

Makroblend® UT203

Covestro - Polycarbonates - *Polycarbonate + PET*

General Information

Product Description

(PC+PET)-blend, impact modified, UV-stabilized, Injection molding grade

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East	• Europe	• North America
	• Asia Pacific	• Latin America	
Additive	• Impact Modifier	• UV Stabilizer	
Features	• Impact Modified		
RoHS Compliance	• RoHS Compliant		
Processing Method	• Injection Molding		

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density (73°F)	1.21	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (260°C/5.0 kg)	17	cm ³ /10min	ISO 1133
Molding Shrinkage ²			ISO 2577
Across Flow	0.60 to 0.80	%	
Flow	0.60 to 0.80	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (73°F)	341000	psi	ISO 527-1/1
Tensile Stress (Yield, 73°F)	8560	psi	ISO 527-2/50
Nominal Tensile Strain at Break (73°F)	50	%	ISO 527-2/50
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength (73°F)	36	ft-lb/in ²	ISO 180/A
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	255	°F	ISO 75-2/B
Deflection Temperature Under Load (264 psi, Unannealed)	216	°F	ISO 75-2/A
Vicat Softening Temperature	273	°F	ISO 306/B120
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.06 in)	HB		UL 94

Processing Information

Injection	Nominal Value	Unit
Drying Temperature - Dry Air Dryer	230	°F
Drying Time - Dry Air Dryer	2.0 to 4.0	hr
Suggested Max Moisture	< 0.010	%
Suggested Shot Size	30 to 70	%
Rear Temperature	473 to 491	°F
Middle Temperature	482 to 500	°F
Front Temperature	491 to 509	°F
Nozzle Temperature	491 to 518	°F
Processing (Melt) Temp	500 to 536	°F
Mold Temperature	122 to 212	°F
Back Pressure	725 to 2180	psi
Vent Depth	9.8E-4 to 3.0E-3	in

Injection Notes

Peripheral Screw Speed: 0.05 - 0.2 m/s
 Hold Pressure (% of Injection Pressure): 50 - 75%
 Standard Melt Temperature: 270°C

