



Makrolon® 8025

PC-GF20

Covestro Deutschland AG

- MVR (300 °C/1.2 kg) 6.0 cm³/10 min
- 20 % glass fiber reinforced
- milled fiber
- high viscosity
- easy release
- precision parts

Rheological properties	Value	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	6	cm³/10min	ISO 1133
Temperature	300	°C	-
Load	1.2	kg	-
Molding shrinkage, parallel	0.6	%	ISO 294-4, 2577
Molding shrinkage, normal	0.3	%	ISO 294-4, 2577

Mechanical Properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	4000	MPa	ISO 527
Yield stress	58	MPa	ISO 527
Yield strain	3.5	%	ISO 527
Tensile Creep Modulus, 1h	3700	MPa	ISO 899-1
Tensile Creep Modulus, 1000h	3500	MPa	ISO 899-1
Impact Strength (Charpy), +23°C	55	kJ/m²	ISO 179/1eU
Impact Strength (Charpy), -30°C	65	kJ/m²	ISO 179/1eU
Puncture - maximum force, +23°C	3300	N	ISO 6603-2
Puncture - maximum force, -30°C	2800	N	ISO 6603-2
Puncture energy, +23°C	20	J	ISO 6603-2
Puncture energy, -30°C	10	J	ISO 6603-2

Thermal Properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load (1.80 MPa)	134	°C	ISO 75-1/-2
Temp. of deflection under load (0.45 MPa)	141	°C	ISO 75-1/-2
Vicat softening temperature, 50°C/h 50N	146	°C	ISO 306
Coeff. of Linear Therm. Expansion, parallel	45	E-6/K	ISO 11359-1/-2
Coeff. of Linear Therm. Expansion, normal	55	E-6/K	ISO 11359-1/-2
Burning Behav. at 1.5 mm Nom. Thickn.	V-2	class	UL 94
Thickness tested	1.5	mm	-
Burning Behav. at thickness h	V-1	class	UL 94
Thickness tested	6.0	mm	-
Oxygen index	32	%	ISO 4589-1/-2

Electrical Properties	Value	Unit	Test Standard
ISO Data			
Relative permittivity, 100Hz	3.3	-	IEC 62631-2-1
Relative permittivity, 1MHz	3.3	-	IEC 62631-2-1
Dissipation Factor, 100Hz	10	E-4	IEC 62631-2-1
Dissipation Factor, 1MHz	90	E-4	IEC 62631-2-1
Volume Resistivity	>1E13	Ohm*m	IEC 62631-3-1
Surface Resistivity	>1E15	Ohm	IEC 62631-3-2
Electric Strength	36	kV/mm	IEC 60243-1
Comparative tracking index	175	-	IEC 60112

Other Properties	Value	Unit	Test Standard
ISO Data			
Water Absorption	0.24	%	Sim. to ISO 62
Humidity absorption	0.1	%	Sim. to ISO 62
Density	1340	kg/m³	ISO 1183

Test specimen production	Value	Unit	Test Standard
ISO Data			

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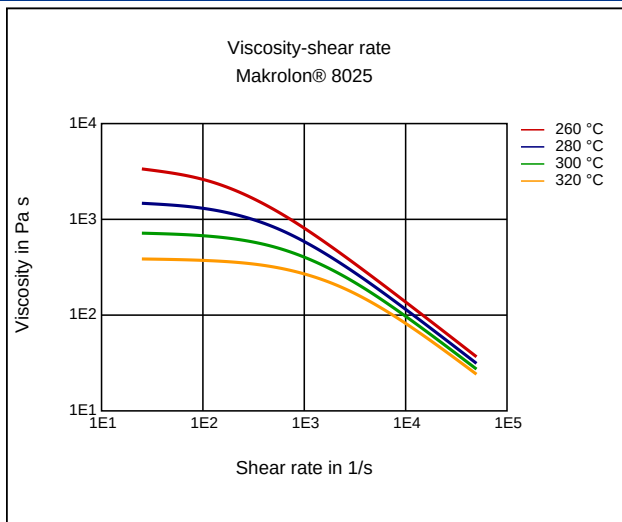
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Injection Molding, melt temperature	300	°C	ISO 294
Injection Molding, mold temperature	110	°C	ISO 294
Injection Molding, injection velocity	200	mm/s	ISO 294

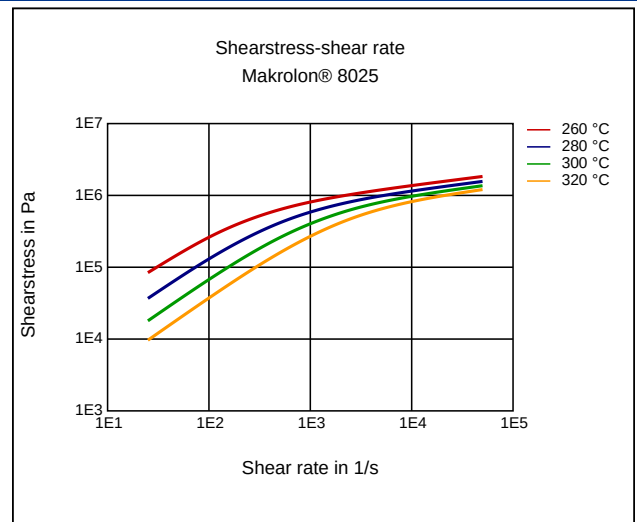
Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	120	°C	-
Pre-drying - Time	2 - 3	h	-
Processing humidity	≤0.02	%	-
Melt temperature	310 - 330	°C	-
Mold temperature	80 - 130	°C	-

Diagrams

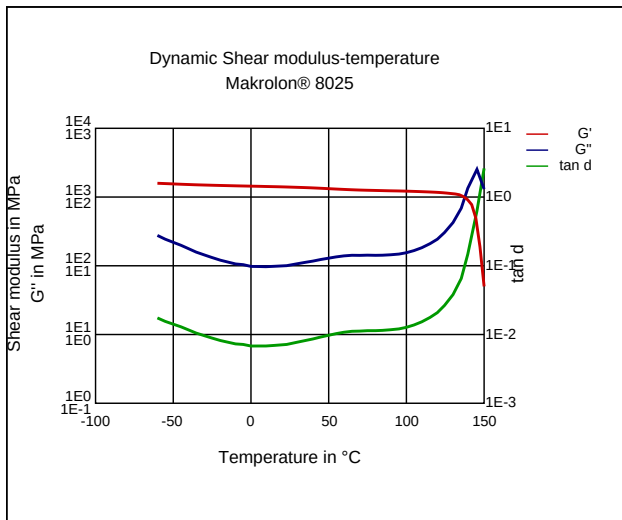
Viscosity-shear rate



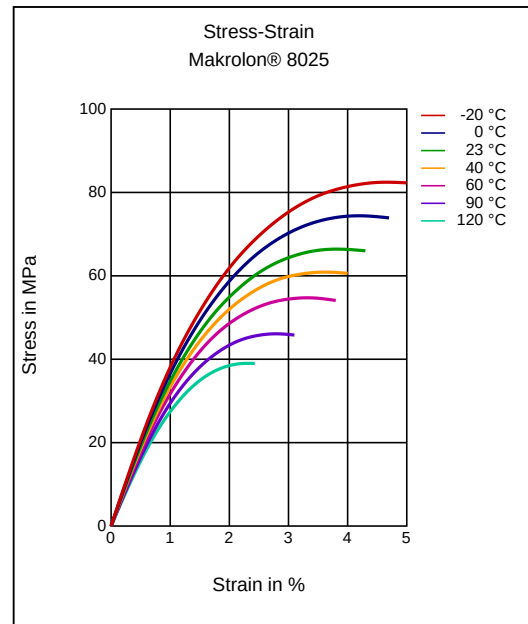
Shearstress-shear rate



Dynamic Shear modulus-temperature



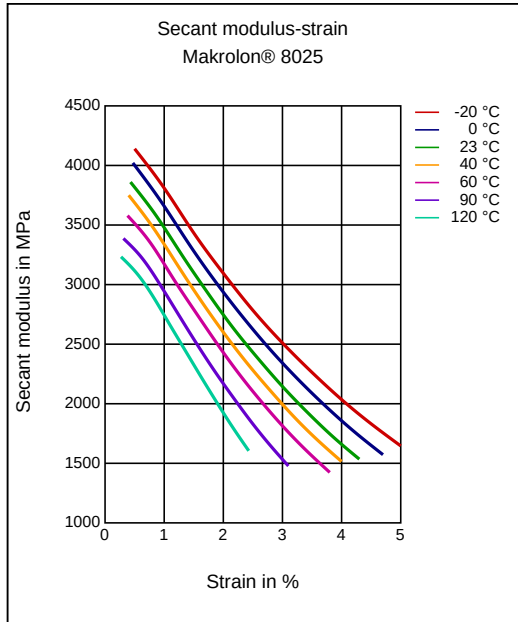
Stress-strain



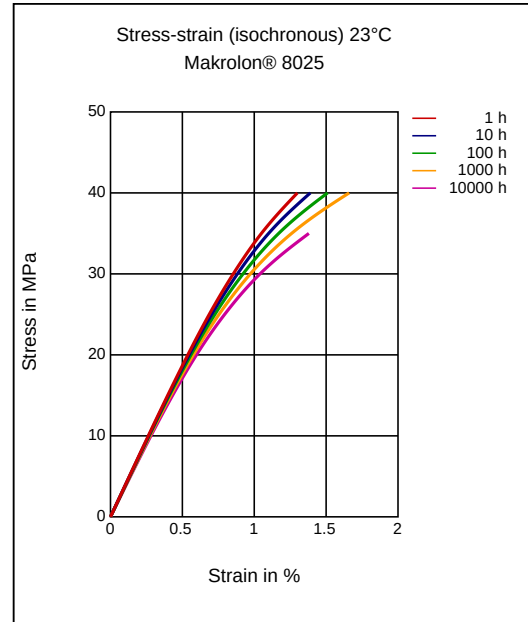
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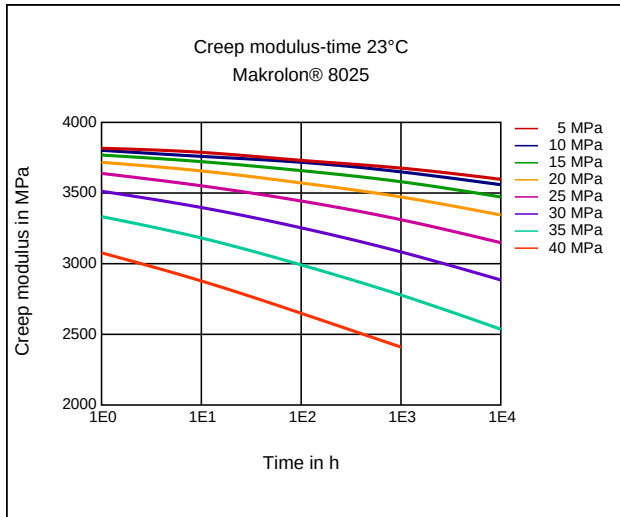
Secant modulus-strain



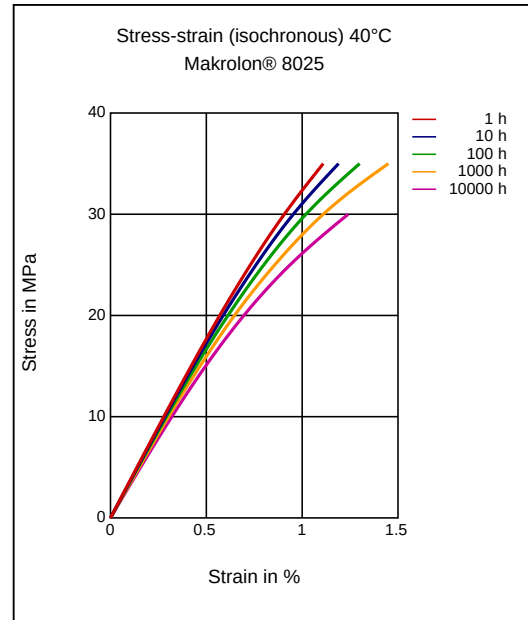
Stress-strain (isochronous) 23°C



Creep modulus-time 23°C



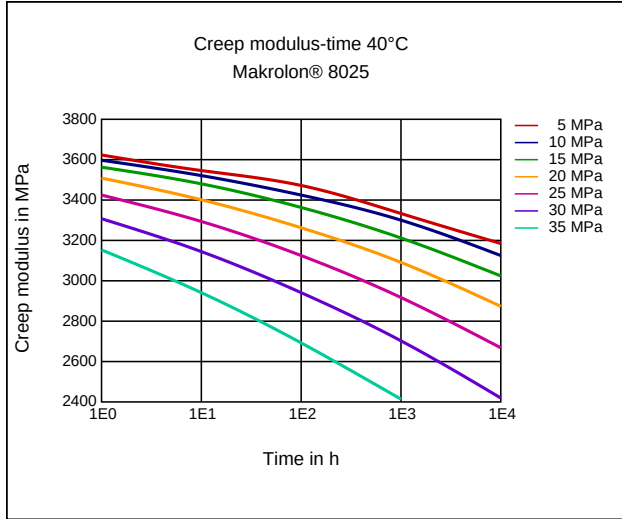
Stress-strain (isochronous) 40°C



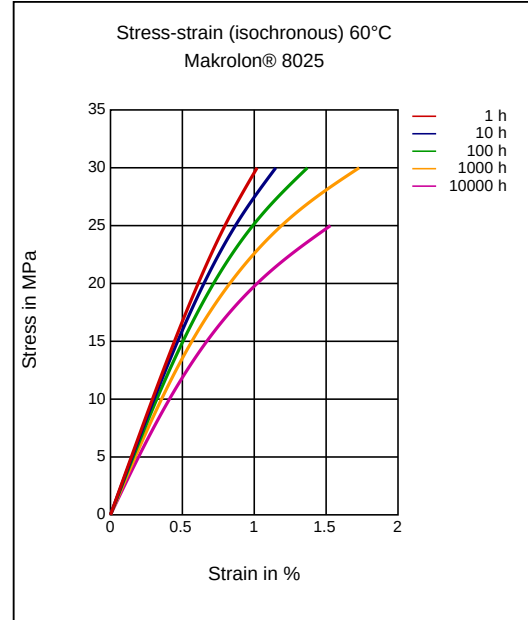
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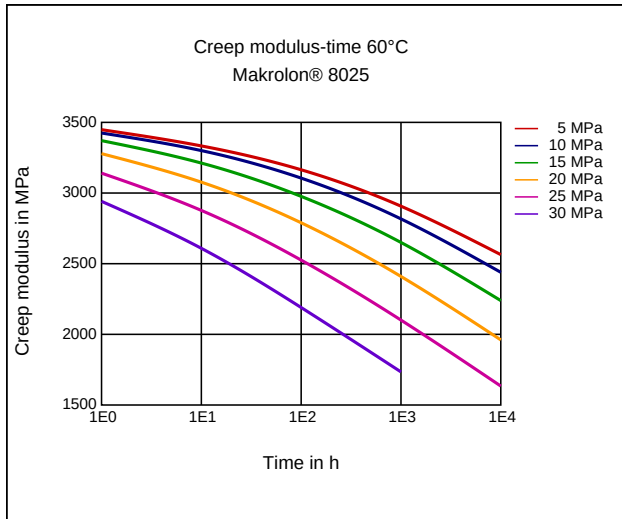
Creep modulus-time 40°C



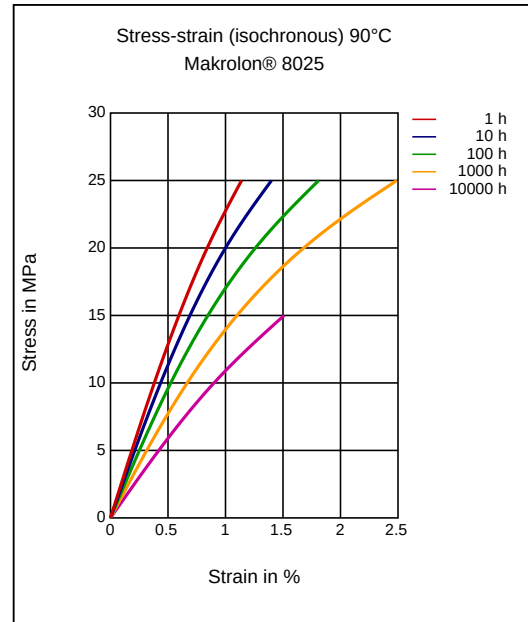
Stress-strain (isochronous) 60°C



Creep modulus-time 60°C



Stress-strain (isochronous) 90°C

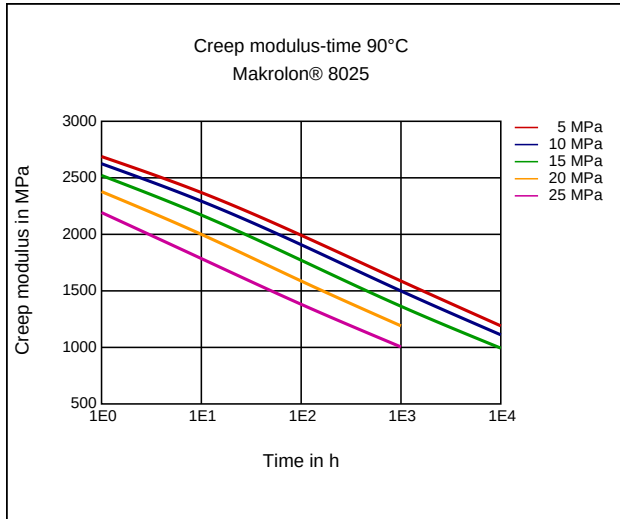


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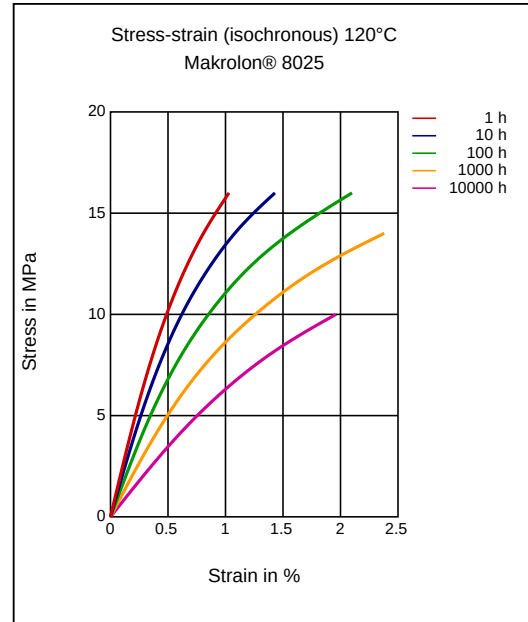
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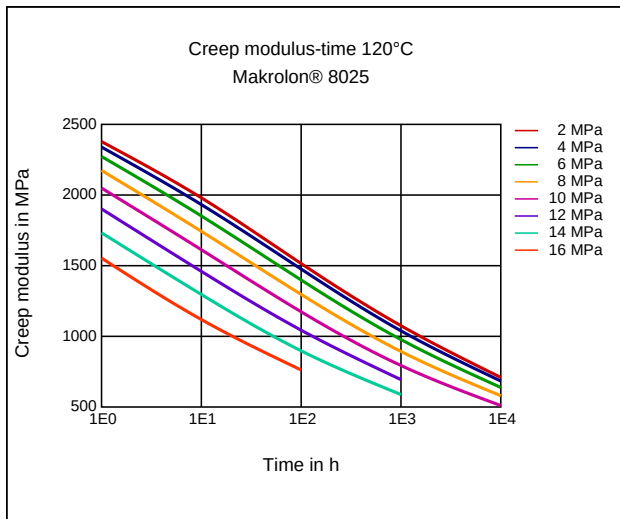
Creep modulus-time 90 °C



Stress-strain (isochronous) 120 °C



Creep modulus-time 120 °C



Characteristics

Processing

Injection Molding, Other Extrusion

Additives

Release agent

Delivery form

Pellets

Special Characteristics

Opaque

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

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Dry air dryer 2-3 h

PROCESSING

Melt temperature: 310-330 °C

Mold temperature: 80-130 °C

Use open nozzle.
