

- MAKROLON 2405 450601 -

PROPERTIES	UNIT	TEST METHOD	VALUES
Physical			
unreinforced			
Density	Kg/m ³	ISO 1183	1200
Mould shrinkage	%		0.6 – 0.8
Water absorption at saturation at 23°C	%		0.15
Mechanical			
Tensile modulus - 1 mm/min	MPa	ISO 527	2400
Yield stress - 50 mm/min	MPa	ISO 527	63
Yield strain - 50 mm/min	%	ISO 527	6.0
Nominal strain at break - 50 mm/min	%	ISO 527	>50
Tensile modulus - 1h	MPa	ISO 899-1	2200
Tensile modulus - 1000h	MPa	ISO 899-1	1900
Impact CHARPY notched at +23°C	kJ/m ²	ISO 180-4A	75
Impact CHARPY notched at -30°C	kJ/m ²	ISO 180-4A	15
Thermal			
HDT / Af at 1,80 MPa	°C	ISO 75	126
HDT / Bf at 0,45 MPa	°C	ISO 75	138
Vicat B/50 50N (method B) at 50°C/h	°C	ISO 306	145
Coefficient of thermal expansion - 23°C at 55°C	10 ⁻⁴ /K	ASTM E 831	0.7
UL 94 rating flame class rating / at mm thickness	Class / mm	UL 94,(IEC 707)	V2 / 1.6
Limited Oxygen Index- LOI	%	ISO 4589	28
Glow wire passed at °C	°C	IEC 695-2-1	850
Electrical			
Relative permittivity - 100 Hz		IEC 60250	3.0
Relative permittivity - 1 MHz		IEC 60250	3.0
Dissipation factor at 100 Hz	10 ⁻⁴	IEC 60250	5
Dissipation factor at 1 MHz	10 ⁻⁴	IEC 60250	90
Volume resistivity	Ohm.cm	IEC 60093	10 ¹⁶
Surface resistivity	Ohm	IEC 60093	10 ¹⁶
Dielectric strength	kV/mm	IEC 243-1	30
Comparative Tracking Index - CTI -	V	IEC 112	275

The values indicated are it with titles codes and do not engage to in no case the responsibility for company PHT



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