



Makroblend® UT250

(PC+PET)-I

Covestro Deutschland AG

- (PC PET)-blend, impact modified, easy release, injection molding. Makroblend UT250 offers high heat resistance, good chemical resistance and flowability. Additionally, molded parts from UT250 having exceptional dimensional stability.

Rheological properties	Value	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	22	cm ³ /10min	ISO 1133
Temperature	265	°C	-
Load	5	kg	-

Mechanical Properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	2250	MPa	ISO 527
Yield stress	55	MPa	ISO 527
Yield strain	5	%	ISO 527
Nominal strain at break	>50	%	ISO 527
Impact Strength (Charpy), +23°C	no break	kJ/m ²	ISO 179/1eU
Impact Strength (Charpy), -30°C	no break	kJ/m ²	ISO 179/1eU
Notched Impact Strength (Charpy), +23°C	70	kJ/m ²	ISO 179/1eA
Notched Impact Strength (Charpy), -30°C	30	kJ/m ²	ISO 179/1eA

Thermal Properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load (1.80 MPa)	110	°C	ISO 75-1/-2
Temp. of deflection under load (0.45 MPa)	125	°C	ISO 75-1/-2

Electrical Properties	Value	Unit	Test Standard
ISO Data			
Relative permittivity, 100Hz	3.2	-	IEC 62631-2-1
Relative permittivity, 1MHz	3	-	IEC 62631-2-1
Dissipation Factor, 100Hz	16	E-4	IEC 62631-2-1
Dissipation Factor, 1MHz	146	E-4	IEC 62631-2-1
Volume Resistivity	>1E13	Ohm*m	IEC 62631-3-1
Surface Resistivity	>1E15	Ohm	IEC 62631-3-2
Electric Strength	34	kV/mm	IEC 60243-1
Comparative tracking index	250	-	IEC 60112

Other Properties	Value	Unit	Test Standard
ISO Data			
Water Absorption	0.55	%	Sim. to ISO 62
Humidity absorption	0.2	%	Sim. to ISO 62
Density	1220	kg/m ³	ISO 1183

Test specimen production	Value	Unit	Test Standard
ISO Data			
Injection Molding, melt temperature	265	°C	ISO 294
Injection Molding, mold temperature	70	°C	ISO 294
Injection Molding, injection velocity	200	mm/s	ISO 294

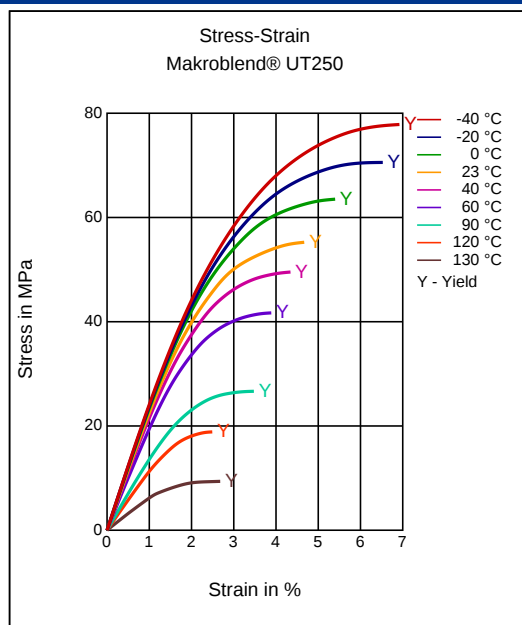
Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	110	°C	-
Pre-drying - Time	2 - 4	h	-
Processing humidity	≤0.01	%	-
Melt temperature	260 - 280	°C	-
Mold temperature	60 - 80	°C	-

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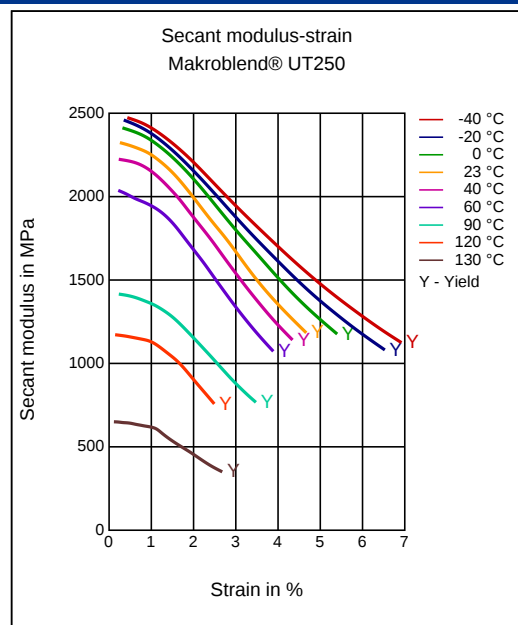
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Diagrams

Stress-strain



Secant modulus-strain



Characteristics

Processing

Injection Molding

Delivery form

Pellets

Special Characteristics

Impact modified, Light stabilized or stable to light

Chemical Resistance

General Chemical Resistance

Injection Molding

PREPROCESSING

Max. Water content: 0.01 %

Drying temperature: 110 °C

Drying time:

Circulating air drying oven (50 % fresh air) 4-12 h

Fresh air dryer (high speed dryer) 2-4 h

Dry air dryer 2-4 h

PROCESSING

Melt temperature: 260-280 °C

Mold temperature: 60-80 °C

Use open nozzle.