



Makrolon® XT5010

PC

Covestro Deutschland AG

- MVR (300 °C/1.2 kg) 34 cm³/10 min
- easy processing
- low viscosity
- easy release
- Vicat softening temperature 50 N, 50 °C/h = 110 °C
- LCD tv frame

Rheological properties	Value	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	34	cm³/10min	ISO 1133
Temperature	300	°C	-
Load	1.2	kg	-

Mechanical Properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	2700	MPa	ISO 527
Yield stress	75	MPa	ISO 527
Yield strain	5	%	ISO 527
Nominal strain at break	>50	%	ISO 527
Impact Strength (Charpy), +23 °C	220	kJ/m²	ISO 179/1eU
Impact Strength (Charpy), -30 °C	no break	kJ/m²	ISO 179/1eU

Thermal Properties	Value	Unit	Test Standard
ISO Data			
Vicat softening temperature, 50 °C/h 50N	112	°C	ISO 306
Burning Behav. at thickness h	V-2	class	UL 94

Other Properties	Value	Unit	Test Standard
ISO Data			
Density	1210	kg/m³	ISO 1183

Test specimen production	Value	Unit	Test Standard
ISO Data			
Injection Molding, melt temperature	260	°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	90	°C	-
Pre-drying - Time	2 - 3	h	-
Processing humidity	≤0.02	%	-
Melt temperature	240 - 280	°C	-
Mold temperature	80 - 100	°C	-

Characteristics

Processing

Injection Molding

Additives

Release agent

Delivery form

Pellets

Special Characteristics

Transparent

Injection Molding

PREPROCESSING

Max. Water content: 0.01 - 0.02 %

Drying temperature: 90 °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

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PROCESSING

Melt temperature: 240-280 °C

Mold temperature: 80-100 °C

Use open nozzle.