



Makroblend® S7916

PBT+PC Blends, elastomer modified / Non reinforced

(PBT+PC)-blend, impact modified, Injection molding grade, excellent chemical resistance, high toughness at low temperatures, ideal for painted applications, unreinforced

ISO Shortname

PBT+PC-I

Property	Test Condition	Unit	Standard	typical Value
Rheological properties				
Göttfert melt viscosity	165 s ⁻¹ / 260 °C	Pa·s	Bayer test	640
C Melt volume-flow rate	260 °C/ 5 kg	cm ³ /10 min	ISO 1133	13
Molding shrinkage, parallel/normal	Value range based on general practical experience (600bar)	%	b.o. ISO 2577	1.2 - 1.6
Post- shrinkage, parallel/normal	Value range based on general practical experience (1h; 90°C)	%	b.o. ISO 2577	0.1 - 0.2
Mechanical properties (23 °C/50 % r. h.)				
C Tensile modulus	1 mm/min	MPa	ISO 527-1,-2	1800
C Yield stress	50 mm/min	MPa	ISO 527-1,-2	40
C Yield strain	50 mm/min	%	ISO 527-1,-2	4
C Nominal strain at break	50 mm/min	%	ISO 527-1,-2	> 50
Stress at break	50 mm/min	MPa	ISO 527-1,-2	35
Flexural modulus	2 mm/min	MPa	ISO 178	1700
Flexural strain at flexural strength	2 mm/min	%	ISO 178	5.0
Flexural stress at 3.5 % strain	2 mm/min	MPa	ISO 178	54
Flexural strength	2 mm/min	MPa	ISO 178	63
C Tensile creep modulus	1 h	MPa	ISO 899-1	1500
C Tensile creep modulus	1000 h	MPa	ISO 899-1	1200
C Charpy impact strength	23 °C	kJ/m ²	ISO 179-1eU	N
C Charpy impact strength	-30 °C	kJ/m ²	ISO 179-1eU	N
C Charpy notched impact strength	23 °C	kJ/m ²	ISO 179-1eA	69
Izod impact strength	23 °C	kJ/m ²	ISO 180-U	N
Izod impact strength	-30 °C	kJ/m ²	ISO 180-U	N
Izod notched impact strength	23 °C	kJ/m ²	ISO 180-A	66
Izod notched impact strength	-30 °C	kJ/m ²	ISO 180-A	47
Ball indentation hardness		N/mm ²	ISO 2039-1	85
Thermal properties				
C Temperature of deflection under load	1.80 MPa	°C	ISO 75-1,-2	60
C Temperature of deflection under load	0.45 MPa	°C	ISO 75-1,-2	90
Vicat softening temperature	50 N; 120 °C/h	°C	ISO 306	116
C Coefficient of linear thermal expansion, parallel	23 to 55 °C	10 ⁻⁴ /K	ISO 11359-1,-2	1.1
C Coefficient of linear thermal expansion, transverse	23 to 55 °C	10 ⁻⁴ /K	ISO 11359-1,-2	1.1
C Burning behavior UL 94 (1.5 mm)	1.6 mm	Class	UL 94	HB
C Burning behavior UL 94	0.8 mm	Class	UL 94	HB
C Oxygen index	Method A	%	ISO 4589-2	20
Thermal conductivity, cross-flow	23 °C; 50 % r. h.	W/(m·K)	ISO 8302	0.2
Glow wire test (GWFI)	2.0 mm	°C	IEC 60695-2-12	650
Burning rate (US-FMVSS)	>=1.0 mm	mm/min	ISO 3795	passed



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Electrical properties (23 °C/50 % r. h.)				
C Relative permittivity	100 Hz	-	IEC 60250	3.1
C Relative permittivity	1 MHz	-	IEC 60250	2.9
C Dissipation factor	100 Hz	10 ⁻⁴	IEC 60250	23
C Dissipation factor	1 MHz	10 ⁻⁴	IEC 60250	140
C Volume resistivity		Ohm·m	IEC 60093	>1E15
C Surface resistivity		Ohm	IEC 60093	>1E17
C Comparative tracking index CTI	Solution A	Rating	IEC 60112	600
C Comparative tracking index CTI M	Solution B	Rating	IEC 60112	400
C Electrolytic corrosion		Rating	IEC 60426	A1
Other properties (23 °C)				
C Water absorption (saturation value)	Water at 23 °C	%	ISO 62	0.5
C Water absorption (equilibrium value)	23 °C; 50 % r. h.	%	ISO 62	0.2
C Density		kg/m³	ISO 1183-1	1200
C Bulk density		g/cm³	ISO 60	0.7
Processing conditions for test specimens				
C Injection molding-Melt temperature		°C	ISO 294	260
C Injection molding-Mold temperature		°C	ISO 294	70
C Injection molding-Injection velocity		mm/s	ISO 294	200
Recommended Processing and Drying Conditions				
C Melt Temperatures		°C	-	250 - 270
C Standard Melt Temperature		°C	-	260
C Barrel Temperatures - Rear		°C	-	230 - 240
C Barrel Temperatures - Middle		°C	-	240 - 250
C Barrel Temperatures - Front		°C	-	250 - 260
C Barrel Temperatures - Nozzle		°C	-	260 - 270
C Mold Temperatures		°C	-	60 - 80
C Hold Pressure (% of injection pressure)		%	-	50 - 75
C Plastic Back Pressure (specific)		bar	-	50 - 100
C Peripheral Screw Speed		m/s	-	0.1 - 0.2
C Shot-to-Cylinder Size		%	-	30 - 70
C Dry Air Drying Temperature		°C	-	110
C Dry Air Drying Time		h	-	2-4
C Moisture Content max. (%)		%	-	<= 0,02
C 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

