

Makrolon® 2407

General purpose grades / Low viscosity

MVR (300 °C/1.2 kg) 19 cm³/10 min; general purpose; low viscosity; UV stabilized; easy release; injection molding - melt temperature 280 - 320 °C; available in transparent, translucent and opaque colors

ISO Shortname

ISO 7391-PC,MLR,(,)-18-9

| Property | Test Condition | Unit | Standard | typical Value |
|---|---|-------------------------|---------------------------|---------------|
| Rheological properties | | | | |
| C Melt volume-flow rate | 300 °C; 1.2 kg | cm ³ /10 min | ISO 1133 | 19 |
| C Molding shrinkage, parallel | 60x60x2 mm; 500 bar | % | ISO 294-4 | 0.65 |
| C Molding shrinkage, normal | 60x60x2 mm; 500 bar | % | ISO 294-4 | 0.7 |
| Molding shrinkage, parallel/normal | Value range based on general practical experience | % | b.o. ISO 2577 | 0.5 - 0.7 |
| Melt mass-flow rate | 300 °C; 1.2 kg | g/10 min | ISO 1133 | 20 |
| Mechanical properties (23 °C/50 % r. h.) | | | | |
| C Tensile modulus | 1 mm/min | MPa | ISO 527-1,-2 | 2400 |
| 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 | 120 |
| C Tensile creep modulus | 1 h | MPa | ISO 899-1 | 2200 |
| C Tensile creep modulus | 1000 h | MPa | ISO 899-1 | 1900 |
| Flexural modulus | 2 mm/min | MPa | ISO 178 | 2350 |
| Flexural strength | 2 mm/min | MPa | ISO 178 | 98 |
| Flexural strain at flexural strength | 2 mm/min | % | ISO 178 | 7.0 |
| Flexural stress at 3.5 % strain | 2 mm/min | MPa | ISO 178 | 74 |
| C Charpy impact strength | 23 °C | kJ/m ² | ISO 179-1eU | N |
| C Charpy impact strength | -30 °C | kJ/m ² | ISO 179-1eU | N |
| Charpy impact strength | -60 °C | kJ/m ² | ISO 179-1eU | N |
| Charpy notched impact strength | 23 °C; 3 mm | kJ/m ² | ISO 7391/b.o. ISO 179-1eA | 65P(C) |
| Charpy notched impact strength | -30 °C; 3 mm | kJ/m ² | ISO 7391/b.o. ISO 179-1eA | 14C |
| Izod notched impact strength | 23 °C; 3 mm | kJ/m ² | ISO 7391/b.o. ISO 180-A | 65P |
| Izod notched impact strength | -30 °C; 3 mm | kJ/m ² | ISO 7391/b.o. ISO 180-A | 12C |
| C Puncture maximum force | 23 °C | N | ISO 6603-2 | 5100 |
| C Puncture maximum force | -30 °C | N | ISO 6603-2 | 6000 |
| C Puncture energy | 23 °C | J | ISO 6603-2 | 55 |
| C Puncture energy | -30 °C | J | ISO 6603-2 | 65 |
| Ball indentation hardness | | N/mm ² | ISO 2039-1 | 116 |

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|---|------------------------|---------------------|----------------|---------------|
| Thermal properties | | | | |
| C Glass transition temperature | 10 °C/min | °C | ISO 11357-1,-2 | 143 |
| C Temperature of deflection under load | 1.80 MPa | °C | ISO 75-1,-2 | 124 |
| C Temperature of deflection under load | 0.45 MPa | °C | ISO 75-1,-2 | 136 |
| C Vicat softening temperature | 50 N; 50 °C/h | °C | ISO 306 | 143 |
| Vicat softening temperature | 50 N; 120 °C/h | °C | ISO 306 | 145 |
| 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, transverse | 23 to 55 °C | 10 ⁻⁴ /K | ISO 11359-1,-2 | 0.65 |
| C Burning behavior UL 94 [UL recognition] | 0.75 mm | Class | UL 94 | V-2 |
| Burning behavior UL 94 [UL recognition] | 2.7 mm | Class | UL 94 | HB |
| C Oxygen index | Method A | % | ISO 4589-2 | 27 |
| Thermal conductivity, cross-flow | 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) | 0.75 mm | °C | IEC 60695-2-12 | 850 |
| Glow wire test (GWFI) | 1.5 mm | °C | IEC 60695-2-12 | 875 |
| Glow wire test (GWFI) | 3.0 mm | °C | IEC 60695-2-12 | 930 |
| Glow wire test (GWIT) | 0.75 mm | °C | IEC 60695-2-13 | 875 |
| Glow wire test (GWIT) | 1.0 mm | °C | IEC 60695-2-13 | 875 |
| Glow wire test (GWIT) | 1.5 mm | °C | IEC 60695-2-13 | 875 |
| Glow wire test (GWIT) | 3.0 mm | °C | IEC 60695-2-13 | 875 |
| Application of flame from small burner | Method K and F; 2.0 mm | Class | DIN 53438-1,-3 | K1, F1 |
| Needle flame test | Method K; 1.5 mm | s | IEC 60695-11-5 | 5 |
| Needle flame test | Method K; 2.0 mm | s | IEC 60695-11-5 | 5 |
| Needle flame test | Method K; 3.0 mm | s | IEC 60695-11-5 | 10 |
| Needle flame test | Method F; 1.5 mm | s | IEC 60695-11-5 | 60 |
| Needle flame test | Method F; 2.0 mm | s | IEC 60695-11-5 | 120 |
| Needle flame test | Method F; 3.0 mm | s | IEC 60695-11-5 | 120 |
| Burning rate (US-FMVSS) | >=1.0 mm | mm/min | ISO 3795 | passed |
| Flash ignition temperature | | °C | ASTM D1929 | 480 |
| 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 | 5 |
| 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 | 250 |
| Comparative tracking index CTI M | Solution B | Rating | IEC 60112 | 125M |
| Electrolytic corrosion | | Rating | IEC 60426 | A1 |

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| Property | Test Condition | Unit | Standard | typical Value |
|--|--------------------------------------|---|---------------|---------------|
| 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/m ³ | ISO 1183-1 | 1200 |
| Water vapor permeability | 23 °C; 85 % RH; 100 µm film | g/(m ² ·24 h) | ISO 15106-1 | 15 |
| Gas permeation | Oxygen; 100 µm film | cm ³ /(m ² ·24 h·bar) | b.o. ISO 2556 | 800 |
| Gas permeation | Oxygen; 25.4 µm (1 mil) film | cm ³ /(m ² ·24 h·bar) | b.o. ISO 2556 | 3150 |
| Gas permeation | Nitrogen; 100 µm film | cm ³ /(m ² ·24 h·bar) | b.o. ISO 2556 | 160 |
| Gas permeation | Nitrogen; 25.4 µm (1 mil) film | cm ³ /(m ² ·24 h·bar) | b.o. ISO 2556 | 630 |
| Gas permeation | Carbon dioxide; 100 µm film | cm ³ /(m ² ·24 h·bar) | b.o. ISO 2556 | 4800 |
| Gas permeation | Carbon dioxide; 25.4 µm (1 mil) film | cm ³ /(m ² ·24 h·bar) | b.o. ISO 2556 | 18900 |
| Bulk density | Pellets | kg/m ³ | ISO 60 | 660 |
| Material specific properties | | | | |
| Refractive index | Procedure A | - | ISO 489 | 1.584 |
| Haze for transparent materials | 3 mm | % | ISO 14782 | < 0.8 |
| Luminous transmittance (clear transparent materials) | 1 mm | % | ISO 13468-2 | 89 |
| C Luminous transmittance (clear transparent materials) | 2 mm | % | ISO 13468-2 | 89 |
| Luminous transmittance (clear transparent materials) | 3 mm | % | ISO 13468-2 | 88 |
| Luminous transmittance (clear transparent materials) | 4 mm | % | ISO 13468-2 | 87 |
| Processing conditions for test specimens | | | | |
| C Injection molding-Melt temperature | | °C | ISO 294 | 280 |
| C Injection molding-Mold temperature | | °C | ISO 294 | 80 |
| C Injection molding-Injection velocity | | mm/s | ISO 294 | 200 |

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



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Disclaimer

Typical value

These values are typical values only. Unless explicitly agreed in written form, they 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.

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Disclaimer Non Medical Grade

This product is not designated for the manufacture of a medical device or of intermediate products for medical devices (1). [This product is also not designated for Food Contact (2), including drinking water, or cosmetic applications. If the intended use of the product is for the manufacture of a medical device or of intermediate products for medical devices, for Food Contact products or cosmetic applications Covestro must be contacted in advance to provide its agreement to sell such product for such purpose.] Nonetheless, any determination as to whether a product is appropriate for use in a medical device or intermediate products for medical devices, for Food Contact products or cosmetic applications must be made solely by the purchaser of the product without relying upon any representations by Covestro. 1) Please see the "Guidance on Use of Covestro Products in a Medical Application" document. 2) As defined in Commission Regulation (EU) 1935/2004.

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