



Makrolon® Ai2257

/ MVR (300 °C/1.2 kg) 35 cm³/10 min; easy release; UV stabilized; available in translucent colors only; Automotive interior; developed for high-gloss surfaces with highest requirements

ISO Shortname

PC

Property	Test Condition	Unit	Standard	typical Value
Rheological properties				
Melt volume-flow rate	300 °C/ 1.2 kg	cm³/10 min	ISO 1133	35
Molding shrinkage, parallel/normal	Value range based on general practical experience	%	b.o. ISO 2577	0.65 - 0.7
Mechanical properties (23 °C/50 % r. h.)				
C Tensile modulus	1 mm/min	MPa	ISO 527-1,-2	2350
C Yield stress	50 mm/min	MPa	ISO 527-1,-2	63
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	60
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	97
Flexural strain at flexural strength	2 mm/min	%	ISO 178	7
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
Thermal properties				
C Temperature of deflection under load	1.80 MPa	°C	ISO 75-1,-2	123
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	143
Vicat softening temperature	50 N; 120 °C/h	°C	ISO 306	145
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
Recommended processing and drying conditions				
Dry Air Drying Temperature		°C	-	120

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

