Makroblend® AX4025 M

(PC+PBT)-MX — Covestro Deutschland AG

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	**15**	cm³/10min	ISO 1133
Temperature	**260**	°C	-
Load	**5**	kg	-
Molding shrinkage, parallel	**0.9**	%	ISO 294-4, 2577
Molding shrinkage, normal	**0.9**	%	ISO 294-4, 2577

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	**3500**	MPa	ISO 527
Yield stress	**60**	MPa	ISO 527
Yield strain	**4**	%	ISO 527
Nominal strain at break	**20**	%	ISO 527
Stress at break	**45**	MPa	ISO 527
Strain at break	**35**	%	ISO 527
Flexural modulus, 23°C	**3500**	MPa	ISO 178
Flexural strength	**90**	MPa	ISO 178
Charpy impact strength, +23°C	**N**	kJ/m²	ISO 179/1eU
Charpy notched impact strength, +23°C	**13**	kJ/m²	ISO 179/1eA
Izod impact strength, +23°C	**N**	kJ/m²	ISO 180/1U
Izod notched impact strength, +23°C	**10**	kJ/m²	ISO 180/1A
Puncture - maximum force, +23°C	**3950**	N	ISO 6603-2
Puncture - maximum force, -30°C	**4850**	N	ISO 6603-2
Puncture energy, +23°C	**40**	J	ISO 6603-2
Puncture energy, -30°C	**42**	J	ISO 6603-2

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	**94**	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	**118**	°C	ISO 75-1/-2
Vicat softening temperature, B	**130**	°C	ISO 306
Coeff. of linear therm. expansion, parallel	**69**	E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal	**70**	E-6/K	ISO 11359-1/-2

Other properties	Value	Unit	Test Standard
Density	**1290**	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

Applications
Automotive

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