

Makrolon 2405

General purpose grades / Low viscosity

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

ISO Shortname

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

Property	Test Condition	Unit	Standard	Value
Rheological properties				
Melt mass-flow rate	300 °C; 1.2 kg	g/10 min	ASTM D1238	20
Mold shrinkage, flow/cross to flow		in/in	ASTM D955	0.005 - 0.007
Mechanical properties (23 °C/50 % r. h.)				
Tensile modulus	1 mm/min	lb/in ²	ASTM D638	350000
Tensile stress at yield	-	lb/in ²	ASTM D638	9400
Tensile elongation at yield	-	%	ASTM D638	6.0
Tensile elongation at break	-	%	ASTM D638	115
Tensile stress at break	-	lb/in ²	ASTM D638	8700
Izod notched impact strength	73 °F, 0.125 in	ft-lb/in	ASTM D256	14
Flexural modulus	-	lb/in ²	ASTM D790	340000
Flexural stress at 5 % strain		lb/in ²	ASTM D790	12000
Rockwell hardness		M Scale	ASTM D785	75
Rockwell hardness		R Scale	ASTM D785	120
Thermal properties				
Deflection temperature under load, Unannealed	264 psi; 0.250 in	°F	ASTM D648	259
Deflection temperature under load, Unannealed	66 psi; 0.250 in	°F	ASTM D648	273
Vicat softening temperature	50 N, 50 °C/h	°F	ASTM D1525	291
Coefficient of linear thermal expansion, flow/cross-flow		in/in/°F	ASTM D696	3.34 E-05
UL94 Flame Class	Thickness tested: 1.5 mm	Class	UL 94	V-2
UL94 Flame Class	Thickness tested: 3.0 mm	Class	UL 94	HB
UL94 Flame Class	Thickness tested: 6.0 mm	Class	UL 94	HB
Oxygen index		%	ASTM D2863	28
Thermal conductivity		Btu-in/(h·ft ² ·°F)	ASTM C177	1.39
Specific heat		Btu/(lb·°F)	ASTM D2766	0.28
Relative temperature index (Tensile impact strength)	Thickness tested: 1.5 mm	°C	UL 746B	115
Relative temperature index (Tensile strength)	Thickness tested: 1.5 mm	°C	UL 746B	125
Relative temperature index (Electric strength)	Thickness tested: 1.5 mm	°C	UL 746B	125
Electrical properties (23 °C/50 % r. h.)				
Dissipation factor, Tinfoil electrodes	60 Hz	-	ASTM D150	0.0008
Dissipation factor, Tinfoil electrodes	1 MHz	-	ASTM D150	0.01
Dielectric constant, Tinfoil electrodes	60 Hz	-	ASTM D150	3.0
Dielectric constant, Tinfoil electrodes	1 MHz	-	ASTM D150	2.9
Volume resistivity, Tinfoil electrodes		Ohm-m	ASTM D257	1.0 E+14
Surface resistivity		Ohm	ASTM D257	1.0 E+16
Electrical strength	Short time under oil at 73 °F	V/mil	ASTM D149	810
Other properties (23 °C)				
Water absorption	73 °F; Immersion to saturation	%	ASTM D570	0.30
Water absorption	73 °F; Immersion 24 h	%	ASTM D570	0.12
Density		lb/in ³	ASTM D792	0.043
Specific volume		in ³ /lb	ASTM D792	23.1
Specific gravity		-	ASTM D792	1.2
Material specific properties				
Refractive index		-	ASTM D542	1.586
Luminous transmittance (clear transparent materials)	0.125 in	%	ASTM D1003	88
Haze for transparent materials	0.125 in	%	ASTM D1003	< 0.8



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Disclaimer

General

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