



Makrolon® 6165 X

PC

Covestro Deutschland AG

- MVR (300 °C/1.2 kg) 28 cm³/10 min
- flame retardant
- UL 94V-0/1.2 mm
- low viscosity
- easy release

Rheological properties	Value	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	28	cm³/10min	ISO 1133
Temperature	300	°C	-
Load	1.2	kg	-
Molding shrinkage, parallel	0.7	%	ISO 294-4, 2577
Molding shrinkage, normal	0.7	%	ISO 294-4, 2577

Mechanical Properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	2350	MPa	ISO 527
Yield stress	65	MPa	ISO 527
Yield strain	6	%	ISO 527
Nominal strain at break	>50	%	ISO 527
Impact Strength (Charpy), +23°C	no break	kJ/m²	ISO 179/1eU
Impact Strength (Charpy), -30°C	no break	kJ/m²	ISO 179/1eU
Puncture - maximum force, +23°C	4800	N	ISO 6603-2
Puncture energy, +23°C	45	J	ISO 6603-2

Thermal Properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load (1.80 MPa)	124	°C	ISO 75-1/-2
Temp. of deflection under load (0.45 MPa)	136	°C	ISO 75-1/-2
Vicat softening temperature, 50°C/h 50N	143	°C	ISO 306
Coeff. of Linear Therm. Expansion, parallel	65	E-6/K	ISO 11359-1/-2
Coeff. of Linear Therm. Expansion, normal	65	E-6/K	ISO 11359-1/-2
Burning Behav. at thickness h	V-0	class	UL 94
Thickness tested	1.2	mm	-
Oxygen index	35	%	ISO 4589-1/-2

Electrical Properties	Value	Unit	Test Standard
ISO Data			
Relative permittivity, 100Hz	3.1	-	IEC 62631-2-1
Relative permittivity, 1MHz	3	-	IEC 62631-2-1
Volume Resistivity	>1E13	Ohm*m	IEC 62631-3-1
Surface Resistivity	>1E15	Ohm	IEC 62631-3-2
Electric Strength	34	kV/mm	IEC 60243-1
Comparative tracking index	225	-	IEC 60112

Other Properties	Value	Unit	Test Standard
ISO Data			
Water Absorption	0.3	%	Sim. to ISO 62
Humidity absorption	0.12	%	Sim. to ISO 62
Density	1200	kg/m³	ISO 1183

Test specimen production	Value	Unit	Test Standard
ISO Data			
Injection Molding, melt temperature	280	°C	ISO 294
Injection Molding, mold temperature	80	°C	ISO 294
Injection Molding, injection velocity	200	mm/s	ISO 294

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	120	°C	-
Pre-drying - Time	2 - 3	h	-
Processing humidity	≤0.02	%	-

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Melt temperature	280 - 320	°C	-
Mold temperature	80 - 100	°C	-

Characteristics

Processing

Injection Molding

Additives

Release agent

Delivery form

Pellets

Special Characteristics

Flame retardant

Injection Molding

PREPROCESSING

Max. Water content: 0.01 - 0.02 %

Drying temperature: 120 °C

Drying time:

Circulating air drying oven (50 % fresh air) 4-8 h

Fresh air dryer (high speed dryer) 2-4 h

Dry air dryer 2-3 h

PROCESSING

Melt temperature: 280-320 °C

Mold temperature: 80-100 °C

Use open nozzle.