



Makroblend® UT215 M

(PC+PET)-T5

Covestro Deutschland AG

- (PC PET) Blend, 5% mineral filled, easy flow, easy release, good impact strength, for automotive applications

Rheological properties	Value	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	49	cm³/10min	ISO 1133
Temperature	270	°C	-
Load	5	kg	-

Mechanical Properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	3050	MPa	ISO 527
Yield stress	65	MPa	ISO 527
Yield strain	5	%	ISO 527
Nominal strain at break	>50	%	ISO 527
Impact Strength (Charpy), +23°C	no break	kJ/m²	ISO 179/1eU
Impact Strength (Charpy), -30°C	200	kJ/m²	ISO 179/1eU
Notched Impact Strength (Charpy), +23°C	6	kJ/m²	ISO 179/1eA
Puncture - maximum force, +23°C	4700	N	ISO 6603-2
Puncture energy, +23°C	45	J	ISO 6603-2
Flexural Modulus (23°C)	3100	MPa	ISO 178
Flexural strength	105	MPa	ISO 178
Notched Impact Strength (Izod), 23°C	6	kJ/m²	ISO 180/1A
Impact Strength (Izod), 23°C	no break	kJ/m²	ISO 180/1U

Thermal Properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load (1.80 MPa)	112	°C	ISO 75-1/-2
Temp. of deflection under load (0.45 MPa)	130	°C	ISO 75-1/-2
Coeff. of Linear Therm. Expansion, parallel	60	E-6/K	ISO 11359-1/-2
Coeff. of Linear Therm. Expansion, normal	60	E-6/K	ISO 11359-1/-2

Other Properties	Value	Unit	Test Standard
ISO Data			
Water Absorption	0.45	%	Sim. to ISO 62
Humidity absorption	0.2	%	Sim. to ISO 62
Density	1270	kg/m³	ISO 1183

Test specimen production	Value	Unit	Test Standard
ISO Data			
Injection Molding, melt temperature	270	°C	ISO 294
Injection Molding, mold temperature	70	°C	ISO 294
Injection Molding, injection velocity	200	mm/s	ISO 294

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	270 - 280	°C	-
Mold temperature	70 - 80	°C	-
Zone 1	220 - 230	°C	-
Zone 2	240 - 250	°C	-
Zone 3	260 - 270	°C	-
Nozzle temperature	270 - 280	°C	-
Back pressure	5 - 10	MPa	-

Characteristics

Processing

Injection Molding

Special Characteristics

Impact modified

Additives

Release agent

Applications

Automotive