Makrolon® 6487

Flame retardant grades / Medium viscosity	MVR (300 °C/1.2 kg) 9.0 cm³/10 min; flame retardant; UL 94V-0/1.5 mm and 5VA/3.0 mm; medium viscosity; UV stabilized; easy release; injection molding - melt temperature 280 - 320 °C; available in opaque colors only
ISO Shortname	ISO 7391-PC,MFLR,(,,)-09-9

	Property	Test Condition	Unit	Standard	typical Value
Rheological properties					-
C	Melt volume-flow rate	300 °C/ 1.2 kg	cm³/10 min	ISO 1133	9
	Melt mass-flow rate	300 °C/ 1.2 kg	g/10 min	ISO 1133	10
C	Molding shrinkage, normal	60x60x2 mm/ 500 bar	%	ISO 294-4	0.7
C	Molding shrinkage, normal	60x60x2 mm/ 500 bar	%	ISO 294-4	0.75
	Molding shrinkage, parallel/normal	Value range based on general practical experience	%	b.o. ISO 2577	0.6 - 0.8
Mechanical properties (23 °C/50 % r. h.)					
C	Tensile modulus	1 mm/min	MPa	ISO 527-1,-2	2450
C	Yield stress	50 mm/min	MPa	ISO 527-1,-2	66
C	Yield strain	50 mm/min	%	ISO 527-1,-2	6.0
C	Nominal strain at break	50 mm/min	%	ISO 527-1,-2	> 50
	Stress at break	50 mm/min	MPa	ISO 527-1,-2	65
	Strain at break	50 mm/min	%	b.o. ISO 527-1,-2	115
	Flexural modulus	2 mm/min	MPa	ISO 178	2450
	Flexural strength	2 mm/min	MPa	ISO 178	99
	Flexural strain at flexural strength	2 mm/min	%	ISO 178	7.0
	Flexural stress at 3.5 % strain	2 mm/min	MPa	ISO 178	75
C	Charpy impact strength	23 °C	kJ/m²	ISO 179/1eU	N
C	Charpy impact strength	-30 °C	kJ/m²	ISO 179/1eU	N
	Charpy notched impact strength	23 °C/ 3 mm	kJ/m²	ISO 7391/b.o. ISO 179/1eA	70P(C)
	Charpy notched impact strength	-30 °C/ 3 mm	kJ/m²	ISO 7391/b.o. ISO 179/1eA	12C
	Izod notched impact strength	23 °C/ 3 mm	kJ/m²	ISO 7391/b.o. ISO 180/A	70P(C)
	Izod notched impact strength	-30 °C/ 3 mm	kJ/m²	ISO 7391/b.o. ISO 180/A	12C
C	Puncture impact properties - maximum force	23 °C	N	ISO 6603-2	5200
C	Puncture impact properties - maximum force	-30 °C	N	ISO 6603-2	6000
C	Puncture energy	23 °C	J	ISO 6603-2	50
C	Puncture energy	-30 °C	J	ISO 6603-2	55
	Ball indentation hardness		N/mm²	ISO 2039-1	117

Makrolon® 6487

	Property	Test Condition	Unit	Standard	typical Value
Thermal properties					
C	Glass transition temperature	10 °C/min	°C	ISO 11357-1,-2	141
C	Temperature of deflection under load	1.80 MPa	°C	ISO 75-1,-2	122
C	Temperature of deflection under load	0.45 MPa	°C	ISO 75-1,-2	134
C	Vicat softening temperature	50 N; 50 °C/h	°C	ISO 306	141
	Vicat softening temperature	50 N; 120 °C/h	°C	ISO 306	141
C	Coefficient of linear thermal expansion, parallel	23 to 55 °C	10^{-4}/K	ISO 11359-1,-2	0.65
C	Coefficient of linear thermal expansion, normal	23 to 55 °C	10^{-4}/K	ISO 11359-1,-2	0.65
C	Burning behavior UL 94 (1.5 mm) [UL recognition]	1.5 mm	Class	UL 94	V-0
C	Burning behavior UL 94-5V [UL recognition]	3.0 mm	Class	UL 94	5VA
C	Oxygen index	Method A	%	ISO 4589-2	36
	Thermal conductivity, through-plane	23 °C; 50 % r. h.	W/(m·K)	ISO 8302	0.20
	Resistance to heat (ball pressure test)		°C	IEC 60695-10-2	135
	Relative temperature index (Tensile strength) [UL recognition]	1.5 mm	°C	UL 746B	125
	Relative temperature index (Tensile impact strength) [UL recognition]	1.5 mm	°C	UL 746B	115
	Relative temperature index (Electric strength) [UL recognition]	1.5 mm	°C	UL 746B	125
	Glow wire test (GWFI)	1.5 mm	°C	IEC 60695-2-12	960
	Glow wire test (GWFI)	3.0 mm	°C	IEC 60695-2-12	960
	Glow wire test (GWIT)	1.5 mm	°C	IEC 60695-2-13	900
	Glow wire test (GWIT)	3.0 mm	°C	IEC 60695-2-13	930
	Application of flame from small burner	Method K and F/ 2.0 mm	Class	DIN 53438-1,-3	K1, F1
	Burning rate (US-FMVSS)	>=1.0 mm	mm/min	ISO 3795	passed
	Flash ignition temperature		°C	ASTM D1929	470
	Self ignition temperature		°C	ASTM D1929	550
Electrical properties (23 °C/50 % r. h.)					
C	Relative permittivity	100 Hz	-	IEC 60250	3.1
C	Relative permittivity	1 MHz	-	IEC 60250	3.0
C	Dissipation factor	100 Hz	10^{-4}	IEC 60250	8
C	Dissipation factor	1 MHz	10^{-4}	IEC 60250	90
C	Volume resistivity		Ohm·m	IEC 60093	1E14
C	Surface resistivity		Ohm	IEC 60093	1E16
C	Electrical strength	1 mm	kV/mm	IEC 60243-1	34
C	Comparative tracking index CTI	Solution A	Rating	IEC 60112	225
	Comparative tracking index CTI M	Solution B	Rating	IEC 60112	125M
	Electrolytic corrosion		Rating	IEC 60426	A1
Other properties (23 °C)					
C	Water absorption (saturation value)	Water at 23 °C	%	ISO 62	0.30
C	Water absorption (equilibrium value)	23 °C; 50 % r. h.	%	ISO 62	0.12
C	Density		kg/m³	ISO 1183-1	1200
	Bulk density	Pellets	kg/m³	ISO 60	640
Processing conditions for test specimens					
C	Injection molding - Melt temperature		°C	ISO 294	300
C	Injection molding - Mold temperature		°C	ISO 294	80
C	Injection molding - Injection velocity		mm/s	ISO 294	200

Makrolon® 6487

	Property	Test Condition	Unit	Standard	typical Value
Recommended processing and drying conditions					
	Melt temperatures		°C	-	280 - 320
	Standard Melt temperature		°C	-	300
	Barrel Temperatures - Rear		°C	-	250 - 260
	Barrel Temperatures - Middle		°C	-	270 - 280
	Barrel Temperatures - Front		°C	-	280 - 290
	Barrel Temperatures - Nozzle		°C	-	290 - 300
	Mold Temperatures		°C	-	80 - 120
	Hold Pressure (% of injection pressure)		%	-	50 - 75
	Plastic Back Pressure (specific)		bar	-	50 - 150
	Peripheral Screw Speed		m/s	-	0.05 - 0.2
	Shot-to-Cylinder Size		%	-	30 - 70
	Dry Air Drying Temperature		°C	-	120
	Dry Air Drying Time		h	-	2-3
	Moisture Content max. (%)		%	-	<= 0,02
	Vent Depth		mm	-	0.025 - 0.075

C These property characteristics are taken from the CAMPUS plastics data bank and are based on the international catalogue of basic data for plastics according to ISO 10350.

Impact properties: N = non-break, P = partial break, C = complete break

Makrolon® 6487

Disclaimer

Typical value

These values are typical values only. Unless explicitly agreed in written form, the do not constitute a binding material specification or warranted values. Values may be affected by the design of the mold/die, the processing conditions and coloring/pigmentation of the product. Unless specified to the contrary, the property values given have been established on standardized test specimens at room temperature.

General

The manner in which you use and the purpose to which you put and utilize our products, technical assistance and information (whether verbal, written or by way of production evaluations), including any suggested formulations and recommendations are beyond our control. Therefore, it is imperative that you test our products, technical assistance, information and recommendations to determine to your own satisfaction whether our products, technical assistance and information are suitable for your intended uses and applications. This application-specific analysis must at least include testing to determine suitability from a technical as well as health, safety, and environmental standpoint. Such testing has not necessarily been done by Covestro. Unless we otherwise agree in writing, all products are sold strictly pursuant to the terms of our standard conditions of sale which are available upon request. All information and technical assistance is given without warranty or guarantee and is subject to change without notice. It is expressly understood and agreed that you assume and hereby expressly release us from all liability, in tort, contract or otherwise, incurred in connection with the use of our products, technical assistance, and information. Any statement or recommendation not contained herein is unauthorized and shall not bind us. Nothing herein shall be construed as a recommendation to use any product in conflict with any claim of any patent relative to any material or its use. No license is implied or in fact granted under the claims of any patent. With respect to health, safety and environment precautions, the relevant Material Safety Data Sheets (MSDS) and product labels must be observed prior to working with our products.

Recommended Processing and Drying Conditions

Barrel temperatures are valid for a standard 3-zone barrel. Temperature set-up for different barrel types may change according to configuration. Values for hold pressure as percentage of injection pressure may vary depending on, amongst others, part geometry, injection molding machine and injection mold. Drying conditions are for dry air dryers only. Drying times and drying temperatures may differ depending on valid dryer type. Further information is provided by your local Covestro support as well as in the following brochures: Injection Molding of High Quality Molded Parts - Drying; Determining the Dryness of Makrolon by TVI Test; The fundamentals of shrinkage in thermoplastics; Shrinkage and deformation of glass fiber reinforced thermoplastics [...]. https://www.plastics.covestro.com/Library/Overview.aspx

Covestro AG

Polycarbonates Business Unit

Kaiser-Wilhelm-Allee 60

51373 Leverkusen

Germany

plastics@covestro.com

www.plastics.covestro.com