

**Product Texts**

- (PC PET)-blend, impact modified, easy release, injection molding. Makroblend UT250 offers high heat resistance, good chemical resistance and flowability. Additionally, molded parts from UT250 having exceptional dimensional stability.

**Processing/Physical Characteristics**

	Value	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Melt volume-flow rate, MVR	22	cm <sup>3</sup> /10min	ISO 1133
Temperature	265	°C	-
Load	5	kg	-

[C]: CAMPUS

**Mechanical properties**

	Value	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Tensile Modulus	2250	MPa	ISO 527
<sup>[C]</sup> Yield stress	55	MPa	ISO 527
<sup>[C]</sup> Yield strain	5	%	ISO 527
<sup>[C]</sup> Nominal strain at break	>50	%	ISO 527
<sup>[C]</sup> Charpy impact strength, +23°C	N	kJ/m <sup>2</sup>	ISO 179/1eU
<sup>[C]</sup> Charpy impact strength, -30°C	N	kJ/m <sup>2</sup>	ISO 179/1eU
<sup>[C]</sup> Charpy notched impact strength, +23°C	70	kJ/m <sup>2</sup>	ISO 179/1eA
<sup>[C]</sup> Charpy notched impact strength, -30°C	30	kJ/m <sup>2</sup>	ISO 179/1eA

[C]: CAMPUS

**Thermal properties**

	Value	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Temp. of deflection under load, 1.80 MPa	110	°C	ISO 75-1/-2
<sup>[C]</sup> Temp. of deflection under load, 0.45 MPa	125	°C	ISO 75-1/-2

[C]: CAMPUS

**Electrical properties**

	Value	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Relative permittivity, 100Hz	3.2	-	IEC 62631-2-1
<sup>[C]</sup> Relative permittivity, 1MHz	3	-	IEC 62631-2-1
<sup>[C]</sup> Dissipation factor, 100Hz	16	E-4	IEC 62631-2-1
<sup>[C]</sup> Dissipation factor, 1MHz	146	E-4	IEC 62631-2-1
<sup>[C]</sup> Volume resistivity	>1E13	Ohm*m	IEC 62631-3-1
<sup>[C]</sup> Surface resistivity	>1E15	Ohm	IEC 62631-3-2
<sup>[C]</sup> Electric strength	34	kV/mm	IEC 60243-1
<sup>[C]</sup> Comparative tracking index	250	-	IEC 60112

[C]: CAMPUS

**Other properties**

	Value	Unit	Test Standard
<sup>[C]</sup> Water absorption	0.55	%	Sim. to ISO 62
<sup>[C]</sup> Humidity absorption	0.2	%	Sim. to ISO 62
<sup>[C]</sup> Density	1220	kg/m <sup>3</sup>	ISO 1183

[C]: CAMPUS

**Test specimen production**

	Value	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Injection Molding, melt temperature	265	°C	ISO 294
Injection Molding, mold temperature	70	°C	ISO 294
Injection Molding, injection velocity	200	mm/s	ISO 294

[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	260 - 280	°C	-
Mold temperature	60 - 80	°C	-

**Characteristics****Processing**

Injection Molding

**Delivery form**

Pellets

**Special Characteristics**

High impact or impact modified, Light stabilized or stable to light

**Chemical Resistance**

General Chemical Resistance

**Regional Availability**

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

**Other text information****Injection molding**

## PREPROCESSING

Max. Water content: 0.01 %

Drying temperature: 110 °C

Drying time:

Circulating air drying oven (50 % fresh air) 4-12 h

Fresh air dryer (high speed dryer) 2-4 h

Dry air dryer 2-4 h

## PROCESSING

Melt temperature: 260-280 °C

Mold temperature: 60-80 °C

Use open nozzle.