



Makrolon® 2865

Flame retardant grades / Medium viscosity

MVR (300 °C/1.2 kg) 10 cm³/10 min; flame retardant; UL 94V-2/1.5 mm and 3.0 mm; medium viscosity; easy release; injection molding - melt temperature 280 - 320 °C; available in transparent, translucent and opaque colors

ISO Shortname

ISO 7391-PC,MFR,(,)-09-9

Property	Test Condition	Unit	Standard	typical Value
Rheological properties				
C Melt volume-flow rate	300 °C/ 1.2 kg	cm³/10 min	ISO 1133	10
Melt mass-flow rate	300 °C/ 1.2 kg	g/10 min	ISO 1133	10
C Molding shrinkage, parallel	60x60x2 mm/ 500 bar	%	ISO 294-4	0.65
C Molding shrinkage, normal	60x60x2 mm/ 500 bar	%	ISO 294-4	0.7
Molding shrinkage, parallel/normal	Value range based on general practical experience	%	b.o. ISO 2577	0.6 - 0.8
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	66
C Yield strain	50 mm/min	%	ISO 527-1,-2	6.2
C Nominal strain at break	50 mm/min	%	ISO 527-1,-2	> 50
Stress at break	50 mm/min	MPa	ISO 527-1,-2	70
Strain at break	50 mm/min	%	b.o. ISO 527-1,-2	130
C Tensile creep modulus	1 h	MPa	ISO 899-1	2200
C Tensile creep modulus	1000 h	MPa	ISO 899-1	1900
Flexural modulus	2 mm/min	MPa	ISO 178	2400
Flexural strength	2 mm/min	MPa	ISO 178	97
Flexural strain at flexural strength	2 mm/min	%	ISO 178	7.1
Flexural stress at 3.5 % strain	2 mm/min	MPa	ISO 178	73
C Charpy impact strength	23 °C	kJ/m²	ISO 179/1eU	N
Charpy impact strength	-60 °C	kJ/m²	ISO 179/1eU	N
Charpy notched impact strength	23 °C/ 3 mm	kJ/m²	ISO 21305/based on ISO 179/1eA	75P
Charpy notched impact strength	-30 °C/ 3 mm	kJ/m²	ISO 21305/based on ISO 179/1eA	16C
Izod notched impact strength	23 °C/ 3 mm	kJ/m²	ISO 21305/based on ISO 180/A	65P
Izod notched impact strength	-30 °C/ 3 mm	kJ/m²	ISO 21305/based on ISO 180/A	12C
C Puncture impact properties - maximum force	23 °C	N	ISO 6603-2	5400
C Puncture impact properties - maximum force	-30 °C	N	ISO 6603-2	6300
C Puncture energy	23 °C	J	ISO 6603-2	60
C Puncture energy	-30 °C	J	ISO 6603-2	65
Ball indentation hardness		N/mm²	ISO 2039-1	115



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Property	Test Condition	Unit	Standard	typical Value
Thermal properties				
C Glass transition temperature	10 °C/min	°C	ISO 11357-1,-2	145
C Temperature of deflection under load	1.80 MPa	°C	ISO 75-1,-2	125
C Temperature of deflection under load	0.45 MPa	°C	ISO 75-1,-2	137
C Vicat softening temperature	50 N; 50 °C/h	°C	ISO 306	145
Vicat softening temperature	50 N; 120 °C/h	°C	ISO 306	146
C Coefficient of linear thermal expansion, parallel	23 to 55 °C	10 ⁻⁴ /K	ISO 11359-1,-2	0.65
C Coefficient of linear thermal expansion, normal	23 to 55 °C	10 ⁻⁴ /K	ISO 11359-1,-2	0.65
C Burning behavior UL 94 [UL recognition]	0.75 mm	Class	UL 94	V-2
Burning behavior UL 94 [UL recognition]	6.0 mm	Class	UL 94	V-0
C Oxygen index	Method A	%	ISO 4589-2	32
Thermal conductivity, through-plane	23 °C; 50 % r. h.	W/(m·K)	ISO 8302	0.20
Resistance to heat (ball pressure test)		°C	IEC 60695-10-2	136
Relative temperature index (Tensile strength) [UL recognition]	1.5 mm	°C	UL 746B	125
Relative temperature index (Tensile impact strength) [UL recognition]	1.5 mm	°C	UL 746B	115
Relative temperature index (Electric strength) [UL recognition]	1.5 mm	°C	UL 746B	125
Glow wire test (GWFI) [UL recognition]	0.75 mm	°C	IEC 60695-2-12	850
Glow wire test (GWFI) [UL recognition]	1.5 mm	°C	IEC 60695-2-12	850
Glow wire test (GWFI) [UL recognition]	3.0 mm	°C	IEC 60695-2-12	960
Glow wire test (GWIT)	0.75 mm	°C	IEC 60695-2-13	875
Glow wire test (GWIT)	1.5 mm	°C	IEC 60695-2-13	900
Glow wire test (GWIT)	3.0 mm	°C	IEC 60695-2-13	900
Application of flame from small burner	Method K and F/ 2.0 mm	Class	DIN 53438-1,-3	K1, F1
Needle flame test	Method K/ 1.5 mm	s	IEC 60695-11-5	10
Needle flame test	Method K/ 2.0 mm	s	IEC 60695-11-5	20
Needle flame test	Method K/ 3.0 mm	s	IEC 60695-11-5	30
Needle flame test	Method F/ 1.5 mm	s	IEC 60695-11-5	60
Needle flame test	Method F/ 2.0 mm	s	IEC 60695-11-5	120
Needle flame test	Method F/ 3.0 mm	s	IEC 60695-11-5	120
Burning rate (US-FMVSS)	>=1.0 mm	mm/min	ISO 3795	passed
Flash ignition temperature		°C	ASTM D1929	480
Self ignition temperature		°C	ASTM D1929	550
Electrical properties (23 °C/50 % r. h.)				
C Relative permittivity	100 Hz	-	IEC 60250	3.1
C Relative permittivity	1 MHz	-	IEC 60250	3.0
C Dissipation factor	100 Hz	10 ⁻⁴	IEC 60250	5
C Dissipation factor	1 MHz	10 ⁻⁴	IEC 60250	90
C Volume resistivity		Ohm·m	IEC 60093	1E14
C Surface resistivity		Ohm	IEC 60093	1E16
C Electrical strength	1 mm	kV/mm	IEC 60243-1	34
C Comparative tracking index CTI	Solution A	Rating	IEC 60112	225
Comparative tracking index CTI M	Solution B	Rating	IEC 60112	125M
Electrolytic corrosion		Rating	IEC 60426	A1



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Property	Test Condition	Unit	Standard	typical Value
Other properties (23 °C)				
C Water absorption (saturation value)	Water at 23 °C	%	ISO 62	0.30
C Water absorption (equilibrium value)	23 °C; 50 % r. h.	%	ISO 62	0.12
C Density		kg/m³	ISO 1183-1	1200
Water vapor permeability	23 °C; 85 % RH/ 100 µm film	g/(m²·24 h)	ISO 15106-1	15
Gas permeation	Oxygen/ 100 µm film	cm³/(m²·24 h·bar)	b.o. ISO 2556	650
Gas permeation	Oxygen/ 25.4 µm (1 mil) film	cm³/(m²·24 h·bar)	b.o. ISO 2556	2760
Gas permeation	Nitrogen/ 100 µm film	cm³/(m²·24 h·bar)	b.o. ISO 2556	120
Gas permeation	Nitrogen/ 25.4 µm (1 mil) film	cm³/(m²·24 h·bar)	b.o. ISO 2556	510
Gas permeation	Carbon dioxide/ 100 µm film	cm³/(m²·24 h·bar)	b.o. ISO 2556	3800
Gas permeation	Carbon dioxide/ 25.4 µm (1 mil) film	cm³/(m²·24 h·bar)	b.o. ISO 2556	16900
Bulk density	Pellets	kg/m³	ISO 60	640
Material specific properties				
Refractive index	Procedure A	-	ISO 489	1.586
Haze for transparent materials	3 mm	%	ISO 14782	< 0.8
Luminous transmittance (clear transparent materials)	1 mm	%	ISO 13468-2	89
C Luminous transmittance (clear transparent materials)	2 mm	%	ISO 13468-2	89
Luminous transmittance (clear transparent materials)	3 mm	%	ISO 13468-2	88
Luminous transmittance (clear transparent materials)	4 mm	%	ISO 13468-2	87
Processing conditions for test specimens				
C Injection molding - Melt temperature		°C	ISO 294	300
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 - 320
Standard Melt temperature		°C	-	300
Barrel Temperatures - Rear		°C	-	250 - 260
Barrel Temperatures - Middle		°C	-	270 - 280
Barrel Temperatures - Front		°C	-	280 - 290
Barrel Temperatures - Nozzle		°C	-	290 - 300
Mold Temperatures		°C	-	80 - 120
Hold Pressure (% of injection pressure)		%	-	50 - 75
Plastic Back Pressure (specific)		bar	-	50 - 150
Peripheral Screw Speed		m/s	-	0.05 - 0.2
Shot-to-Cylinder Size		%	-	30 - 70
Dry Air Drying Temperature		°C	-	120
Dry Air Drying Time		h	-	2-3
Moisture Content max. (%)		%	-	<= 0,02
Vent Depth		mm	-	0.025 - 0.075

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

