



Makroblend® M525

(PC+PBT)-I

Covestro Deutschland AG

- (PC PBT) Blend, impact modified, easy release, injection molding grade. Makroblend M525 offers an exceptional low-temperature impact strength, good flowability and excellent chemical resistance. Manufactured according to GMP, tested only according to ISO 10993-5 and ISO 10993-10 for contact with uncompromised skin only
- for questions regarding biocompatibility we ask for an email inquiry under plastics@covestro.com.

Rheological properties	Value	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	21	cm³/10min	ISO 1133
Temperature	260	°C	-
Load	5	kg	-

Mechanical Properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	2000	MPa	ISO 527
Yield stress	55	MPa	ISO 527
Yield strain	4.5	%	ISO 527
Nominal strain at break	>50	%	ISO 527
Flexural Modulus (23°C)	2000	MPa	ISO 178
Notched Impact Strength (Izod), 23°C	60	kJ/m²	ISO 180/1A
Notched Impact Strength (Izod)	45	kJ/m²	ISO 180/1A
Temperature	-20	°C	-

Thermal Properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load (1.80 MPa)	75	°C	ISO 75-1/-2
Temp. of deflection under load (0.45 MPa)	100	°C	ISO 75-1/-2
Burning Behav. at 1.5 mm Nom. Thickn.	HB	class	UL 94

Electrical Properties	Value	Unit	Test Standard
ISO Data			
Volume Resistivity	>1E13	Ohm*m	IEC 62631-3-1
Surface Resistivity	>1E15	Ohm	IEC 62631-3-2
Comparative tracking index	225	-	IEC 60112

Other Properties	Value	Unit	Test Standard
ISO Data			
Density	1220	kg/m³	ISO 1183

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	110	°C	-
Pre-drying - Time	2 - 4	h	-
Processing humidity	≤0.01	%	-
Melt temperature	250 - 270	°C	-
Mold temperature	60 - 100	°C	-
Zone 1	245 - 255	°C	-
Zone 2	250 - 260	°C	-
Zone 3	255 - 265	°C	-
Nozzle temperature	255 - 270	°C	-
Back pressure	5 - 15	MPa	-

Characteristics

Processing

Injection Molding

Additives

Release agent

Special Characteristics

Impact modified

Chemical Resistance

General Chemical Resistance

Certifications

Medical, Biocompatibility ISO 10993

Applications

Medical