

Covestro Makrolon® 2407

Polycarbonate, Injection Grade

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

Physical Properties	Metric	English	Comments
Bulk Density	0.660 g/cc	0.0238 lb/in ³	ISO 60
Density	1.20 g/cc	0.0434 lb/in ³	ISO 1183-1
Water Absorption at Saturation	0.30 %	0.30 %	ISO 62
	0.35 %	0.35 %	
Water Vapor Transmission	15.0 g/m ² /day	0.966 g/100 in ² /day	85 % RH; 100 µm film; ISO 15106-1
Oxygen Transmission	800 cc-mm/m ² -24hr-atm	2030 cc-mil/100 in ² -24hr-atm	[cm ³ /(m ² ·24 h·bar)], 100 µm film; b.o. ISO 2556
	3150 cc-mm/m ² -24hr-atm	8000 cc-mil/100 in ² -24hr-atm	[cm ³ /(m ² ·24 h·bar)], 25.4 µm (1 mil) film; b.o. ISO 2556
Nitrogen Transmission	160 cc-mm/m ² -24hr-atm	406 cc-mil/100 in ² -24hr-atm	[cm ³ /(m ² ·24 h·bar)], 100 µm film; b.o. ISO 2556
	630 cc-mm/m ² -24hr-atm	1600 cc-mil/100 in ² -24hr-atm	[cm ³ /(m ² ·24 h·bar)], 25.4 µm (1 mil) film; b.o. ISO 2556
Carbon Dioxide Transmission	4800 cc-mm/m ² -24hr-atm	12200 cc-mil/100 in ² -24hr-atm	[cm ³ /(m ² ·24 h·bar)], 100 µm film; b.o. ISO 2556
	18900 cc-mm/m ² -24hr-atm	48000 cc-mil/100 in ² -24hr-atm	[cm ³ /(m ² ·24 h·bar)], 25.4 µm (1 mil) film; b.o. ISO 2556
Linear Mold Shrinkage	0.0050 - 0.0070 cm/cm	0.0050 - 0.0070 in/in	parallel/normal; b.o. ISO 2577
Linear Mold Shrinkage, Flow	0.0065 cm/cm	0.0065 in/in	60x60x2 mm; 500 bar; ISO 294-4
Linear Mold Shrinkage, Transverse	0.0070 cm/cm	0.0070 in/in	60x60x2 mm; 500 bar; ISO 294-4
Melt Flow	20 g/10 min @Load 1.20 kg, Temperature 300 °C	20 g/10 min @Load 2.65 lb, Temperature 572 °F	ISO 1133