



Makrolon 2656

Food contact grades / Medium viscosityGlobal grade; MVR 12.5 cm³/10 min; Food contact quality; Medium viscosity; Easy release; Good hydrolysis resistance; 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				
C Melt volume-flow rate	300 °C; 1.2 kg	cm ³ /10 min	ISO 1133	12.5
C Molding shrinkage, parallel	60x60x2; 500 bar	%	ISO 294-4	0.65
C Molding shrinkage, normal	60x60x2; 500 bar	%	ISO 294-4	0.7
Molding shrinkage, parallel/normal	Value range based on general practical experience	%	b.o. ISO 2577	0.6 - 0.8
Melt mass-flow rate	300 °C; 1.2 kg	g/10 min	ISO 1133	13
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	6.1
C Nominal strain at break	50 mm/min	%	ISO 527-1,-2	> 50
Stress at break	50 mm/min	MPa	ISO 527-1,-2	70
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	2400
Flexural strength	2 mm/min	MPa	ISO 178	97
Flexural strain at flexural strength	2 mm/min	%	ISO 178	7.1
Flexural stress at 3.5 % strain	2 mm/min	MPa	ISO 178	73
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	b.o. ISO 179/1eA	70P
Charpy notched impact strength	-30 °C; 3 mm	kJ/m ²	b.o. ISO 179/1eA	16C
C Puncture maximum force	23 °C	N	ISO 6603-2	5400
C Puncture maximum force	-30 °C	N	ISO 6603-2	6300
C Puncture energy	23 °C	J	ISO 6603-2	60
C Puncture energy	-30 °C	J	ISO 6603-2	65
Izod notched impact strength	23 °C; 3.2 mm	kJ/m ²	b.o. ISO 180/A	80P(C)
Izod notched impact strength	-30 °C; 3.2 mm	kJ/m ²	b.o. ISO 180/A	14C
Ball indentation hardness		N/mm ²	ISO 2039-1	115



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Property	Test Condition	Unit	Standard	Value
Thermal properties				
C Glass transition temperature	10 °C/min	°C	ISO 11357-1,-2	145
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	144
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 (1.5 mm) [UL recognition]	1.5 mm	Class	UL 94	V-2
C Burning behavior UL 94 [UL recognition]	2.4 mm	Class	UL 94	V-2
Burning behavior UL 94 [UL recognition]	0.75 mm	Class	UL 94	V-2
Burning behavior UL 94 [UL recognition]	2.5 mm	Class	UL 94	HB
Burning behavior UL 94 [UL recognition]	3.0 mm	Class	UL 94	HB
Burning behavior UL 94 [UL recognition]	6.0 mm	Class	UL 94	HB
C Oxygen index	Method A	%	ISO 4589-2	27
Thermal conductivity	23 °C	W/(m·K)	ISO 8302	0.20
Resistance to heat (ball pressure test)		°C	IEC 60695-10-2	136
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)	1.0 mm	°C	IEC 60695-2-12	850
Glow wire test (GWFI)	1.5 mm	°C	IEC 60695-2-12	850
Glow wire test (GWFI)	2.0 mm	°C	IEC 60695-2-12	850
Glow wire test (GWFI)	3.0 mm	°C	IEC 60695-2-12	930
Glow wire test (GWFI)	4.0 mm	°C	IEC 60695-2-12	960
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)	2.0 mm	°C	IEC 60695-2-13	875
Glow wire test (GWIT)	3.0 mm	°C	IEC 60695-2-13	875
Glow wire test (GWIT)	4.0 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 60695-2-2	5
Needle flame test	Method K; 2.0 mm	s	IEC 60695-2-2	5
Needle flame test	Method K; 3.0 mm	s	IEC 60695-2-2	10
Needle flame test	Method F; 1.5 mm	s	IEC 60695-2-2	60
Needle flame test	Method F; 2.0 mm	s	IEC 60695-2-2	60
Needle flame test	Method F; 3.0 mm	s	IEC 60695-2-2	120
Incandescent bar test		Rating	IEC 60707-BH	BH2/< 30 mm
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

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Property	Test Condition	Unit	Standard	Value
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
C Comparative tracking index CTI M	Solution B	Rating	IEC 60112	125
C 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/m ³	ISO 1183	1200
C Water vapor permeability	23 °C; 85 % RH; 100 µm film	g/(m ² ·24 h)	ISO 15106-1	15
C Gas permeation	Oxygen; 100 µm film	cm ³ /(m ² ·24 h·bar)	b.o. ISO 2556	700
C Gas permeation	Oxygen; 25.4 µm (1 mil) film	cm ³ /(m ² ·24 h·bar)	b.o. ISO 2556	2760
C Gas permeation	Nitrogen; 100 µm film	cm ³ /(m ² ·24 h·bar)	b.o. ISO 2556	130
C Gas permeation	Nitrogen; 25.4 µm (1 mil) film	cm ³ /(m ² ·24 h·bar)	b.o. ISO 2556	510
C Gas permeation	Carbon dioxide; 100 µm film	cm ³ /(m ² ·24 h·bar)	b.o. ISO 2556	4300
C Gas permeation	Carbon dioxide; 25.4 µm (1 mil) film	cm ³ /(m ² ·24 h·bar)	b.o. ISO 2556	16900
C Bulk density	Pellets	kg/m ³	ISO 60	660
Material specific properties				
C Refractive index	Procedure A	-	ISO 489	1.586
C Haze for transparent materials	3 mm	%	ISO 14782	< 0.8
C Luminous transmittance (clear transparent materials)	1 mm	%	ISO 13468-2	89
C Luminous transmittance (clear transparent materials)	2 mm	%	ISO 13468-2	89
C Luminous transmittance (clear transparent materials)	3 mm	%	ISO 13468-2	88
C Luminous transmittance (clear transparent materials)	4 mm	%	ISO 13468-2	87
Processing conditions for test specimens				
C Injection molding-Melt temperature		°C	ISO 294	290
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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Test values

Unless specified to the contrary, the values given have been established on standardized test specimens at room temperature. The figures should be regarded as guide values only and not as binding minimum values. Please note that, under certain conditions, the properties can be affected to a considerable extent by the design of the mold/die, the processing conditions and coloring.

Processing note

Under the recommended processing conditions small quantities of decomposition product may be given off during processing. To preclude any risk to the health and well-being of the machine operatives, tolerance limits for the work environment must be ensured by the provision of efficient exhaust ventilation and fresh air at the workplace in accordance with the Safety Data Sheet. In order to prevent the partial decomposition of the polymer and the generation of volatile decomposition products, the prescribed processing temperatures should not be substantially exceeded.

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