



Makrolon® RW2405

PC

Covestro Deutschland AG

- MVR (300 °C/1.2 kg) 19 cm³/10 min
- low viscosity
- easy release
- variable content of filler for high reflectance application

Rheological properties	Value	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	19	cm³/10min	ISO 1133
Temperature	300	°C	-
Load	1.2	kg	-

Mechanical Properties	Value	Unit	Test Standard
ISO Data			
Impact Strength (Charpy), +23°C	no break	kJ/m²	ISO 179/1eU
Puncture - maximum force, +23°C	5100	N	ISO 6603-2
Puncture energy, +23°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			
Vicat softening temperature, 50°C/h 50N	144	°C	ISO 306
Burning Behav. at 1.5 mm Nom. Thickn.	V-2	class	UL 94
Burning Behav. at thickness h	HB	class	UL 94
Thickness tested	3.0	mm	-
Glow Wire (GWFI, Flammability Index)	850	°C	IEC 60695-2-12
GWFI - thickness tested (1)	0.75	mm	-
Glow Wire (GWFI, Flammability Index)	960	°C	IEC 60695-2-12
GWFI - thickness tested (2)	3	mm	-

Other Properties	Value	Unit	Test Standard
ISO Data			
Density	1340	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

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

Additives

Release agent

Delivery form

White

Features

Light Reflecting

Disclaimer