



Makrolon® 6487 R30 CQ
PC

Covestro Deutschland AG

Rheological properties	Value	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	11	cm³/10min	ISO 1133
Temperature	300	°C	-
Load	1.2	kg	-

Mechanical Properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	2350	MPa	ISO 527
Yield stress	67	MPa	ISO 527
Yield strain	6	%	ISO 527
Nominal strain at break	>50	%	ISO 527
Stress at Break	67	MPa	ISO 527
Strain at Break	110	%	ISO 527
Impact Strength (Charpy), -30°C	no break	kJ/m²	ISO 179/1eU
Puncture - maximum force, +23°C	5200	N	ISO 6603-2
Puncture - maximum force, -30°C	6100	N	ISO 6603-2
Puncture energy, +23°C	50	J	ISO 6603-2
Puncture energy, -30°C	50	J	ISO 6603-2
Notched Impact Strength (Izod), 23°C	15	kJ/m²	ISO 180/1A

Thermal Properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load (1.80 MPa)	122	°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	141	°C	ISO 306
Burning Behav. at 1.5 mm Nom. Thickn.	V-0	class	UL 94
Thickness tested	1.5	mm	-
UL recognition	yes	-	-
Burning Behav. at thickness h	V-0	class	UL 94
Thickness tested	3.0	mm	-
UL recognition	yes	-	-
Thickness tested	3.0	mm	-
Glow Wire (GWFI, Flammability Index)	960	°C	IEC 60695-2-12
GWFI - thickness tested (1)	1	mm	-
Glow Wire (GWFI, Flammability Index)	960	°C	IEC 60695-2-12
GWFI - thickness tested (2)	3	mm	-
Burning Behav. 5V at Thickness h	5VA	class	Producer Method

Electrical Properties	Value	Unit	Test Standard
ISO Data			
Relative permittivity, 100Hz	3	-	IEC 62631-2-1
Relative permittivity, 1MHz	3	-	IEC 62631-2-1
Dissipation Factor, 100Hz	7	E-4	IEC 62631-2-1
Dissipation Factor, 1MHz	96	E-4	IEC 62631-2-1
Volume Resistivity	9E16	Ohm*m	IEC 62631-3-1
Surface Resistivity	2E16	Ohm	IEC 62631-3-2
Comparative tracking index	225	-	IEC 60112

Test specimen production	Value	Unit	Test Standard
ISO Data			
Injection Molding, melt temperature	300	°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	%	-
Melt temperature	280 - 320	°C	-

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Mold temperature	80 - 120	°C	-
Zone 1	250 - 260	°C	-
Zone 2	270 - 280	°C	-
Zone 3	280 - 290	°C	-
Nozzle temperature	290 - 300	°C	-
Back pressure	5 - 15	MPa	-

Characteristics

Processing

Injection Molding

Special Characteristics

Flame retardant, UV stablized, Opaque

Delivery form

Black

Certifications

Recycled Resin Content

Additives

Release agent

Applications

Electrical and Electronical