO 1183

[C]: CAMPUS

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	110	°C	-
Pre-drying - Time	2 - 4	h	-
Processing humidity	≤0.01	%	-
Melt temperature	250 - 270	°C	-
Mold temperature	60 - 100	°C	-
Zone 1	245 - 255	°C	-
Zone 2	250 - 260	°C	-
Zone 3	255 - 265	°C	-
Nozzle temperature	255 - 270	°C	-

Back pressure

5 - 15

MPa

-

Characteristics**Processing**

Injection Molding

Additives

Release agent

Special Characteristics

High impact or impact modified

Chemical Resistance

General Chemical Resistance

Certifications

Medical Grade, Biocompatibility ISO 10993

Applications

Medical

Regional Availability

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