

Makrolon® 2407 DC

Covestro - Polycarbonates - *Polycarbonate*

General Information

Product Description

MVR (300 °C/1.2 kg) 19 cm³/10 min; light diffusion grade; low viscosity; UV stabilized; easy release; available in translucent colors only

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Additive	• UV Stabilizer		
Features	• Good Mold Release	• Low Viscosity	
RoHS Compliance	• RoHS Compliant		
Appearance	• Colors Available	• Translucent	
ISO Designation	• PC		

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density (73°F)	1.20	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (300°C/1.2 kg)	19	cm ³ /10min	ISO 1133
Molding Shrinkage			ISO 2577
Across Flow	0.70	%	
Flow	0.65	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (73°F)	348000	psi	ISO 527-1/1
Tensile Stress (Yield, 73°F)	9430	psi	ISO 527-2/50
Tensile Stress (Break, 73°F)	8700	psi	ISO 527-2/5
Tensile Strain (Yield, 73°F)	6.0	%	ISO 527-2/50
Tensile Strain (Break, 73°F)	110	%	ISO 527-2/5
Nominal Tensile Strain at Break (73°F)	> 50	%	ISO 527-2/5
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-22°F, Complete Break	5.7	ft·lb/in ²	
73°F, Complete Break	5.7	ft·lb/in ²	
Charpy Unnotched Impact Strength			ISO 179/1eU
-22°F	No Break		
73°F	No Break		
Multi-Axial Instrumented Impact Energy			ISO 6603-2
-22°F	40.6	ft·lb	
73°F	36.9	ft·lb	
Multi-Axial Instrumented Impact Peak Force			ISO 6603-2
-22°F	1350	lbf	
73°F	1120	lbf	
Hardness	Nominal Value	Unit	Test Method
Ball Indentation Hardness	17400	psi	ISO 2039-1
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	273	°F	ISO 75-2/B
Deflection Temperature Under Load (264 psi, Unannealed)	252	°F	ISO 75-2/A
Vicat Softening Temperature	284	°F	ISO 306/B120
Flammability	Nominal Value	Unit	Test Method



Flame Rating (0.030 in)	V-2	UL 94
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Processing Information

Injection	Nominal Value	Unit
Drying Temperature - Dry Air Dryer	248	°F
Drying Time - Dry Air Dryer	4.0	hr
Processing (Melt) Temp	536	°F
Mold Temperature	176	°F

Notes

¹ Typical properties: these are not to be construed as specifications.

