



Makrolon® 2407 DC

Grades / Special grades

MVR (300 °C/1.2 kg) 19 cm³/10 min; light diffusion grade; low viscosity; UV stabilized; easy release; available in translucent colors only

ISO Shortname

PC

Property	Test Condition	Unit	Standard	typical Value
Rheological properties				
C Melt volume-flow rate	300 °C/ 1.2 kg	cm³/10 min	ISO 1133	19
C Molding shrinkage, parallel	60x60x2 mm	%	ISO 294-4	0.65
C Molding shrinkage, normal	60x60x2 mm	%	ISO 294-4	0.7
Mechanical properties (23 °C/50 % r. h.)				
C Tensile modulus	1 mm/min	MPa	ISO 527-1,-2	2400
C Yield stress	50 mm/min	MPa	ISO 527-1,-2	65
C Yield strain	50 mm/min	%	ISO 527-1,-2	6
Nominal strain at break	5 mm/min	%	ISO 527-1,-2	>50
C Stress at break	5 mm/min	MPa	ISO 527-1,-2	60
C Strain at break	5 mm/min	%	ISO 527-1,-2	110
C Charpy impact strength	23 °C	kJ/m²	ISO 179/1eU	N
Charpy notched impact strength	23 °C	kJ/m²	ISO 21305/based on ISO 179/1eA	12(C)
Charpy notched impact strength	-20 °C	kJ/m²	ISO 21305/based on ISO 179/1eA	12(C)
C Puncture impact properties - maximum force	23 °C	N	ISO 6603-2	5000
C Puncture impact properties - maximum force	-30 °C	N	ISO 6603-2	6000
C Puncture energy	23 °C	J	ISO 6603-2	50
C Puncture energy	-30 °C	J	ISO 6603-2	55
C Ball indentation hardness		N/mm²	ISO 2039-1	120
Thermal properties				
C Temperature of deflection under load	1.80 MPa	°C	ISO 75-1,-2	122
C Temperature of deflection under load	0.45 MPa	°C	ISO 75-1,-2	134
C Vicat softening temperature	50 N; 50 °C/h	°C	ISO 306	140
C Burning behavior UL 94	0.75 mm	Class	UL 94	V-2
Other properties (23 °C)				
C Density		kg/m³	ISO 1183-1	1200
Processing conditions for test specimens				
C Injection molding - Melt temperature		°C	ISO 294	280
C Injection molding - Mold temperature		°C	ISO 294	80
C Injection molding - Injection velocity		mm/s	ISO 294	200
Recommended processing and drying conditions				
Melt temperatures		°C	-	280
Mold Temperatures		°C	-	80
Dry Air Drying Temperature		°C	-	120
Dry Air Drying Time		h	-	4

C These property characteristics are taken from the CAMPUS plastics data bank and are based on the international catalogue of basic data for plastics according to ISO 10350.

Impact properties: N = non-break, P = partial break, C = complete break

