Makrolon® FP2987

PC

Covestro Deutschland AG

- high viscosity
- MVR (300 °C/1.2 kg) 9.0 cm³/10 min

Rheological properties	Value	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	9	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	66	MPa	ISO 527
Yield strain	6	%	ISO 527
Puncture - maximum force, +23°C	5700	N	ISO 6603-2
Puncture - maximum force, -30°C	6500	N	ISO 6603-2
Puncture energy, +23°C	62	J	ISO 6603-2
Puncture energy, -30°C	67	J	ISO 6603-2
Notched Impact Strength (Izod), 23°C	75	kJ/m²	ISO 180/1A
Notched Impact Strength (Izod)	14	kJ/m²	ISO 180/1A
Temperature	-20	°C	-

Thermal Properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load (1.80 MPa)	122	°C	ISO 75-1/-2
Vicat softening temperature, 50°C/h 50N	142	°C	ISO 306

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	-
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