Makrolon® AX2475

I	MVR (300 °C/1.2 kg) 19 cm³/10 min; low viscosity; easy release; injection molding; developed for high-gloss surfaces with highest requirements; for the use in combination with hard coatings
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/ 500 bar	%	ISO 294-4	0.65
C	Molding shrinkage, normal	60x60x2 mm/ 500 bar	%	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	66
C	Yield strain	50 mm/min	%	ISO 527-1,-2	6.0
C	Nominal strain at break	50 mm/min	%	ISO 527-1,-2	> 50
	Stress at break	50 mm/min	MPa	ISO 527-1,-2	65
	Strain at break	50 mm/min	%	b.o. ISO 527-1,-2	120
	Flexural modulus	2 mm/min	MPa	ISO 178	2350
	Flexural strength	2 mm/min	MPa	ISO 178	98
C	Charpy impact strength	23 °C	kJ/m²	ISO 179/1eU	N
	Izod notched impact strength	23 °C/ 3 mm	kJ/m²	ISO 21305/based on ISO 180/A	60P(C)
	Izod notched impact strength	-30 °C/ 3 mm	kJ/m²	ISO 21305/based on ISO 180/A	12C
Thermal properties					
C	Temperature of deflection under load	1.80 MPa	°C	ISO 75-1,-2	124
C	Temperature of deflection under load	0.45 MPa	°C	ISO 75-1,-2	136
C	Vicat softening temperature	50 N; 50 °C/h	°C	ISO 306	141
	Vicat softening temperature	50 N; 120 °C/h	°C	ISO 306	143
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
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

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